

# EnLon 635GFBUIM

Polyamide 6



Product Description					
35% Glass Fiber, Glass Bead Filled, UV Stabilized, Impact Modified 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	10,800	psi	74	MPa
Tensile Modulus	ASTM D638	700,000	psi	4828	MPa
Tensile Elongation at Break	ASTM D638	5	%	5	%
Flexural Modulus	ASTM D790	690,000	psi	4,759	MPa
Flexural Strength	ASTM D790	19,000	psi	131	MPa
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.34	sp gr	1.34	sp gr
Melt Flow 275°C/2.16 kg	ASTM D1238	10.0	g/10min	10.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.003	in/in	0.003	mm/mm
Filler Content		35	%	35	%
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	330	°F	166	°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.