



Preliminary Product Data & Processing Guidelines

ISO 9001:2008 Certification

OmniLon™
PA6/12 GR33 HS

33% Glass Reinforced, Heat Stabilized, Nylon 6/12

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.31	1.31
Filler/Reinforcement	%	D5630	33	33
IMPACT				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	2.2	117
MECHANICAL				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	22,500	155
Tensile Elongation	%	D638	3	3
Flexural Modulus	psi (MPa)	D790	1,300,000	8,963
Flexural Strength	psi (MPa)	D790	35,000	242
THERMAL				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	400	204
1/8" bar, 264 psi	°F (°C)	D648	390	199
RECOMMENDED PROCESSING CONDITIONS				
Drying Temperature			175° F	
Drying Time			2 to 4 Hours	
Maximum Moisture			0.15%	
Rear Zone(s)			500 to 540° F	
Middle Zone(s)			520 to 560° F	
Front Zone(s)			520 to 560° F	
Nozzle			520 to 560° F	
Mold Temperature			120 to 220° F	
Melt Temperature			510 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.

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