



**OmniLon™**  
**PA6/6 U IM4 HS BK1000**

Impact Modified, Heat Stabilized, Utility Grade, Nylon 6/6

PHYSICAL	Units	ASTM/ISO Procedure	English	Metric
Specific Gravity		D792	1.10	1.10
<b>IMPACT</b>				
Izod Impact Resistance Notched, 73°F	ft.-lbs/in. (J/m)	D256	2	107
<b>MECHANICAL</b>				
Tensile Strength At Yield, 73°F	psi (MPa)	D638	11,000	76
Tensile Elongation	%	D638	20	20
Flexural Modulus	psi (MPa)	D790	410,000	2,827
Flexural Strength	psi (MPa)	D790	17,000	117
<b>THERMAL</b>				
Deflection Temperature 1/8" bar, 66 psi	°F (°C)	D648	440	227
1/8" bar, 264 psi	°F (°C)	D648	165	74
<b>FLAMMABILITY</b>				
Flame Resistance *Omni Internal Testing	.125"	UL94	HB*	HB*
<b>RECOMMENDED PROCESSING CONDITIONS</b>				
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.