



**OmniLon™**

**PA6/6 GR33 LM BK2000**

33% Glass Reinforced, Laser Markable, Pre-Colored Black, Nylon 6/6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.39	1.39
Filler/Reinforcement	%	D5630	33	33
Mold Shrinkage, Linear	in/in		.001 to .003	
Mold Shrinkage, Transverse	in/in		.004 to .008	
Water Absorption 24 hr	%	D570	1.2	

**IMPACT**

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	2	106
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**MECHANICAL**

Tensile Strength At Yield, 73°F	psi (MPa)	D638	26,500	183
Tensile Elongation	%	D638	3	3
Flexural Modulus	psi (MPa)	D790	1,500,000	10,350
Flexural Strength	psi (MPa)	D790	42,500	293

**THERMAL**

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	500	260
1/8" bar, 264 psi	°F (°C)	D648	480	249

**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)	520 to 560° F
Middle Zone(s)	520 to 560° F
Front Zone(s)	520 to 560° F
Nozzle	520 to 560° F
Mold Temperature	80 to 140° F
Melt Temperature	520 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.