

TexRes PA 6 FG33

TexCo Resin - Polyamide 6

General Information

General

Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Lubricant
Features	• Lubricated
Forms	• Pellets
Processing Method	• Injection Molding

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		ASTM D792
Molding Shrinkage - Flow	3.5E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	24000	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength (Yield)	36000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.4	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.250 in	419	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.250 in	419	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		Internal Method

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Suggested Shot Size	30 to 80	%
Rear Temperature	480 to 510	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	490 to 525	°F
Processing (Melt) Temp	490 to 520	°F
Mold Temperature	175 to 250	°F
Injection Pressure	1200 to 2000	psi
Back Pressure	50.0	psi
Screw Speed	20 to 100	rpm

Injection Notes

Injection Pressure, Secondary: 60% of Initial