

## OMNILON® PA6 GR30 - PA6

| Physical properties                              | Value     | Unit  | Test Standard |
|--------------------------------------------------|-----------|-------|---------------|
| Density                                          | 1370      | kg/m³ | ISO 1183      |
| Mechanical properties                            | Value     | Unit  | Test Standard |
| Tensile stress at yield, 23°C                    | 173       | MPa   | ASTM D 638    |
| Tensile strain at break, 23°C                    | 3         | %     | ASTM D 638    |
| Flexural modulus, 23°C                           | 9660      | MPa   | ASTM D 790    |
| Flexural stress, 23°C                            | 269       | MPa   | ASTM D 790    |
| Izod impact notched, 23°C                        | 128       | J/m   | ASTM D 256    |
| Thermal properties                               | Value     | Unit  | Test Standard |
| DTUL at 1.8 MPa                                  | 210       | °C    | ISO 75-1, -2  |
| DTUL at 0.45 MPa                                 | 218       | °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    | -             |