

AuroraTec™ 22116

Aurora Material Solutions, LLC - Copolyester

General Information

Product Description

BPA Free Polyester Copolymer

Formerly known as EnCounter 22116

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• BPA Free • Chemical Resistant	• Copolymer • High Clarity	• UV Resistant
Agency Ratings	• FDA Food Contact		
Appearance	• Clear/Transparent		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6500	psi	ASTM D638
Tensile Elongation (Break)	300	%	ASTM D638
Flexural Modulus	260000	psi	ASTM D790
Flexural Strength	9700	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	15	ft·lb/in	ASTM D256
Unnotched Izod Impact	29	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	158	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	144	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	190	°F
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.20	%
Suggested Shot Size	25 to 75	%
Rear Temperature	470 to 500	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	500 to 540	°F
Mold Temperature	90 to 150	°F
Back Pressure	25.0 to 75.0	psi
Screw Speed	25 to 75	rpm
Vent Depth	1.0E-3	in

