

ECOMID® B GF33 BK 9005/1A - PA6

Description

(OMNILON® PA6 U GR33 BK1000)
33% Glass Reinforced, Utility Grade, PA6

Physical properties	Value	Unit	Test Standard
Density	86.8	lb/ft ³	ISO 1183
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	1.67E6	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	22500	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	2.1	%	ISO 527-1, -2
Flexural modulus, 23°C	1.57E6	psi	ISO 178
Flexural strength, 23°C	35500	psi	ISO 178
Charpy notched impact strength, 23°C	4.04	ft-lb/in ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	410	°F	ISO 75-1, -2
DTUL at 0.45 MPa	424	°F	ISO 75-1, -2

Typical injection molding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.15	%
Drying time	4 - 8	h
Drying temperature	176 - 194	°F
Temperature	Value	Unit
Zone1 temperature	428 - 446	°F
Zone2 temperature	437 - 455	°F
Zone3 temperature	455 - 473	°F
Zone4 temperature	473 - 491	°F
Nozzle temperature	491 - 518	°F
Melt temperature	482 - 518	°F
Mold temperature	140 - 176	°F
Hot runner temperature	491 - 518	°F

Characteristics

Special Characteristics	Recycled content
Product Categories	Glass reinforced
Processing	Injection molding