

ECOMID® B BK 9005/1 - PA6

Description

(OMNILON® PA6 U BK1000)
Unfilled, Utility Grade, PA6

Physical properties	Value	Unit	Test Standard
Density	70.5	lb/ft ³	ISO 1183
Water absorption, 23°C-sat	9.3	%	Sim. to ISO 62
Humidity absorption, 23°C/50%RH	2.6	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	478625/203053	psi	ISO 527-1, -2
Tensile stress at yield, 50mm/min	10200/5800	psi	ISO 527-1, -2
Tensile strain at break, 50mm/min	16/>20	%	ISO 527-1, -2
Flexural modulus, 23°C	406000/-	psi	ISO 178
Flexural strength, 23°C	15200/-	psi	ISO 178
Charpy notched impact strength, 23°C	2.38/4.76	ft-lb/in ²	ISO 179/1eA

Typical injection molding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.15	%
Drying time	4 - 8	h
Drying temperature	176 - 194	°F

Temperature	Value	Unit
Zone1 temperature	428 - 446	°F
Zone2 temperature	437 - 455	°F
Zone3 temperature	455 - 473	°F
Zone4 temperature	473 - 491	°F
Nozzle temperature	491 - 518	°F
Melt temperature	482 - 518	°F
Mold temperature	140 - 176	°F
Hot runner temperature	491 - 518	°F

Characteristics

Special Characteristics Recycled content

Product Categories Unfilled

Processing Injection molding

Other Approvals

OEM	Specification	Additional Information
VW Group*	VW50134	* best fitting grade to PA6-1-A, not officially approved
VW Group*	VW50125	* best fitting grade to PA6-1, not officially approved

General Disclaimer

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