

Polifil® Nylon 836L

Polyamide 6

The Plastics Group

Message:

Polifil® Nylon 6 provides superior strength and rigidity with electrical resistance and surface lubricity. These properties have been proven to work in the following applications: automotive, bearings, and appliances. Standard processing techniques are applicable. Use this information as a guide to aid you in selecting the proper resin for your application. TPG will custom compound and fine-tune our formulations for your application.

General Information			
Additive	Lubricant		
Features	Good Electrical Properties		
	High Rigidity		
	High Strength		
	Lubricated		
Uses	Appliances		
	Automotive Applications		
	Bearings		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.2	%	ASTM D955
Water Absorption (24 hr)	1.3	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2480	MPa	ASTM D638
Tensile Strength (23°C)	64.8	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield, 23°C	9.0	%	
Break, 23°C	60	%	
Flexural Modulus - Tangent (23°C)	2210	MPa	ASTM D790
Flexural Strength (23°C)	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	130	J/m	ASTM D256
Gardner Impact (23°C, 12.7 mm)	11.3	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	149	°C	

1.8 MPa, Unannealed	60.0	°C
Injection	Nominal Value	Unit
Drying Temperature	104	°C
Drying Time	2.0	hr
Rear Temperature	249	°C
Middle Temperature	271	°C
Front Temperature	282	°C
Nozzle Temperature	282	°C
Processing (Melt) Temp	277 to 293	°C
Mold Temperature	37.8 to 93.3	°C
Injection Rate	Fast	
Back Pressure	0.172 to 0.517	MPa
Screw Speed	30 to 60	rpm

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