Bergamid™ A70 Black FD

Polyamide 66

Key Characteristics

Product Description		
PA66 Compound		
General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	• Europe
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.14	1.14	ASTM D792
Molding Shrinkage - Flow [2]			ISO 294-4
73°F (23°C), 0.157 in (4.00 mm)	1.7 to 2.3 %	1.7 to 2.3 %	
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Modulus	616000 psi	4250 MPa	ISO 527-2
Tensile Stress (Break)	12800 psi	88.0 MPa	ISO 527-2
Tensile Strain (Break)	> 10 %	> 10 %	ISO 527-2
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179
-22°F (-30°C)	1.1 ft·lb/in²	2.4 kJ/m²	
73°F (23°C)	2.4 ft·lb/in²	5.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Notched Izod Impact (0.126 in (3.20 mm))	0.75 ft·lb/in	40 J/m	ASTM D256

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 194 °F	80 to 90 °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 to 85 °C

Injection Notes

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

Notes

[1] Typical values are not to be construed as specifications.

[2] PolyOne Method