

AuroraTec™ ENV24-NC850

Aurora Material Solutions, LLC - Copolyester

General Information

Product Description

Injection Molding Grade, High Clarity in Natural or Light Tints, BPA Free, Excellent Impact Toughness, Good Mold Release, Hydrolytically Stable, Good Chemical and Heat Resistance, FDA Food Contact/REACH/RoHS 2 Compliant

NC060 = To Be Assigned 5 Digit Number Indicating Natural, FDA Black or Custom Color.

The ENV17 Series Products Are Available With Mold Release.

Formerly known as ENVIROCLEAR® ENV24-NC850

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• BPA Free • Chemical Resistant • Good Impact Resistance	• Good Mold Release • Good Strength • Good Toughness	• High Clarity • Hydrolytically Stable • Medium Heat Resistance
Uses	• Displays	• Household Goods	• Packaging
Agency Ratings	• EC 1907/2006 (REACH)	• FDA	
RoHS Compliance	• RoHS Compliant		
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	6190	psi	ASTM D638
Tensile Elongation (Break)	> 200	%	ASTM D638
Flexural Modulus	225000	psi	ASTM D790
Flexural Strength	8500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	18	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	185	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	185	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	500 to 540	°F
Mold Temperature	110 to 150	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 80	rpm

