

ECOMID® A GF33 BK 9005/1A - PA66

Description

(OMNILON® PA6/6 U GR33 BK1000)
33% Glass Reinforced, Utility Grade, PA66

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	23900	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	2	%	ISO 527-1, -2
Flexural modulus, 23°C	1.62E6	psi	ISO 178
Flexural strength, 23°C	37700	psi	ISO 178
Charpy notched impact strength, 23°C	3.81	ft-lb/in ²	ISO 179/1eA
Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	446	°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	500 - 518	°F
Zone2 temperature	509 - 527	°F
Zone3 temperature	527 - 545	°F
Zone4 temperature	527 - 554	°F
Nozzle temperature	545 - 572	°F
Melt temperature	536 - 563	°F
Mold temperature	140 - 176	°F
Hot runner temperature	545 - 572	°F

Characteristics

Special Characteristics	Recycled content
Product Categories	Glass reinforced
Processing	Injection molding