



**OmniLon™**  
**PA6 U GR13 BK1000**

13% Glass Reinforced, Utility Grade, Nylon 6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.22	1.22
Filler/Reinforcement	%	D5630	13	13
<b>IMPACT</b>				
Izod Impact Resistance Notched 1/8" bar, 73 °F	ft.-lbs/in. (J/m)	D256	1.2	64
Charpy Impact Resistance Notched, 23 °C	ft-lb/in <sup>2</sup> (kJ/m <sup>2</sup> )	ISO 179-1eA	2	4.2
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73 °F	psi (MPa)	D638	15,800	109
Tensile Elongation	%	D638	3	3
Tensile Strength At Break, 23 °C	psi (MPa)	ISO 527	16,500	114
Flexural Modulus	psi (MPa)	D790	650,000	4,485
Flexural Strength	psi (MPa)	D790	22,000	152
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	420	216
1/8" bar, 264 psi	°F (°C)	D648	380	193
<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 520 °F
Middle Zone(s)	460 to 520 °F
Front Zone(s)	480 to 540 °F
Nozzle	480 to 540 °F
Mold Temperature	80 to 140 °F
Melt Temperature	460 to 520 °F
Back Pressure	25 to 75 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.