

# OmniLon™ PA6/6 U GR33 HSL BK1000

Polyamide 66

OMNI Plastics, LLC

Message:

33% Glass Reinforced, Heat Stabilized, Lubricated, Utility Grade, Nylon 6/6

| General Information                 |                                  |                   |                 |
|-------------------------------------|----------------------------------|-------------------|-----------------|
| Filler / Reinforcement              | Glass Fiber,33% Filler by Weight |                   |                 |
| Additive                            | Heat Stabilizer                  |                   |                 |
|                                     | Lubricant                        |                   |                 |
| Features                            | Heat Stabilized                  |                   |                 |
|                                     | Lubricated                       |                   |                 |
| Processing Method                   | Injection Molding                |                   |                 |
| Physical                            | Nominal Value                    | Unit              | Test Method     |
| Specific Gravity                    | 1.39                             | g/cm <sup>3</sup> | ASTM D792       |
| Molding Shrinkage                   |                                  |                   | ASTM D955       |
| Flow                                | 0.10 to 0.30                     | %                 |                 |
| Across Flow                         | 0.30 to 0.80                     | %                 |                 |
| Mechanical                          | Nominal Value                    | Unit              | Test Method     |
| Tensile Strength (Yield, 23°C)      | 155                              | MPa               | ASTM D638       |
| Tensile Elongation (Break)          | 3.0                              | %                 | ASTM D638       |
| Flexural Modulus                    | 9650                             | MPa               | ASTM D790       |
| Flexural Strength                   | 252                              | MPa               | ASTM D790       |
| Impact                              | Nominal Value                    | Unit              | Test Method     |
| Notched Izod Impact (23°C, 3.18 mm) | 80                               | J/m               | ASTM D256       |
| Thermal                             | Nominal Value                    | Unit              | Test Method     |
| Deflection Temperature Under Load   |                                  |                   | ASTM D648       |
| 0.45 MPa, Unannealed, 3.18 mm       | 257                              | °C                |                 |
| 1.8 MPa, Unannealed, 3.18 mm        | 246                              | °C                |                 |
| Flammability                        | Nominal Value                    |                   | Test Method     |
| Flame Rating (3.18 mm)              | HB                               |                   | Internal Method |
| Injection                           | Nominal Value                    | Unit              |                 |
| Drying Temperature                  | 82.2                             | °C                |                 |
| Drying Time                         | 2.0 to 4.0                       | hr                |                 |
| Suggested Max Moisture              | 0.20                             | %                 |                 |
| Rear Temperature                    | 271 to 293                       | °C                |                 |
| Middle Temperature                  | 271 to 293                       | °C                |                 |
| Front Temperature                   | 271 to 293                       | °C                |                 |

|                        |                |     |
|------------------------|----------------|-----|
| Nozzle Temperature     | 271 to 293     | °C  |
| Processing (Melt) Temp | 271 to 293     | °C  |
| Mold Temperature       | 26.7 to 60.0   | °C  |
| Back Pressure          | 0.345 to 0.689 | MPa |

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519  
Phone: +86 13424755533  
Email: sales@su-jiao.com  
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

