

Matrixx F663E13

Polyamide 66
The Matrixx Group, Inc.

Message:

Matrixx F663E13 is a polyamide 66 (nylon 66) material, which contains a 13% glass fiber reinforced material. This product is available in North America. The main characteristics of Matrixx F663E13 are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 13% filler by weight		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30 - 0.60	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	114	MPa	ASTM D638
Flexural Modulus - Tangent	4960	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	238	°C	ASTM D648
RTI	65.6	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 93.3	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	271 - 299	°C	
Middle Temperature	271 - 299	°C	
Front Temperature	271 - 299	°C	
Processing (Melt) Temp	277 - 299	°C	
Mold Temperature	65.6 - 93.3	°C	
Injection Rate	Moderate-Fast		
Back Pressure	< 0.345	MPa	
Cushion	6.35 - 12.7	mm	
Injection instructions			

Screw Speed: Slow to MediumDessicant dryer with -20°F dewpoint

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