

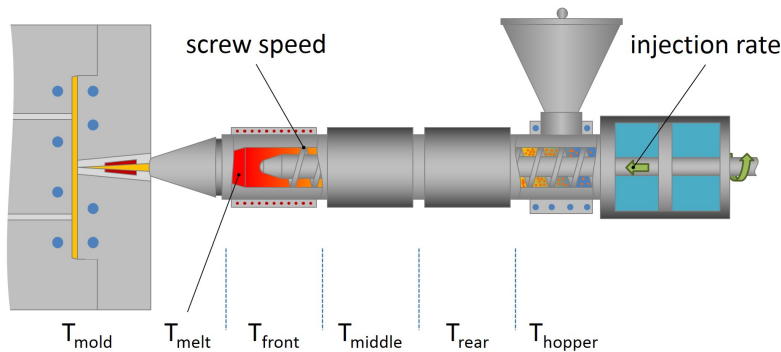
Technical Data Sheet
Matrixx F663E13
Polyamide 66
Engineering Plastics



General			
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Forms	• Pellets		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.22	1.22 g/cm ³	ASTM D792
Molding Shrinkage - Flow (0.125 in (3.18 mm))	3.0E-3 to 6.0E-3 in/in	0.30 to 0.60 %	Internal Method
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	16500 psi	114 MPa	ASTM D638
Flexural Modulus - Tangent	720000 psi	4960 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	1.0 ft·lb/in	53 J/m	ASTM D256
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	460 °F	238 °C	ASTM D648
RTI Str	150 °F	65.6 °C	UL 746
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
Rear Temperature	520 to 570 °F	271 to 299 °C
Middle Temperature	520 to 570 °F	271 to 299 °C
Front Temperature	520 to 570 °F	271 to 299 °C
Processing (Melt) Temp	530 to 570 °F	277 to 299 °C
Mold Temperature	150 to 200 °F	66 to 93 °C
Injection Rate	Moderate-Fast	Moderate-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.

