

# Polifil® Nylon 628L

Polyamide 66  
The Plastics Group

Message:

Polifil® Nylon 628L is a Polyamide 66 (Nylon 66) product. It can be processed by injection molding and is available in North America. Typical application: Engineering/Industrial Parts.  
Characteristics include:  
Chemical Resistant  
Wear Resistant

| General Information                |                          |                   |             |
|------------------------------------|--------------------------|-------------------|-------------|
| Features                           | Good Abrasion Resistance |                   |             |
|                                    | Good Chemical Resistance |                   |             |
| Uses                               | Bearings                 |                   |             |
|                                    | Valves/Valve Parts       |                   |             |
| Forms                              | Pellets                  |                   |             |
| Processing Method                  | Injection Molding        |                   |             |
| Physical                           | Nominal Value            | Unit              | Test Method |
| Specific Gravity                   | 1.14                     | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow (3.18 mm) | 1.5                      | %                 | ASTM D955   |
| Water Absorption (24 hr)           | 1.5                      | %                 | ASTM D570   |
| Hardness                           | Nominal Value            | Unit              | Test Method |
| Rockwell Hardness (R-Scale)        | 119                      |                   | ASTM D785   |
| Mechanical                         | Nominal Value            | Unit              | Test Method |
| Tensile Strength (23°C)            | 12.4                     | MPa               | ASTM D638   |
| Tensile Elongation                 |                          |                   | ASTM D638   |
| Yield                              | 5.0                      | %                 |             |
| Break                              | 50                       | %                 |             |
| Flexural Modulus - Tangent         | 2800                     | MPa               | ASTM D790   |
| Flexural Strength (23°C)           | 89.6                     | MPa               | ASTM D790   |
| Impact                             | Nominal Value            | Unit              | Test Method |
| Notched Izod Impact (23°C)         | 53                       | J/m               | ASTM D256   |
| Thermal                            | Nominal Value            | Unit              | Test Method |
| Deflection Temperature Under Load  |                          |                   | ASTM D648   |
| 0.45 MPa, Unannealed               | 235                      | °C                |             |
| 1.8 MPa, Unannealed                | 90.0                     | °C                |             |
| Melting Temperature                | 255                      | °C                |             |
| Electrical                         | Nominal Value            | Unit              | Test Method |
| Volume Resistivity                 | 1.0E+16                  | ohms · cm         | ASTM D257   |

| Dielectric Strength         | 25            | kV/mm | ASTM D149 |
|-----------------------------|---------------|-------|-----------|
| Dielectric Constant (1 MHz) | 3.10          |       | ASTM D150 |
| 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            | 37.8 to 93.3  | °C    |           |
| Injection Pressure          | 34.5 to 138   | MPa   |           |
| Injection Rate              | Moderate-Fast |       |           |

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