

EnLon 630GFV

Polyamide 6



Product Description			
30% Glass Filled Nylon 6, Recycled Content			
General Properties			
Appearance	Black only		
Processing Methods	Injection Molding		
Applications	Automotive, Material Handling		
Mechanical Properties	Test Method	English Units	S.I. Units
Tensile Strength @ Yield	ASTM D638	23,000 psi	159 MPa
Tensile Elongation at Break	ASTM D638	5 %	5 %
Flexural Modulus	ASTM D790	1,100,000 psi	7,586 MPa
Flexural Strength	ASTM D790	30,500 psi	210 MPa
Notched Izod Impact (73°F)	ASTM D256	1.8 ft-lb/in	96 J/m
Physical Properties	Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.38 sp gr	1.38 sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.003 in/in	0.003 mm/mm
Filler Content		30 %	30 %
Water Absorption	ASTM D570	0.70 %	0.70 %
Thermal Properties	Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 264 psi	ASTM D648	400 °F	204 °C
Injection Molding		Value	
Drying Temperature		185	°F
Drying Time		2.0 - 4.0	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.

EnCom Polymers, Inc.

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