

EnLon 615GFHS

Polyamide 6



Product Description					
15% Glass Filled Nylon 6, Heat Stabilized					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Injection Molding				
Applications	Automotive, Material Handling				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	17,000	psi	117	MPa
Tensile Elongation at Break	ASTM D638	6	%	6	%
Flexural Modulus	ASTM D790	750,000	psi	5,172	MPa
Flexural Strength	ASTM D790	27,000	psi	186	MPa
Notched Izod Impact (73°F)	ASTM D256	1.1	ft-lb/in	59	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.23	sp gr	1.23	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.005	in/in	0.127	mm/mm
Rockwell Hardness (R-Scale)	ASTM D785	121		121	
Filler Content		15.0	%	15.0	%
Flame Rating HB	UL 94	HB		HB	
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	405	°F	207	°C
Injection Molding		Value			
Drying Temperature		165	°F		
Drying Time		4.0 - 8.0	hrs		
Maximum Drying Time		4	hrs		
Suggested Maximum Moisture		0.02	%		
Suggested Shot Size		25 - 75	%		
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 - 530	°F		
Mold Temperatures		160 - 200	°F		
Back Pressure		20 - 60	psi		
Screw speed		50 - 120	rpm		

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.

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