

EnCom PA6U GR15 MF25 BK 42004

Polyamide 6

EnCom, Inc.

Message:

Glass & Mineral Filled Nylon 6

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
	Mineral,25% Filler by Weight		
Uses	Automotive Applications		
	Industrial Applications		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	5.5	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	122	MPa	ASTM D638
Tensile Elongation (Break)	2.3	%	ASTM D638
Flexural Modulus	10800	MPa	ASTM D790
Flexural Strength (Yield)	188	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	213	°C	
1.8 MPa, Unannealed	199	°C	
Flammability	Nominal Value		Test Method
Flame Rating (1.57 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	73.9 to 93.3	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	238 to 282	°C	

Middle Temperature	238 to 282	°C
Front Temperature	243 to 296	°C
Nozzle Temperature	243 to 296	°C
Processing (Melt) Temp	252 to 296	°C
Mold Temperature	71.1 to 104	°C

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