



# Bergamid™ A70 TM-Z BK705

## Polyamide 66

### Key Characteristics

| Product Description   |                      |
|-----------------------|----------------------|
| Impact modified       |                      |
| General               |                      |
| Material Status       | • Commercial: Active |
| Regional Availability | • Asia Pacific       |
| Additive              | • Impact Modifier    |
| Features              | • Impact Modified    |
| Appearance            | • Black              |
| Processing Method     | • Injection Molding  |

### Technical Properties <sup>1</sup>

| Physical                                          | Typical Value (English) | Typical Value (SI) | Test Method |
|---------------------------------------------------|-------------------------|--------------------|-------------|
| Specific Gravity                                  | 1.10                    | 1.10               | ASTM D792   |
| Molding Shrinkage - Flow                          | 0.016 to 0.020 in/in    | 1.6 to 2.0 %       | ASTM D955   |
| Mechanical                                        | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength <sup>2</sup>                     | 8700 psi                | 60.0 MPa           | ASTM D638   |
| Flexural Modulus <sup>3</sup>                     | 290000 psi              | 2000 MPa           | ASTM D790   |
| Flexural Strength <sup>3</sup>                    | 13100 psi               | 90.0 MPa           | ASTM D790   |
| Impact                                            | Typical Value (English) | Typical Value (SI) | Test Method |
| Notched Izod Impact                               |                         |                    | ASTM D256   |
| 73°F (23°C), 0.126 in (3.20 mm)                   | 11 ft-lb/in             | 600 J/m            |             |
| Thermal                                           | Typical Value (English) | Typical Value (SI) | Test Method |
| Deflection Temperature Under Load                 |                         |                    | ASTM D648   |
| 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm) | 140 °F                  | 60.0 °C            |             |

### Processing Information

| Injection          | Typical Value (English) | Typical Value (SI) |
|--------------------|-------------------------|--------------------|
| Drying Temperature | 176 to 194 °F           | 80.0 to 90.0 °C    |
| Drying Time        | 4.0 to 6.0 hr           | 4.0 to 6.0 hr      |
| Rear Temperature   | 500 to 536 °F           | 260 to 280 °C      |
| Middle Temperature | 500 to 536 °F           | 260 to 280 °C      |
| Front Temperature  | 500 to 536 °F           | 260 to 280 °C      |
| Mold Temperature   | 149 to 185 °F           | 65.0 to 85.0 °C    |

| Injection Notes              |
|------------------------------|
| Injection Pressure: MED-HIGH |
| Hold Pressure: MED-HIGH      |
| Screw Speed: MODERATE        |
| Back Pressure: LOW           |

### Notes

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 2.0 in/min (50 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)

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