

Polifil® Nylon 620-33GF

Polyamide 66

The Plastics Group

Message:

Polifil® Nylon 620-33GF is a Polyamide 66 (Nylon 66) product filled with 33% glass fiber. It is available in North America.

General Information			
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792
Water Absorption			ASTM D570
24 hr	0.80	%	
Saturation	5.4	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	159	MPa	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Flexural Modulus	7930	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	96	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	252	°C	
1.8 MPa, Unannealed	249	°C	
Melting Temperature	252	°C	
Injection	Nominal Value	Unit	
Rear Temperature	271 to 282	°C	
Middle Temperature	260 to 266	°C	
Front Temperature	260 to 266	°C	
Nozzle Temperature	271 to 277	°C	
Processing (Melt) Temp	271 to 282	°C	
Mold Temperature	71.1 to 82.2	°C	
Injection Rate	Fast		
Back Pressure	0.345 to 1.03	MPa	
Screw Speed	50 to 80	rpm	

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