

EnLon 633GF-R

Polyamide 6



Product Description					
33% Glass Filled, Heat Stabilized, Lubricated Nylon 6 Recycled Content					
General Properties					
Appearance	Black				
Processing Methods	Injection Molding				
Applications	Automotive, Material Handling				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	17,500	psi	121	MPa
Tensile Elongation at Break	ASTM D638	2	%	2	%
Flexural Modulus	ASTM D790	1,000,000	psi	6,897	MPa
Flexural Strength	ASTM D790	28,500	psi	197	MPa
Notched Izod Impact (73°F)	ASTM D256	1.5	ft-lb/in	80	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		35	%	35	%
Water Absorption	ASTM D570	0.70	%	0.70	%
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		2.0 - 4.0	hrs		
Maximum Drying Time		4.0	hrs		
Suggested Maximum Moisture		0.02	%		
Rear Barrel Temperatures		550 - 570	°F		
Middle Barrel Temperatures		530 - 550	°F		
Front Barrel Temperatures		510 - 530	°F		
Nozzle Temperature		540 - 560	°F		
Melt (processing) Temperatures		550 - 580	°F		
Mold Temperatures		150 - 210	°F		
Back Pressure		20 - 60	psi		
Screw speed		40 - 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.