

AuroraGuard™ 615GFIM

Aurora Material Solutions, LLC - Polyamide 6

General Information

Product Description

15% Glass Filled Nylon 6, Impact Modified

Formerly known as EnLon 615GFIM

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	• Impact Modifier		
Features	• Impact Modified		
Uses	• Automotive Applications	• Material Handling	
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
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	14000	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	550000	psi	ASTM D790
Flexural Strength	22000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.0	ft·lb/in	ASTM D256
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
Injection Notes		
Maximum Drying Time 4 hrs		

