AuroraGuard™ 610GFIM

Aurora Material Solutions, LLC - *Polyamide 6*

General Information

Product Description			
10% Glass Filled Nylon 6, Impact Modified			
Formerly known as EnLon 610GFIM			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Additive	• Impact Modifier		
Features	• Impact Modified		
Uses	• Automotive Applications		
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.126 in)	4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow	8.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	8700	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	319000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	4.0	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	380	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	165	°F
Drying Time	4.0 to 8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	25 to 75	%
Rear Temperature	470 to 520	°F
Middle Temperature	480 to 530	°F
Front Temperature	490 to 540	°F
Nozzle Temperature	490 to 540	°F
Processing (Melt) Temp	490 to 530	°F
Mold Temperature	160 to 200	°F
Back Pressure	20.0 to 60.0	psi
Screw Speed	50 to 120	rpm

Notes

[1] Typical properties: these are not to be construed as specifications.