



**OmniLon™**  
**PA6 IM20**

Super High Impact Resistant, Nylon 6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.07	1.07
Mold Shrinkage, Isotropic	in/in		.012 to .022	
<b>IMPACT</b>				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	16	849
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	7,000	48
Tensile Elongation	%	D638	100	100
Flexural Modulus	psi (MPa)	D790	275,000	1,898
Flexural Strength	psi (MPa)	D790	10,000	69
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	-	-
1/8" bar, 264 psi	°F (°C)	D648	160	71
<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.