



**OmniLon™**  
**PA6 U IM8 BK1000**  
 High Impact, Utility Grade, Nylon 6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.09	1.09
Filler/Reinforcement	%	D2584	-	-
<b>IMPACT</b>				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	3	159
Charpy Impact Resistance Notched 1/8" bar, 23°F	ft.-lbs/in <sup>2</sup> (kJ/m <sup>2</sup> )	ISO 1701e/A	3	6.3
Charpy Impact Resistance Notched 1/8" bar, -30°F	ft.-lbs/in <sup>2</sup> (kJ/m <sup>2</sup> )	ISO 1701e/A	1.2	2.5
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	9,000	62
Tensile Elongation	%	D638	30	30
Flexural Modulus	psi (MPa)	D790	340,000	2,346
Flexural Strength	psi (MPa)	D790	12,500	86
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	-	-
1/8" bar, 264 psi	°F (°C)	D648	140	60
<b>FLAMMABILITY</b>				
Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
<b>RECOMMENDED PROCESSING CONDITIONS</b>				
Drying Temperature			180° F	
Drying Time			2 to 4 Hours	
Maximum Moisture			0.20%	
Rear Zone(s)			460 to 540° F	
Middle Zone(s)			480 to 560° F	
Front Zone(s)			480 to 560° F	
Nozzle			500 to 560° F	
Mold Temperature			80 to 180° F	
Melt Temperature			480 to 560° F	
Back Pressure			50 psi	

Values are based on natural or black materials unless otherwise noted. Properties and values herein are based on laboratory test specimens and should not be used to establish minimum specification limits or fabricate tooling.

Omni does not guarantee the accuracy of this information or the suitability of this product in any given application or usage situation.