

OMNILON® PA6 GR23 IM6 BK1000 - PA6

Physical properties	Value	Unit	Test Standard
Density	1270	kg/m³	ISO 1183
Molding shrinkage, parallel	1.1	%	ISO 294-4, 2577
Molding shrinkage, normal	1.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
Tensile stress at yield, 23°C	128	MPa	ASTM D 638
Tensile strain at break, 23°C	3	%	ASTM D 638
Flexural modulus, 23°C	6200	MPa	ASTM D 790
Flexural stress, 23°C	193	MPa	ASTM D 790
Izod impact notched, 23°C	140	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	185	°C	ISO 75-1, -2
DTUL at 0.45 MPa	210	°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	220 - 230	°C	-
Zone2 temperature	225 - 235	°C	-
Zone3 temperature	235 - 245	°C	-
Zone4 temperature	245 - 255	°C	-
Nozzle temperature	255 - 270	°C	-
Melt temperature	250 - 270	°C	-
Mold temperature	60 - 80	°C	-
Hot runner temperature	255 - 270	°C	-

