

**OMNILON® PA6 U GR33 NA - PA6**

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1380</b>	kg/m <sup>3</sup>	ISO 1183
<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile modulus	<b>11500</b>	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	<b>200</b>	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	<b>3.6</b>	%	ISO 527-2/1A
Flexural modulus, 23°C	<b>9500</b>	MPa	ISO 178
Flexural strength, 23°C	<b>270</b>	MPa	ISO 178
Charpy notched impact strength, 23°C	<b>17.5</b>	kJ/m <sup>2</sup>	ISO 179/1eA
<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
DTUL at 1.8 MPa	<b>210</b>	°C	ISO 75-1, -2
DTUL at 0.45 MPa	<b>218</b>	°C	ISO 75-1, -2
<b>Typical injection moulding processing conditions</b>			
<b>Pre Drying</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Necessary low maximum residual moisture content	<b>0.15</b>	%	-
Drying time	<b>4 - 8</b>	h	-
Drying temperature	<b>80 - 90</b>	°C	-
<b>Temperature</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Zone1 temperature	<b>220 - 230</b>	°C	-
Zone2 temperature	<b>225 - 235</b>	°C	-
Zone3 temperature	<b>235 - 245</b>	°C	-
Zone4 temperature	<b>245 - 255</b>	°C	-
Nozzle temperature	<b>255 - 270</b>	°C	-
Melt temperature	<b>250 - 270</b>	°C	-
Mold temperature	<b>60 - 80</b>	°C	-
Hot runner temperature	<b>255 - 270</b>	°C	-