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**OMNILON® PA6/6 GR33 BK1000 - PA66**


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<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1390</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>12500</b>	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	<b>190</b>	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	<b>2.1</b>	%	ISO 527-2/1A
Charpy notched impact strength, 23°C	<b>9</b>	kJ/m <sup>2</sup>	ISO 179/1eA

**Typical injection moulding processing conditions**


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<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>260 - 270</b>	°C	-
Zone2 temperature	<b>265 - 275</b>	°C	-
Zone3 temperature	<b>275 - 285</b>	°C	-
Zone4 temperature	<b>275 - 290</b>	°C	-
Nozzle temperature	<b>285 - 300</b>	°C	-
Melt temperature	<b>280 - 295</b>	°C	-
Mold temperature	<b>60 - 80</b>	°C	-
Hot runner temperature	<b>285 - 300</b>	°C	-