

**AuroraGuard™ PP5MF2504**

Aurora Material Solutions, LLC - Polypropylene

**General Information**
**Product Description**

5% Mineral Filled, Impact Modified Polypropylene

Formerly known as Evolve PP5MF2504

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Mineral, 5.0% Filler by Weight		
Additive	• Impact Modifier		
Features	• Impact Modified		
Uses	• Automotive Applications	• Lawn & Garden Equipment	• Material Handling
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding	• Profile Extrusion	

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.960		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	0.011 to 0.015	in/in	ASTM D955
Ash Content	5.0	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	3500	psi	ASTM D638
Flexural Modulus	180000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	4.0	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	170	°F	ASTM D648

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	25 to 75	%
Rear Temperature	375 to 450	°F
Middle Temperature	375 to 450	°F
Front Temperature	375 to 450	°F
Nozzle Temperature	375 to 450	°F
Processing (Melt) Temp	375 to 450	°F
Mold Temperature	90 to 160	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 100	psi
Vent Depth	1.0E-3 to 1.5E-3	in

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
