

EnLon 633GF

Polyamide 6



Product Description				
33% Glass Filled Nylon 6				
General Properties				
Appearance	Black, Natural, Colors			
Processing Methods	Injection Molding			
Applications	Automotive, Material Handling			
Mechanical Properties		Test Method	English Units	S.I. Units
Tensile Strength @ Yield	ASTM D638	26,000	psi	179 MPa
Tensile Elongation at Break	ASTM D638	5	%	5 %
Flexural Modulus	ASTM D790	1,200,000	psi	8,276 MPa
Flexural Strength	ASTM D790	31,000	psi	214 MPa
Notched Izod Impact (73°F)	ASTM D256	2.0	ft-lb/in	107 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		33	%	33 %
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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