



# Bergamid™ B70 G30 GR248

## Polyamide 6

### Key Characteristics

| Product Description                 |                                     |
|-------------------------------------|-------------------------------------|
| Glass fiber reinforced PA6 compound |                                     |
| General                             |                                     |
| Material Status                     | • Commercial: Active                |
| Regional Availability               | • Asia Pacific                      |
| Filler / Reinforcement              | • Glass Fiber, 30% Filler by Weight |
| Appearance                          | • Grey                              |
| Processing Method                   | • Injection Molding                 |

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

| Physical                                          | Typical Value (English) | Typical Value (SI) | Test Method     |
|---------------------------------------------------|-------------------------|--------------------|-----------------|
| Specific Gravity                                  | 1.36                    | 1.36               | ASTM D792       |
| Molding Shrinkage                                 | 0.30 to 0.60 %          | 0.30 to 0.60 %     | ASTM D955       |
| Mechanical                                        | Typical Value (English) | Typical Value (SI) | Test Method     |
| Tensile Strength <sup>2</sup>                     | 21000 psi               | 145 MPa            | ASTM D638       |
| Flexural Modulus <sup>3</sup>                     | 1.23E+6 psi             | 8500 MPa           | ASTM D790       |
| Flexural Strength <sup>3</sup>                    | 37700 psi               | 260 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)                   | 1.7 ft-lb/in            | 90 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) | 410 °F                  | 210 °C             |                 |
| Electrical                                        | Typical Value (English) | Typical Value (SI) | Test Method     |
| Surface Resistivity                               | > 1.0E+12 ohms          | > 1.0E+12 ohms     | ASTM D257       |
| Flammability                                      | Typical Value (English) | Typical Value (SI) | Test Method     |
| Flame Rating (0.06 in (1.6 mm))                   | HB                      | HB                 | Internal Method |

### 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      |
| Processing (Melt) Temp       | 464 to 536 °F           | 240 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           |                         |                    |

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## Notes

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

<sup>2</sup> 0.20 in/min (5.0 mm/min)

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

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