

Polifil® Nylon 730-13GF

Polyamide 6

The Plastics Group

Message:

Polifil® Nylon 730-13GF is a Polyamide 6 (Nylon 6) product filled with 13% glass fiber. It is available in North America.

General Information			
Filler / Reinforcement	Glass Fiber, 13% Filler by Weight		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50	%	ASTM D955
Water Absorption (24 hr)	1.4	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	117	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	4900	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	213	°C	
1.8 MPa, Unannealed	196	°C	
Melting Temperature	216	°C	
Injection	Nominal Value	Unit	
Rear Temperature	227 to 260	°C	
Middle Temperature	238 to 271	°C	
Front Temperature	249 to 282	°C	
Nozzle Temperature	249 to 282	°C	
Processing (Melt) Temp	254 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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