



OmniLon™
PA6 IM8
 Impact Modified, Nylon 6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.09	1.09
Mold Shrinkage, Isotropic	in/in		.012 - .020	
IMPACT				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	3.2	171
MECHANICAL				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	9,200	63
Tensile Elongation	%	D638	35	35
Flexural Modulus	psi (MPa)	D790	330,000	2,275
Flexural Strength	psi (MPa)	D790	13,500	93
THERMAL				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	340	171
1/8" bar, 264 psi	°F (°C)	D648	140	60
FLAMMABILITY				
Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
RECOMMENDED PROCESSING CONDITIONS				
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.