



OmniLon™

PA6 GR33

33% Glass Reinforced, Nylon 6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.38	1.38
Filler/Reinforcement	%	D5630	33	33
Mold Shrinkage, Linear	in/in		.001 to .004	
Mold Shrinkage, Transverse	in/in		.003 to .008	

IMPACT

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	2.2	117
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MECHANICAL

Tensile Strength At Yield, 73°F	psi (MPa)	D638	26,800	185
Tensile Elongation	%	D638	3	3
Flexural Modulus	psi (MPa)	D790	1,400,000	9,660
Flexural Strength	psi (MPa)	D790	42,000	290

THERMAL

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	425	218
1/8" bar, 264 psi	°F (°C)	D648	410	210

FLAMMABILITY

UL File Number E138590

Flame Resistance	.118" (3.0mm)	UL94	HB	HB
	.059" (1.5mm)	UL94	HB	HB

All Color Recognition

RECOMMENDED PROCESSING CONDITIONS

Drying Temperature	180° F
Drying Time	2 to 4 Hours
Maximum Moisture	0.20%
Rear Zone(s)	480 to 540° F
Middle Zone(s)	500 to 560° F
Front Zone(s)	500 to 560° F
Nozzle	500 to 560° F
Mold Temperature	80 to 180° F
Melt Temperature	500 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.