

EnLon 6643GFHSV

Polyamide 66



Product Description				
Heat Stabilized, Lubricated 43% Glass Filled Nylon 66				
General Properties				
Appearance	Black			
Processing Methods	Injection Molding			
Applications	Automotive, Material Handling, Industrial			
Mechanical Properties	Test Method	English Units		S.I. Units
Tensile Strength @ Yield	ASTM D638	29,000	psi	200 MPa
Tensile Elongation at Break	ASTM D638	3	%	3 %
Flexural Modulus	ASTM D790	1,650,000	psi	11,379 MPa
Flexural Strength	ASTM D790	43,000	psi	297 MPa
Notched Izod Impact (73°F)	ASTM D256	3.0	ft-lb/in	160 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	0.003	in/in	0.076 mm/mm
Filler Content		43	%	43 %
Thermal Properties	Test Method	English Units		S.I. Units
Heat Deflection Temperature @ 66 psi	ASTM D648	495	°F	257 °C
Heat Deflection Temperature @ 264 psi	ASTM D648	480	°F	249 °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.