

EnLon 6640GM

Polyamide 66



Product Description				
40% Glass/Mineral Filled 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	18,000 psi	124 MPa	
Tensile Elongation at Break	ASTM D638	3 %	3 %	
Flexural Modulus	ASTM D790	1,200,000 psi	8,276 MPa	
Flexural Strength	ASTM D790	27,000 psi	186 MPa	
Notched Izod Impact (73°F)	ASTM D256	1.0 ft-lb/in	53 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	0.102 mm/mm	
Filler Content		40 %	40 %	
Thermal Properties		Test Method	English Units	S.I. Units
Heat Deflection Temperature @ 264 psi	ASTM D648	464 °F	240 °C	
Injection Molding		Value		
Drying Temperature		180 °F		
Drying Time		2.0 - 4.0 hrs		
Maximum Drying Time		4.0 hrs		
Suggested Maximum Moisture		0.02 %		
Rear Barrel Temperatures		520 - 540 °F		
Middle Barrel Temperatures		540 - 570 °F		
Front Barrel Temperatures		540 - 580 °F		
Nozzle Temperature		550 - 580 °F		
Melt (processing) Temperatures		550 - 580 °F		
Mold Temperatures		180 - 220 °F		
Back Pressure		20 - 60 psi		
Screw speed		60 - 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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