

EnLon 640GFIM

Polyamide 6



Product Description			
40% Glass Filled Nylon 6, Impact Modified			
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	21,400 psi	148 MPa
Tensile Elongation at Break	ASTM D638	3 %	3 %
Flexural Modulus	ASTM D790	1,310,000 psi	9,034 MPa
Flexural Strength	ASTM D790	33,200 psi	229 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	1.46 sp gr	1.46 sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.002 in/in	0.002 mm/mm
Filler Content		40 %	40 %
Thermal Properties	Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	429 °F	221 °C
Heat Deflection Temperature @ 264 psi	ASTM D648	406 °F	208 °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.

EnCom Polymers, Inc.

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