

**OMNILON® PA6 GR55 UV BKC2000 - PA6**

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	1620	kg/m³	ISO 1183
<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile modulus	20000	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	215	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.8	%	ISO 527-2/1A
Flexural modulus, 23°C	19000	MPa	ISO 178
Flexural strength, 23°C	345	MPa	ISO 178
Charpy notched impact strength, 23°C	14.5	kJ/m²	ISO 179/1eA
<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
DTUL at 1.8 MPa	213	°C	ISO 75-1, -2
DTUL at 0.45 MPa	218	°C	ISO 75-1, -2

**Typical injection moulding processing conditions**

<b>Pre Drying</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Necessary low maximum residual moisture content	0.15	%	-
Drying time	4 - 8	h	-
Drying temperature	80 - 90	°C	-
<b>Temperature</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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	-