



Bergamid™ B70 G10 H BK702

Polyamide 6

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20	ASTM D792
Molding Shrinkage	0.90 to 1.2 %	0.90 to 1.2 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	14500 psi	100 MPa	ASTM D638
Flexural Modulus ³	580000 psi	4000 MPa	ASTM D790
Flexural Strength ³	21800 psi	150 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)	0.94 ft·lb/in	50 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)	356 °F	180 °C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+14 ohms	1.0E+14 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 212 °F	80 to 100 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	428 to 518 °F	220 to 270 °C
Middle Temperature	428 to 518 °F	220 to 270 °C
Front Temperature	428 to 518 °F	220 to 270 °C
Mold Temperature	140 to 176 °F	60 to 80 °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)