

EnLon 635GFM

Polyamide 6



Product Description					
35% Glass Filled Nylon 6, Heat Stabilized, Lubricated					
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	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		35	%	35	%
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.

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