

AUX 536

AUXIVA's AUX 536 is a Nylon 66 heat stabilized, lubricated compound reinforced with 20% glass fiber to improve strength and rigidity. For injection molding applications.

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30		ASTM D792
Ash	20	%	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	17,000	psi	ASTM D638
Tensile Elongation (Break)	2 to 4	%	ASTM D638
Flexural Modulus	900,000	psi	ASTM D790
Flexural Strength	25,000	psi	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	0.9	ft-lb/in	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	460	°F	ASTM D648

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Recommended Process Conditions	
Injection Molding Parameters	Nominal Values (English)
Drying temperature	180 °F
Drying time	2-4 HR
Suggested max moisture	0.20%
Rear temperature	520°F
Middle temperature	525°F
Front temperature	530°F
Processing (melt) temperature	500-550°F
Mold temperature	170 to 185°F
Back pressure	35-40.0 psi
Screw speed	50 to 70 rpm
Cushion	0.125 to 0.250 in