

# TexRes PA 6 FG13

## TexCo Resin - Polyamide 6

### General Information

#### General

|                        |                                     |
|------------------------|-------------------------------------|
| Filler / Reinforcement | • Glass Fiber, 13% Filler by Weight |
| Additive               | • Lubricant                         |
| Features               | • Lubricated                        |
| Forms                  | • Pellets                           |
| Processing Method      | • Injection Molding                 |

### Properties <sup>1</sup>

| Physical   | Nominal Value | Unit     | Test Method     |
|--|---------------|----------|-----------------|
| Density / Specific Gravity                               | 1.12          |          | ASTM D792       |
| Molding Shrinkage - Flow                                 | 6.0E-3        | in/in    | ASTM D955       |
| Mechanical   | Nominal Value | Unit     | Test Method     |
| Tensile Strength   | 12000         | psi      | ASTM D638       |
| Tensile Elongation (Break)                               | 6.0           | %        | ASTM D638       |
| Flexural Modulus   | 500000        | psi      | ASTM D790       |
| Flexural Strength  | 18000         | psi      | ASTM D790       |
| Impact   | Nominal Value | Unit     | Test Method     |
| Notched Izod Impact                                      | 0.90          | ft-lb/in | ASTM D256       |
| Thermal  | Nominal Value | Unit     | Test Method     |
| Deflection Temperature Under Load (66 psi, Unannealed)   | 410           | °F       | ASTM D648       |
| Deflection Temperature Under Load<br>264 psi, Unannealed | 390           | °F       | ASTM D648       |
| Melting Temperature                                      | 425           | °F       |                 |
| Flammability   | Nominal Value | Unit     | Test Method     |
| Flame Rating   | HB            |          | Internal Method |

### Processing Information

| Injection             | Nominal Value | Unit |
|-----------------------|---------------|------|
| Drying Temperature    | 160 to 180    | °F   |
| Suggested Max Regrind | 25            | %    |
| Rear Temperature      | 410 to 450    | °F   |
| Middle Temperature    | 440 to 480    | °F   |
| Front Temperature     | 470 to 510    | °F   |
| Nozzle Temperature    | 450 to 500    | °F   |
| Mold Temperature      | 160 to 220    | °F   |
| Injection Pressure    | 5000 to 20000 | psi  |
| Back Pressure         | 0.00 to 150   | psi  |
| Screw Speed           | 30 to 60      | rpm  |