

AuroraGuard™ 635GFM

Aurora Material Solutions, LLC - Polyamide 6

General Information

Product Description

35% Glass Filled Nylon 6, Heat Stabilized, Lubricated

Formerly known as EnLon 635GFM

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 35% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
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
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	23000	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	30500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.8	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	185	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	428 to 500	°F
Middle Temperature	446 to 509	°F
Front Temperature	482 to 518	°F
Mold Temperature	131 to 203	°F
Back Pressure	50.8 to 102	psi
Screw Speed	60 to 90	rpm
Injection Notes		
Maximum Drying Time 4.0 hrs		

