



**OmniLon™**

**PA6/6 IM20**

Super High Impact, Nylon 6/6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.08	1.08
Mold Shrinkage, Isotropic	in/in		.016 to .022	

**IMPACT**

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	18	955
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**MECHANICAL**

Tensile Strength At Yield, 73°F	psi (MPa)	D638	7,500	52
Tensile Elongation	%	D638	45	45
Flexural Modulus	psi (MPa)	D790	250,000	1,725
Flexural Strength	psi (MPa)	D790	9,500	66

**THERMAL**

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	420	216
1/8" bar, 264 psi	°F (°C)	D648	160	71

**FLAMMABILITY**

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

Drying Temperature	175° F
Drying Time	2 to 4 Hours
Maximum Moisture	0.20%
Rear Zone(s)	500 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.