

EnLon 610HSL

Polyamide 6



Product Description					
Heat Stabilized, Impact Modified Nylon 6					
General Properties					
Appearance	Black and Natural				
Processing Methods	Injection Molding				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	8,000	psi	55	MPa
Tensile Elongation at Break	ASTM D638	75	%	75	%
Flexural Modulus	ASTM D790	270,000	psi	1,862	MPa
Flexural Strength	ASTM D790	11,000	psi	76	MPa
Notched Izod Impact (73°F)	ASTM D256	10.0	ft-lb/in	534	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.08	sp gr	1.08	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.014	in/in	0.014	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	140	°F	60	°C
Injection Molding		Value			
Drying Temperature		180	°F		
Drying Time		2.0 - 4.0	hrs		
Maximum Drying Time		4	hrs		
Suggested Maximum Moisture		0.02	%		
Rear Barrel Temperatures		470 - 520	°F		
Middle Barrel Temperatures		480 - 530	°F		
Front Barrel Temperatures		490 - 540	°F		
Nozzle Temperature		490 - 540	°F		
Melt (processing) Temperatures		490 - 540	°F		
Mold Temperatures		130 - 200	°F		

These Data Sheet Values are Typical Values and are not intended for specification purposes. These values should only be used as a guide and no assurances by EnCom, Inc. can be granted that all molded articles will exhibit duplicate properties as those listed above. Each material user should perform their own testing for suitability.