

AuroraGuard™ 6613GF

Aurora Material Solutions, LLC - Polyamide 66

General Information

Product Description

13% Glass Filled Nylon 66

Formerly known as EnLon 6613GF

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Uses	• Automotive Applications	• Industrial Applications	
Appearance	• Black	• Colors Available	• Natural Color
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 (Saturation)	0.010	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	15500	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	650000	psi	ASTM D790
Flexural Strength	22000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.3	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	470	°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		

