



OmniLon™
PA6/6 U GR33 HSL BK1000

33% Glass Reinforced, Heat Stabilized, Lubricated, Utility Grade, 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		.003 to .009	

IMPACT

Izod Impact Resistance Notched 1/8" bar, 73°F	ft.-lbs/in. (J/m)	D256	1.6	80
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MECHANICAL

Tensile Strength At Yield, 73°F	psi (MPa)	D638	22,500	155
Tensile Elongation	%	D638	3	3
Flexural Modulus	psi (MPa)	D790	1,400,000	9,660
Flexural Strength	psi (MPa)	D790	36,500	252

THERMAL

Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	495	257
1/8" bar, 264 psi	°F (°C)	D648	475	246

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 to 100 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.