

EnLon 6640MFHS

Polyamide 66



Product Description			
Heat Stabilized, 40% Mineral Filled Nylon 66			
General Properties			
Appearance	Black, Natural, Colors		
Processing Methods	Injection Molding		
Applications	Automotive, Material Handling, Industrial		
Mechanical Properties	Test Method	English Units	S.I. Units
Tensile Strength @ Yield	ASTM D638	11,500 psi	79 MPa
Tensile Elongation at Break	ASTM D638	15 %	15 %
Flexural Modulus	ASTM D790	950,000 psi	6,552 MPa
Notched Izod Impact (73°F)	ASTM D256	0.9 ft-lb/in	45 J/m
Physical Properties	Test Method	English Units	S.I. Units
Specific Gravity	ASTM D792	1.50 sp gr	1.50 sp gr
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	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.

812-421-7700 • www.encompolymers.com