

AuroraTec™ 200 ABS

Aurora Material Solutions, LLC - Acrylonitrile Butadiene Styrene

General Information

Product Description

High Heat ABS

Formerly known as EnCore HH5004

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• General Purpose	• High Heat Resistance	
Uses	• Automotive Applications	• Business Equipment	• General Purpose
Appearance	• Black • Colors Available	• Natural Color • Opaque	
Processing Method	• Injection Molding	• Profile Extrusion	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.06		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6500	psi	ASTM D638
Flexural Modulus	350000	psi	ASTM D790
Flexural Strength	11500	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)	220	°F	ASTM D648
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.125 in	195	°F	
264 psi, Unannealed, 0.252 in	212	°F	
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

Injection Notes

