

Matrixx FP63E13

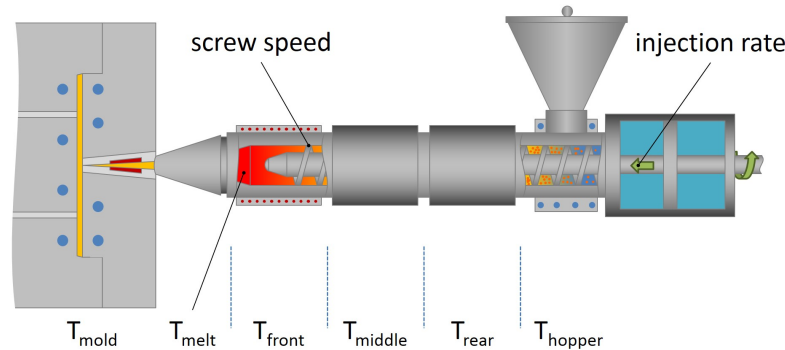
Polyamide 6
LyondellBasell Industries
Engineering Plastics

General			
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Forms	• Pellets		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21 g/cm ³	ASTM D792
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	16000 psi	110 MPa	ASTM D638
Flexural Modulus - Tangent	650000 psi	4480 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	0.90 ft·lb/in	48 J/m	ASTM D256
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	390 °F	199 °C	
264 Psi (1.8 Mpa), Unannealed	380 °F	193 °C	
RTI Str	150 °F	65.6 °C	UL 746B
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94



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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	500 to 550 °F	260 to 288 °C
Middle Temperature	500 to 550 °F	260 to 288 °C
Front Temperature	500 to 550 °F	260 to 288 °C
Processing (Melt) Temp	500 to 560 °F	260 to 293 °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.

