AuroraGuard™ 6650LGFHS

Aurora Material Solutions, LLC - *Polyamide 66*

General Information

Product Description			
50% Long Glass Fober Filled Nylon 66, Heat Stabalized Formerly known as EnLon 6650LGFHS			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Long Glass Fiber, 50% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Heat Stabilized		
Uses	• Automotive Applications	• Material Handling	
Appearance	• Black		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.58	g/cm³	ISO 1183
Molding Shrinkage - Flow (0.126 in)	0.10	in/in	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress	33400	psi	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	2.39E+6	psi	ISO 178
Flexural Stress	50800	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	0.10	ft·lb/in²	ISO 179
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94
Additional Information	**Nominal Value**	**Unit**	**Test Method**
Filler Content	50	%	

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	185	°F
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	25 to 75	%
Rear Temperature	500 to 560	°F
Middle Temperature	555 to 570	°F
Front Temperature	555 to 570	°F
Nozzle Temperature	555 to 570	°F
Processing (Melt) Temp	550 to 580	°F
Mold Temperature	200	°F
Back Pressure	20.0 to 50.0	psi
Screw Speed	30 to 50	rpm
Injection Notes		
Maximum Drying Time 6 hrs		