



**OmniLon™**  
**PA6 U BK1000**  
 Utility Grade, Nylon 6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.13	1.13
Mold Shrinkage, Isotropic	in/in		.012 to .020	
<b>IMPACT</b>				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	1	53
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	10,500	73
Tensile Modulus	psi (MPa)	D638	450,000	3,100
Tensile Elongation	%	D638	40	40
Flexural Modulus	psi (MPa)	D790	380,000	2,622
Flexural Strength	psi (MPa)	D790	15,500	107
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	350	177
1/8" bar, 264 psi	°F (°C)	D648	150	66
<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)			450 to 520° F	
Middle Zone(s)			460 to 520° F	
Front Zone(s)			460 to 520° F	
Nozzle			480 to 540° F	
Mold Temperature			80 to 180° F	
Melt Temperature			450 to 520° 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.