

OMNILON® PA6/6 GR33 IM4 HSH - PA66

Physical properties	Value	Unit	Test Standard
Density	1360	kg/m³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile stress at yield, 23°C	155	MPa	ASTM D 638
Tensile strain at break, 23°C	3	%	ASTM D 638
Flexural modulus, 23°C	8620	MPa	ASTM D 790
Flexural stress, 23°C	214	MPa	ASTM D 790
Izod impact notched, 23°C	159	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	-

