

Polifil® Nylon 628L-13GF

Polyamide 66

The Plastics Group

Message:

Polifil® Nylon 628L-13GF is a Polyamide 66 (Nylon 66) product. It is available in North America.

General Information			
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.50	%	ASTM D955
Water Absorption			ASTM D570
24 hr	1.1	%	
Saturation	7.1	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	96.5	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	4830	MPa	ASTM D790
Deformation Under Load (50°C, 14 MPa)	1.10	%	ASTM D621
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	243	°C	ASTM D648
Melting Temperature	252	°C	
Injection	Nominal Value	Unit	
Rear Temperature	282	°C	
Middle Temperature	274	°C	
Front Temperature	271	°C	
Nozzle Temperature	260 to 299	°C	
Processing (Melt) Temp	279 to 304	°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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