

**OMNILON® PA6/6 GR7 IM4 - PA66**

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	1170	kg/m <sup>3</sup>	ISO 1183

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile stress at yield, 23°C	79	MPa	ASTM D 638
Tensile strain at break, 23°C	5	%	ASTM D 638
Flexural modulus, 23°C	2620	MPa	ASTM D 790
Flexural stress, 23°C	97	MPa	ASTM D 790
Izod impact notched, 23°C	107	J/m	ASTM D 256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
DTUL at 1.8 MPa	243	°C	ISO 75-1, -2
DTUL at 0.45 MPa	249	°C	ISO 75-1, -2

**Typical injection moulding processing conditions**

<b>Pre Drying</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Necessary low maximum residual moisture content	0.15	%	-
Drying time	4 - 8	h	-
Drying temperature	80 - 90	°C	-
<b>Temperature</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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	-