

EnLon 640MGF

Polyamide 6



Product Description

40% Glass/Mineral Filled Nylon 6

General Properties

Appearance	Black
Processing Methods	Injection Molding
Applications	Automotive, Material Handling, Industrial

Mechanical Properties

	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	16,000	psi	110	MPa
Tensile Elongation at Break	ASTM D638	3	%	3	%
Flexural Modulus	ASTM D790	1,000,000	psi	6,897	MPa
Flexural Strength	ASTM D790	28,000	psi	193	MPa
Notched Izod Impact (73°F)	ASTM D256	0.8	ft-lb/in	43	J/m

Physical Properties

	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.49	sp gr	1.49	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.004	in/in	0.004	mm/mm
Filler Content		40	%	40	%

Thermal Properties

	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	390	°F	199	°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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