

EnLon 6633GFHM

Polyamide 66



Product Description				
33% Glass Filled, Heat Stabilized, and Modified 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	20,000	psi	138 MPa
Tensile Elongation at Break	ASTM D638	3	%	3 %
Flexural Modulus	ASTM D790	1,100,000	psi	7,586 MPa
Notched Izod Impact (73°F)	ASTM D256	1.5	ft-lb/in	80 J/m
Physical Properties		Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.39	sp gr	1.39 sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.003 - 0.006	in/in	0.076 - 0.152 mm/mm
Filler Content		30	%	30 %
Thermal Properties		Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 264 psi	ASTM D648	450	°F	232 °C
Injection Molding			Value	
Drying Temperature		165 - 200	°F	
Drying Time		3.0 - 6.0	hrs	
Maximum Drying Time		4.0	hrs	
Suggested Maximum Moisture		0.02	%	
Rear Barrel Temperatures		530 - 570	°F	
Middle Barrel Temperatures		530 - 570	°F	
Front Barrel Temperatures		510 - 530	°F	
Nozzle Temperature		530 - 570	°F	
Melt (processing) Temperatures		540 - 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.