

OMNILON® PA6/6 U GR33 BK1000 - PA66

Physical properties	Value	Unit	Test Standard
Density	1390	kg/m ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	11500	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	160	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.9	%	ISO 527-2/1A
Flexural modulus, 23°C	10500	MPa	ISO 178
Flexural strength, 23°C	245	MPa	ISO 178
Charpy notched impact strength, 23°C	8	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	230	°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	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	-