

AuroraGuard™ 603-CL1002

Aurora Material Solutions, LLC - *Acrylonitrile Butadiene Styrene*

General Information

Product Description

Molding Grade Transparent ABS with Exceptional Impact

Formerly known as EnCore 603-CL1002

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Impact Resistance		
Uses	• Automotive Applications	• Business Equipment	• Thin-walled Parts
Appearance	• Clear/Transparent		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.09		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	7540	psi	ASTM D638
Tensile Elongation (Break)	14	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	174	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	HB		
0.13 in	HB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180 to 200	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	370 to 450	°F
Middle Temperature	400 to 475	°F
Front Temperature	425 to 500	°F
Nozzle Temperature	425 to 525	°F
Processing (Melt) Temp	425 to 525	°F
Mold Temperature	120 to 170	°F
Back Pressure	25.0 to 100	psi
Screw Speed	25 to 75	rpm

