

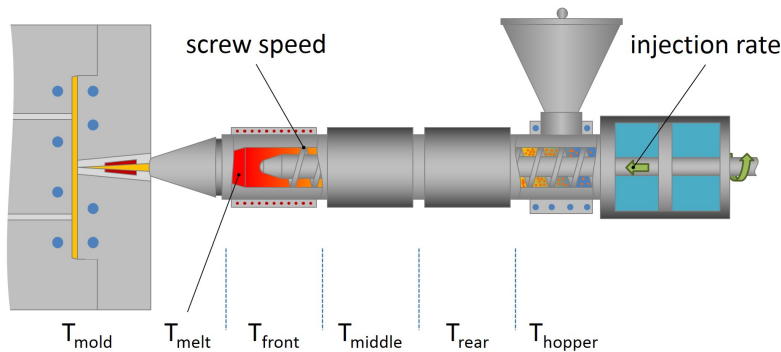
Technical Data Sheet
Matrixx 663E0
Polyamide 66
Engineering Plastics



General			
Features	• High Impact Resistance		
Forms	• Pellets		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.10	1.10 g/cm³	ASTM D792
Molding Shrinkage - Flow (0.125 in (3.18 mm))	0.010 to 0.014 in/in	1.0 to 1.4 %	Internal Method
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	9300 psi	64.1 MPa	ASTM D638
Flexural Modulus - Tangent	360000 psi	2480 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	4.0 ft·lb/in	210 J/m	ASTM D256
Gardner Impact	> 320 in·lb	> 36.2 J	ASTM D5420
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
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 180 °F	71 to 82 °C
Drying Time	4.0 hr	4.0 hr
Rear Temperature	480 to 560 °F	249 to 293 °C
Middle Temperature	480 to 560 °F	249 to 293 °C
Front Temperature	480 to 560 °F	249 to 293 °C
Processing (Melt) Temp	520 to 560 °F	271 to 293 °C
Mold Temperature	125 to 180 °F	52 to 82 °C
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	< 50.0 psi	< 0.345 MPa
Cushion	0.125 to 0.250 in	3.18 to 6.35 mm

Injection Notes
-20°C Dewpoint
Screw Speed: Medium

Notes

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

