

AuroraGuard™ 633GF-R

Aurora Material Solutions, LLC - Polyamide 6

General Information

Product Description

33% Glass Filled, Heat Stabilized, Lubricated Nylon 6 Recycled Content
Formerly known as EnLon 633GF-R

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Recycled Content	• Yes		
Features	• Heat Stabilized	• Lubricated	• Recyclable Material
Uses	• Automotive Applications		
Appearance	• Black		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow (0.126 in)	3.0E-3	in/in	ASTM D955
Water Absorption (Saturation)	0.70	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	17500	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	28500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	405	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	165	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	550 to 570	°F
Middle Temperature	530 to 550	°F
Front Temperature	510 to 530	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	550 to 580	°F
Mold Temperature	150 to 210	°F
Back Pressure	20.0 to 60.0	psi
Screw Speed	40 to 120	rpm

