

**AuroraGuard™ 6630GFHS**

Aurora Material Solutions, LLC - Polyamide 66

**General Information**
**Product Description**

30% Glass Filled, Heat Stabilized, and Lubricated Nylon 66

Formerly known as EnLon 6630GFHS

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
Uses	• Automotive Applications
Appearance	• Black • Natural Color
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.36		ASTM D792
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
<b>Mechanical</b>			
Tensile Strength (Yield)	27000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength (Yield)	40000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F)	2.0	ft·lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	475	°F	ASTM D648

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	530 to 570	°F
Middle Temperature	530 to 570	°F
Front Temperature	530 to 570	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	530 to 570	°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 6.0 hrs

