AuroraGuard™ ENV17-19284

Aurora Material Solutions, LLC - *Polyetherimide*

General Information

Product Description

AuroraGuard™ ENV17-19284 in an Unreinforced, Transparent/Medium Amber Tint, Polyetherimide (PEI) Injection Molding Grade.

Formerly Branded as ENVIROPLAS®

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific • Europe	• Latin America • North America	
Features	• Flame Retardant • Good Thermal Stability	• High Stiffness • High Strength	
Uses	• Aircraft Applications	• Automotive Applications	• Batteries
RoHS Compliance	• RoHS Compliant		
Appearance	• Amber		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	15800	psi	ASTM D638
Tensile Elongation (Break)	55	%	ASTM D638
Flexural Modulus	510000	psi	ASTM D790
Flexural Strength	23600	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	0.60	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	390	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			Internal Method
0.06 in	V-0		
0.13 in	5VA		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	300	°F
Drying Time	4.0 to 6.0	hr
Rear Temperature	630 to 750	°F
Middle Temperature	640 to 750	°F
Front Temperature	650 to 750	°F
Nozzle Temperature	650 to 750	°F
Mold Temperature	275 to 325	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

塑料专家 www.ponci.com.cn/wxb/ +13538586433 +18816996168