

# EnLon 630GFIM

Polyamide 6



Product Description					
30% Glass Fiber Reinforced, Heat Stabilized Nylon 6					
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	26,100	psi	180	MPa
Tensile Modulus	ASTM D638	1,310,000	psi	9034	MPa
Tensile Elongation at Break	ASTM D638	4	%	4	%
Flexural Modulus	ASTM D790	1,230,000	psi	8,483	MPa
Flexural Strength	ASTM D790	36,300	psi	250	MPa
Notched Izod Impact (73°F)	ASTM D256	2.2	ft-lb/in	117	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.36	sp gr	1.36	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.003 - 0.007	in/in	0.003 - 0.007	mm/mm
Filler Content		30	%	30	%
Flame Rating 0.118	UL 94	HB		HB	
Water Absorption 73F (23C), Equil (50%) RH, 73°F	ASTM D570	2.10	%	2.10	%
Water Absorption 73F (23C), sat	ASTM D570	6.60	%	6.60	%
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 66 psi	ASTM D648	423	°F	217	°C
Heat Deflection Temperature @ 264 psi	ASTM D648	401	°F	205	°C
Vicat Softening Temperature	ASTM D1525	401	°F	205	°F
Melting Temperature	ASTM D3418	430	°F	221	°F
Injection Molding		Value			
Drying Temperature		185	°F		
Drying Time		3.0	hrs		
Maximum Drying Time		4.0	hrs		
Suggested Maximum Moisture		0.02	%		
Rear Barrel Temperatures		428 - 500	°F		
Middle Barrel Temperatures		446 - 509	°F		
Front Barrel Temperatures		482 - 518	°F		
Mold Temperatures		131 - 203	°F		
Back Pressure		50.8 - 102	psi		
Screw speed		60 - 90	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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