

# Nylene® 7228 HS

Polyamide 6  
Custom Resins Group

Message:

Nylene® 7228 HS is a Polyamide 6 (Nylon 6) material filled with 28% glass\mineral. It is available in North America for extrusion or injection molding. Important attributes of Nylene® 7228 HS are:  
Heat Resistant  
Heat Stabilizer

General Information	
Filler / Reinforcement	Glass\Mineral,28% Filler by Weight
Additive	Heat Stabilizer
Features	Good Thermal Stability
	Heat Stabilized
	High Heat Resistance
Forms	Pellets
Processing Method	Extrusion
	Injection Molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	66.0	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	8.0	%	ASTM D638
Flexural Modulus (23°C)	3390	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	151	°C	ASTM D648
Melting Temperature	216	°C	
Injection	Nominal Value	Unit	
Drying Temperature	65.6 to 82.2	°C	
Drying Time	2.0 to 4.0	hr	
Drying Time, Maximum	4.0	hr	
Suggested Max Moisture	0.20	%	
Suggested Shot Size	25 to 75	%	
Suggested Max Regrind	25	%	
Rear Temperature	249 to 277	°C	

Middle Temperature	260 to 288	°C
Front Temperature	271 to 299	°C
Nozzle Temperature	271 to 299	°C
Processing (Melt) Temp	271 to 299	°C
Mold Temperature	82.2 to 93.3	°C
Injection Pressure	55.2 to 124	MPa
Injection Rate	Fast	
Holding Pressure	41.4 to 103	MPa
Back Pressure	0.00 to 0.345	MPa

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#### Recommended distributors for this material

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