

## AuroraGuard™ F06610GF

Aurora Material Solutions, LLC - Polyamide 66

### General Information

#### Product Description

10% Glass Filled Nylon 66, flame retardant

Formerly known as EnLon F06610GF

#### General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Features	• Flame Retardant
Uses	• Automotive Applications
Appearance	• Black • Colors Available • Natural Color
Processing Method	• Injection Molding

### Properties <sup>1</sup>

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.42		ASTM D792
Molding Shrinkage - Flow (0.126 in)	4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow	8.0E-3	in/in	ASTM D955
<b>Mechanical</b>			
Tensile Strength (Yield)	12500	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F)	1.0	ft-lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
<b>Flammability</b>			
Flame Rating (0.13 in)	V-0		UL 94

### Processing Information

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	4.0 to 8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	25 to 75	%
Rear Temperature	470 to 520	°F
Middle Temperature	480 to 530	°F
Front Temperature	490 to 540	°F
Nozzle Temperature	490 to 540	°F
Processing (Melt) Temp	490 to 530	°F
Mold Temperature	160 to 200	°F
Back Pressure	20.0 to 60.0	psi
Screw Speed	50 to 120	rpm

