



**OmniLon™**  
**PA6 U GR33 BK1000**

33% Glass Reinforced, Utility Grade, 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		.004 to .009	

**IMPACT**

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	2	107
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**MECHANICAL**

Tensile Strength, yld.	psi (MPa)	D638	21,800	150
Tensile Elongation	%	D638	3	3
Flexural Modulus	psi (MPa)	D790	1,400,000	9,660
Flexural Strength	psi (MPa)	D790	32,500	224

**THERMAL**

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

**FLAMMABILITY**

Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
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**RECOMMENDED PROCESSING CONDITIONS**

Drying Temperature	180° F
Drying Time	2 to 4 Hours
Maximum Moisture	0.20%
Rear Zone(s)	480 to 520° 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.