

## OMNILON® PA6/6 U GR33 HS BK1000 - PA66

| Physical properties | Value | Unit  | Test Standard |
|---------------------|-------|-------|---------------|
| Density             | 1390  | kg/m³ | ISO 1183      |

| Mechanical properties                | Value | Unit  | Test Standard |
|--------------------------------------|-------|-------|---------------|
| Tensile modulus                      | 12500 | MPa   | ISO 527-2/1A  |
| Tensile stress at break, 5mm/min     | 160   | MPa   | ISO 527-2/1A  |
| Tensile strain at break, 5mm/min     | 2.1   | %     | ISO 527-2/1A  |
| Flexural modulus, 23°C               | 10200 | MPa   | ISO 178       |
| Flexural strength, 23°C              | 255   | MPa   | ISO 178       |
| Charpy notched impact strength, 23°C | 9     | kJ/m² | ISO 179/1eA   |

## Typical injection moulding processing conditions

| Pre Drying                                      | Value     | Unit | Test Standard |
|-------------------------------------------------|-----------|------|---------------|
| Necessary low maximum residual moisture content | 0.15      | %    | -             |
| Drying time                                     | 4 - 8     | h    | -             |
| Drying temperature                              | 80 - 90   | °C   | -             |
| Temperature                                     | Value     | Unit | Test Standard |
| Zone1 temperature                               | 260 - 270 | °C   | -             |
| Zone2 temperature                               | 265 - 275 | °C   | -             |
| Zone3 temperature                               | 275 - 285 | °C   | -             |
| Zone4 temperature                               | 275 - 290 | °C   | -             |
| Nozzle temperature                              | 285 - 300 | °C   | -             |
| Melt temperature                                | 280 - 295 | °C   | -             |
| Mold temperature                                | 60 - 80   | °C   | -             |
| Hot runner temperature                          | 285 - 300 | °C   | -             |