AuroraGuard™ 6613GFIM

Aurora Material Solutions, LLC - *Polyamide 66*

General Information

Product Description			
13% Glass Filled, Impact Modified Nylon 66 Formerly known as EnLon 6613GFIM			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Additive	• Impact Modifier		
Features	• Impact Modified		
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	1.19		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)	14000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	550000	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	5.7	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	82		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	448	°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		