

Polifil® Nylon 620-13GF

Polyamide 66

The Plastics Group

Message:

Polifil® Nylon 620-13GF is a Polyamide 66 (Nylon 66) product filled with 13% glass fiber. It is available in North America. Typical application: Housings.

General Information			
Filler / Reinforcement	Glass Fiber, 13% Filler by Weight		
Uses	Housings		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.70	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	89.6	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	4340	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	252	°C	
1.8 MPa, Unannealed	239	°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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