AuroraGuard™ 635GFBUIM

Aurora Material Solutions, LLC - *Polyamide 6*

General Information

Product Description

35% Glass Fiber, Glass Bead Filled, UV Stabilized, Impact Modified Nylon 6
Formerly known as EnLon 635GFBUIM

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Bead\Glass Fiber, 35% Filler by Weight		
Additive	• Impact Modifier	• UV Stabilizer	
Features	• Impact Modified	• UV Stabilized	
Uses	• Automotive Applications		
Appearance	• Black	• Colors Available	• Natural Color
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Melt Mass-Flow Rate (MFR) (275°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.126 in)	3.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	700000	psi	ASTM D638
Tensile Strength (Yield)	10800	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	690000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	330	°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

Injection Notes

Maximum Drying Time 4.0 hrs