

EnLon 6613GFIM

Polyamide 66



Product Description					
13% Glass Filled, Impact Modified Nylon 66					
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	14,000	psi	97	MPa
Tensile Elongation at Break	ASTM D638	3	%	3	%
Flexural Modulus	ASTM D790	550,000	psi	3,793	MPa
Flexural Strength	ASTM D790	23,000	psi	159	MPa
Notched Izod Impact (73°F)	ASTM D256	5.7	ft-lb/in	305	J/m
Physical Properties		Test Method	English Units	S.I. Units	
Specific Gravity	ASTM D792	1.19	sp gr	1.19	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	.005 - .008	in/in	0.127 - 0.203	mm/mm
Rockwell Hardness (R-Scale)	ASTM D785	82 (M Scale)		82 (M Scale)	
Filler Content		13	%	13	%
Flame Rating 0.062	UL 94	HB		HB	
Water Absorption	ASTM D570	0.01	%	0.01	%
Thermal Properties		Test Method	English Units	S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	448	°F	231	°C
Injection Molding			Value		
Drying Temperature		165 - 200	°F		
Drying Time		2.0 - 4.0	hrs		
Maximum Drying Time		4.0	hrs		
Suggested Maximum Moisture		0.02	%		
Rear Barrel Temperatures		460 - 540	°F		
Middle Barrel Temperatures		460 - 540	°F		
Front Barrel Temperatures		470 - 565	°F		
Nozzle Temperature		470 - 565	°F		
Melt (processing) Temperatures		485 - 565	°F		
Mold Temperatures		160 - 220	°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.