



Bergamid™ A70 G15 H BK013

Polyamide 66

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.24	1.24	ASTM D792
Molding Shrinkage - Flow	6.0E-3 to 0.010 in/in	0.60 to 1.0 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	18100 psi	125 MPa	ASTM D638
Flexural Modulus ³	725000 psi	5000 MPa	ASTM D790
Flexural Strength ³	26100 psi	180 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm)	0.84 ft·lb/in	45 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	446 °F	230 °C	ASTM D648

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 0.20 in/min (5.0 mm/min)

³ 0.051 in/min (1.3 mm/min)