

# EnLon 6IM20E

Polyamide 6



Product Description					
Extrusion Grade Nylon 6, Heat Stabilized, Impact Modified					
General Properties					
Appearance	Black, Natural or Colors				
Processing Methods	Extrusion, Blow Molding, Vacuum Forming				
Applications	Automotive, Material Handling, Industrial				
Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	7,000	psi	48	MPa
Tensile Elongation at Break	ASTM D638	125	%	125	%
Flexural Modulus	ASTM D790	225,000	psi	1,552	MPa
Flexural Strength	ASTM D790	8,000	psi	55	MPa
Notched Izod Impact (73°F)	ASTM D256	16.0	ft-lb/in	854	J/m
Physical Properties	Test Method	English Units		S.I. Units	
Specific Gravity	ASTM D792	1.07	sp gr	1.07	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)	ASTM D955	0.014	in/in	0.014	mm/mm
Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	140	°F	60	°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		470 - 520	°F		
Middle Barrel Temperatures		480 - 530	°F		
Front Barrel Temperatures		490 - 540	°F		
Nozzle Temperature		490 - 540	°F		
Melt (processing) Temperatures		490 - 540	°F		
Mold Temperatures		130 - 200	°F		

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.