

AuroraGuard™ ENV24-10268

Aurora Material Solutions, LLC - Copolyester

General Information

Product Description

AuroraGuard™ ENV24-10258 is an Unfilled, Copolyester Injection Molding Grade.

Formerly Branded as ENVIROCLEAR®.

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Latin America • Europe • North America
Features	• Chemical Resistant • Good Heat Resistance • High Impact Resistance • Excellent Processability • High Flow • Hydrolytically Stable
Uses	• Non-specific Food Applications
Agency Ratings	• FDA 21 CFR 174.5(d)
RoHS Compliance	• RoHS Compliant
Appearance	• Clear/Transparent
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) ² (260°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.00700 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6300	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	220000	psi	ASTM D790
Flexural Strength	8600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	16	ft-lb/in	ASTM D256
Unnotched Izod Impact (73°F)	No Break		ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness	112		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	210	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	185	°F	ASTM D648
Optical	Nominal Value	Unit	Test Method
Light Transmittance	91.0	%	ASTM D1003
Haze	< 1.00	%	ASTM D1003

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	190	°F
Drying Time	4.0 to 6.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	500 to 540	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	500 to 540	°F
Mold Temperature	100 to 150	°F
Injection Rate	Moderate	



Back Pressure	50.0 to 300 psi
Notes	
¹ Typical properties: these are not to be construed as specifications.	
² Procedure A	

