

AuroraGuard™ 610IMHSX

Aurora Material Solutions, LLC - Polyamide 6

General Information

Product Description

Heat Stabilized, Impact Modified Nylon 6 with Extra Release

Formerly known as EnLon 610IMHSX

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• Good Mold Release	• Heat Stabilized	• Impact Modified
Appearance	• Black	• Natural Color	
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow (0.126 in)	0.014	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8000	psi	ASTM D638
Tensile Elongation (Break)	75	%	ASTM D638
Flexural Modulus	270000	psi	ASTM D790
Flexural Strength	11000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	10	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	140	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
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 540	°F
Mold Temperature	130 to 200	°F

Injection Notes

Maximum Drying Time 4.0 hrs

