

Matrixx FP63E15BK22

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

FP63E15BK22 is a 15% glass-reinforced, Black Nylon 6

General

Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Features	• Filled
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.23	1.23 g/cm ³	ASTM D792
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Break)	18500 psi	128 MPa	ASTM D638
Flexural Modulus	77000 psi	531 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	0.80 ft·lb/in	43 J/m	ASTM D256
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 Psi (1.8 Mpa), Unannealed	370 °F	188 °C	ASTM D648

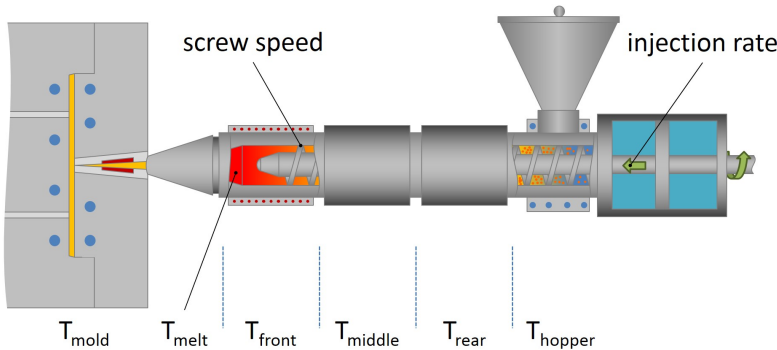
Additional Information

1F873A/PR1223
Revision: 5/2/2020



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	160 to 200 °F	71 to 93 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.10 %	0.10 %
Rear Temperature	480 to 540 °F	249 to 282 °C
Middle Temperature	500 to 540 °F	260 to 282 °C
Front Temperature	500 to 540 °F	260 to 282 °C
Processing (Melt) Temp	480 to 540 °F	249 to 282 °C
Mold Temperature	180 to 200 °F	82 to 93 °C
Injection Rate	Fast	Fast
Back Pressure	< 50.0 psi	< 0.345 MPa
Cushion	0.250 to 0.500 in	6.35 to 12.7 mm

Injection Notes
Screw Speed: Slow to Medium
Dessicant dryer with -20°F dewpoint

Notes

These are typical property values not to be construed as specification limits.

