Celanese
The chemistry inside innovation™

OMNILON® PA6/6 GR15 - PA66

Physical properties	Value	Unit	Test Standard
Density	**1250**	kg/m³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile stress at yield, 23°C	**119**	MPa	ASTM D 638
Tensile strain at break, 23°C	**3**	%	ASTM D 638
Flexural modulus, 23°C	**5380**	MPa	ASTM D 790
Flexural stress, 23°C	**172**	MPa	ASTM D 790
Izod impact notched, 23°C	**64**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	**243**	°C	ISO 75-1, -2
DTUL at 0.45 MPa	**260**	°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	-

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