

AuroraGuard™ 616HM

Aurora Material Solutions, LLC - Polyamide 6

General Information

Product Description

Nylon 6, Heat Stabilized and Impact Modified

Formerly known as EnLon 616HM

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• Heat Stabilized	• Impact Modified	
Uses	• Automotive Applications	• Industrial Applications	• Material Handling
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow (0.126 in)	1.4E-5	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Elongation (Break)	200	%	ASTM D638
Flexural Modulus	270000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	16	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	142	°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 hrs		

