AuroraTec™ 3F0IMU

Aurora Material Solutions, LLC - *Polycarbonate + PBT*

General Information

Product Description			
Impact modified Flame Retardant PC/PBT Alloy - 5 year UV packge Formerly known as EnCounter 3F0IMU			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant	• Impact Modifier	
Features	• Flame Retardant	• Impact Modified	
Uses	• Electrical/Electronic Applications • Industrial Applications	• Lighting Applications • Medical/Healthcare Applications	
UL File NumberUSA	• E175765		
Appearance	• Colors Available	• Natural Color	
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.30		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	8.0E-3 to 0.011	in/in	Internal Method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	6500	psi	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	275000	psi	ASTM D790
Flexural Strength	9500	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	13	ft·lb/in	ASTM D256
Gardner Impact	320	in·lb	ASTM D5420
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	216	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	155	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	• V-0 • 5VA		

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	240	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 75	%
Rear Temperature	460 to 480	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	480 to 500	°F

Processing (Melt) Temp	480 to 500	°F
Mold Temperature	95 to 170	°F
Back Pressure	40.0 to 90.0	psi
Screw Speed	25 to 75	rpm

Notes

[1] Typical properties: these are not to be construed as specifications.