

# EnLon 640GF

Polyamide 6



Product Description				
40% Glass Filled Nylon 6				
General Properties				
Appearance	Black, Natural or Colors			
Processing Methods	Injection Molding			
Applications	Automotive, Material Handling, Industrial			
Mechanical Properties		Test Method	English Units	S.I. Units
Tensile Strength @ Yield	ASTM D638	29,000	psi	200 MPa
Tensile Elongation at Break	ASTM D638	3	%	3 %
Flexural Modulus	ASTM D790	1,500,000	psi	10,345 MPa
Notched Izod Impact (73°F)	ASTM D256	2.5	ft-lb/in	134 J/m
Physical Properties		Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.45	sp gr	1.45 sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.002	in/in	0.051 mm/mm
Filler Content		40	%	40 %
Thermal Properties		Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	390	°F	199 °C
Heat Deflection Temperature @ 264 psi	ASTM D648	400	°F	204 °C
Injection Molding			Value	
Drying Temperature		180	°F	
Drying Time		3.0 - 4.0	hrs	
Maximum Drying Time		4.0	hrs	
Suggested Maximum Moisture		0.02	%	
Rear Barrel Temperatures		490 - 540	°F	
Middle Barrel Temperatures		510 - 550	°F	
Front Barrel Temperatures		520 - 570	°F	
Nozzle Temperature		540 - 570	°F	
Melt (processing) Temperatures		500 - 570	°F	
Mold Temperatures		160 - 210	°F	

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.