



OmniLon™
PA6/6 IM4 FR0

Flame Resistant, Impact Modified, Nylon 6/6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.24	1.24
Filler/Reinforcement	%	D5630	-	-

IMPACT

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	1.5	80
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MECHANICAL

Tensile Strength At Yield, 73°F	psi (MPa)	D638	7,000	48
Tensile Elongation	%	D638	10	10
Flexural Modulus	psi (MPa)	D790	300,000	2,068
Flexural Strength	psi (MPa)	D790	9,000	62

THERMAL

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	440	227
1/8" bar, 264 psi	°F (°C)	D648	160	71

FLAMMABILITY

Flame Resistance *Omni Internal Testing	.125"	UL94	V-0*	V-0*
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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.