

OMNILON® PA6 IM8 UV L - PA6

| Physical properties | Value | Unit | Test Standard |
|----------------------------|--------------|-------------------|----------------------|
| Density | 1090 | kg/m ³ | ISO 1183 |

| Mechanical properties | Value | Unit | Test Standard |
|-------------------------------|--------------|-------------|----------------------|
| Tensile stress at yield, 23°C | 63 | MPa | ASTM D 638 |
| Tensile strain at break, 23°C | 35 | % | ASTM D 638 |
| Flexural modulus, 23°C | 2270 | MPa | ASTM D 790 |
| Flexural stress, 23°C | 93 | MPa | ASTM D 790 |
| Izod impact notched, 23°C | 171 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|---------------------------|--------------|-------------|----------------------|
| DTUL at 1.8 MPa | 60 | °C | ISO 75-1, -2 |
| DTUL at 0.45 MPa | 171 | °C | ISO 75-1, -2 |

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 | 220 - 230 | °C | - |
| Zone2 temperature | 225 - 235 | °C | - |
| Zone3 temperature | 235 - 245 | °C | - |
| Zone4 temperature | 245 - 255 | °C | - |
| Nozzle temperature | 255 - 270 | °C | - |
| Melt temperature | 250 - 270 | °C | - |
| Mold temperature | 60 - 80 | °C | - |
| Hot runner temperature | 255 - 270 | °C | - |