

AuroraGuard™ 615GFHSXL

Aurora Material Solutions, LLC - Polyamide 6

General Information

Product Description

15% Glass Filled Nylon 6, Heat Stabilized, Extra Lubrication
Formerly known as EnLon 615GFHSXL

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
Uses	• Automotive Applications
Appearance	• Black • Colors Available • Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow (0.126 in)	5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	17000	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	750000	psi	ASTM D790
Flexural Strength	27000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.1	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	405	°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

