

AuroraGuard™ 6635GFM

Aurora Material Solutions, LLC - Polyamide 66

General Information

Product Description

35% Glass Filled, Heat Stabilized, Lubricated Nylon 66

Formerly known as EnLon 6635GFM

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • Asia Pacific • Latin America • North 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

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow (0.126 in)	3.0E-3	in/in	ASTM D955
Water Absorption (Equilibrium)	0.70	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	22000	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	1.25E+6	psi	ASTM D790
Flexural Strength	31000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F)	2.0	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	487	°F	ASTM D648
Flammability			
Flame Rating (0.06 in)	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

