

AuroraGuard™ 6640GM

Aurora Material Solutions, LLC - Polyamide 66

General Information

Product Description

40% Glass/Mineral Filled Nylon 66

Formerly known as EnLon 6640GM

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber/Mineral, 40% 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	1.49		ASTM D792
Molding Shrinkage - Flow (0.126 in)	4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	18000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Flexural Strength	27000	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)	464	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	520 to 540	°F
Middle Temperature	540 to 570	°F
Front Temperature	540 to 580	°F
Nozzle Temperature	550 to 580	°F
Processing (Melt) Temp	550 to 580	°F
Mold Temperature	180 to 220	°F
Back Pressure	20.0 to 60.0	psi
Screw Speed	60 to 120	rpm

Injection Notes

Maximum Drying Time 4.0 hrs

