

**OMNILON® PA6/6 U IM20 HS BK1000 - PA66**

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1080</b>	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	<b>48</b>	MPa	ASTM D 638
Tensile strain at break, 23°C	<b>40</b>	%	ASTM D 638
Flexural modulus, 23°C	<b>1660</b>	MPa	ASTM D 790
Flexural stress, 23°C	<b>62</b>	MPa	ASTM D 790
Izod impact notched, 23°C	<b>849</b>	J/m	ASTM D 256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
DTUL at 1.8 MPa	<b>71</b>	°C	ISO 75-1, -2
DTUL at 0.45 MPa	<b>216</b>	°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	<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	-