AuroraGuard™ 6613GFV

Aurora Material Solutions, LLC - *Polyamide 66*

General Information

Product Description	
13% Glass Filled Nylon 66 Formerly known as EnLon 6613GFV	
General	
Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight
Uses	• Automotive Applications • Industrial Applications
Appearance	• Black
Processing Method	• Injection Molding

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow (0.126 in)	5.0E-3 to 8.0E-3	in/in	ASTM D955
Water Absorption (Equilibrium)	0.010	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	520000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	1.0	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	430	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	165 to 200	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	460 to 540	°F
Middle Temperature	460 to 540	°F
Front Temperature	470 to 565	°F
Nozzle Temperature	470 to 565	°F
Processing (Melt) Temp	485 to 565	°F
Mold Temperature	160 to 220	°F
Injection Notes		
Maximum Drying Time 4.0 hrs		