

EnLon 6633GF

Polyamide 66



Product Description				
33% Glass Filled, Heat Stabilized, and Lubricated Nylon 66				
General Properties				
Appearance	Black, Natural or Colors			
Processing Methods	Injection Molding			
Applications	Automotive, Material Handling			
Mechanical Properties		Test Method	English Units	S.I. Units
Tensile Strength @ Yield	ASTM D638	28,000	psi	193 MPa
Tensile Elongation at Break	ASTM D638	3	%	3 %
Flexural Modulus	ASTM D790	1,500,000	psi	10,345 MPa
Flexural Strength	ASTM D790	43,000	psi	297 MPa
Notched Izod Impact (73°F)	ASTM D256	2.0	ft-lb/in	107 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	0.076 mm/mm
Filler Content		33	%	33 %
Flame Rating 0.059	UL 94	HB		HB
Water Absorption	ASTM D570	0.70	%	0.70 %
Thermal Properties		Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 264 psi	ASTM D648	487	°F	253 °C
Injection Molding			Value	
Drying Temperature		165	°F	
Drying Time		2.0 - 4.0	hrs	
Maximum Drying Time		4.0	hrs	
Suggested Maximum Moisture		0.02	%	
Rear Barrel Temperatures		550 - 570	°F	
Middle Barrel Temperatures		530 - 550	°F	
Front Barrel Temperatures		510 - 530	°F	
Nozzle Temperature		540 - 560	°F	
Melt (processing) Temperatures		550 - 580	°F	
Mold Temperatures		150 - 210	°F	
Back Pressure		20 - 60	psi	
Screw speed		40 - 120	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.

EnCom Polymers, Inc.

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