

Polifil® Nylon 628-33GF

Polyamide 66

The Plastics Group

Message:

Polifil® GFN/MRN 6/6 reinforced series of compounds offer superior strength, rigidity, and creep resistance. Glass fibers provide excellent thermal and dimensional stability while maintaining good heat and chemical resistance. Polifil® GFN/MRN are excellent candidates for bike components and fuel caps, as well as other automotive components. Standard processing techniques are applicable. Use this information as a guide to aid you in selecting the proper resin for your application. TPG will custom compound and fine-tune our formulations for your application.

General Information			
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Features	Good Chemical Resistance		
	Good Creep Resistance		
	Good Dimensional Stability		
	Good Thermal Stability		
	High Heat Resistance		
	High Rigidity		
	High Strength		
Uses	Automotive Applications		
	Caps		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9650	MPa	ASTM D638
Tensile Strength (23°C)	165	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield, 23°C	3.0	%	
Break, 23°C	3.0	%	
Flexural Modulus - Tangent (23°C)	8270	MPa	ASTM D790
Flexural Strength (23°C)	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Gardner Impact (23°C, 12.7 mm)	0.452	J	ASTM D3029

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	254	°C	
1.8 MPa, Unannealed	249	°C	
Injection	Nominal Value	Unit	
Drying Temperature	104	°C	
Drying Time	2.0	hr	
Rear Temperature	288	°C	
Middle Temperature	274	°C	
Front Temperature	282	°C	
Nozzle Temperature	288	°C	
Processing (Melt) Temp	282 to 304	°C	
Mold Temperature	37.8 to 93.3	°C	
Injection Rate	Fast		
Back Pressure	0.172 to 0.517	MPa	
Screw Speed	30 to 60	rpm	

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