

EnLon F0610GF

PA 6



Product Description						
10% Glass Filled Nylon 6, flame retardant						
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	12,500	psi	86	MPa
Tensile Elongation at Break		ASTM D638	10	%	10	%
Flexural Modulus		ASTM D790	500,000	psi	3,448	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	1.42	sp gr	1.42	sp gr
Mold Shrink - Flow: 0.126 in (3.20 mm)		ASTM D955	0.004	in/in	0.004	mm/mm
Mold Shrink Xverse		ASTM D955	0.008	in/in	0.008	mm/mm
Filler Content			10.0	%	10.0	%
Flame Rating	0.125	UL 94	V0		V0	
Thermal Properties		Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi		ASTM D648	400	°F	204	°C
Injection Molding			Value			
Drying Temperature			165	°F		
Drying Time			4.0 - 8.0	hrs		
Maximum Drying Time			4	hrs		
Suggested Maximum Moisture			0.02	%		
Suggested Shot Size			25 - 75	%		
Rear Barrel Temperatures			430-480	°F		
Middle Barrel Temperatures			440-490	°F		
Front Barrel Temperatures			450-500	°F		
Nozzle Temperature			450-500	°F		
Melt (processing) Temperatures			460-500	°F		
Mold Temperatures			160 - 200	°F		
Back Pressure			20 - 60	psi		
Screw speed			50 - 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.

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