



OmniLon™
PA6/6 HSL

Heat Stabilized, Internally Lubricated, Nylon 6/6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.14	1.14
Mold Shrinkage, Isotropic	in/in		.012 to .020	
IMPACT				
Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	1	53
MECHANICAL				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	11,700	81
Tensile Elongation	%	D638	12	12
Flexural Modulus	psi (MPa)	D790	430,000	2,965
Flexural Strength	psi (MPa)	D790	19,500	134
THERMAL				
Melting Point	°F (°C)	ISO 3146	500	260
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	400	204
1/8" bar, 264 psi	°F (°C)	D648	150	66
FLAMMABILITY				
Flame Resistance *Omni Internal Testing	.125"	UL94	V-2*	V-2*
RECOMMENDED PROCESSING CONDITIONS				

Drying Temperature	180° F
Drying Time	2 to 4 Hours
Maximum Moisture	0.20%
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	80 to 180° 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.