Bergamid™ B70 Mi40 P Natural

Polyamide 6

Key Characteristics

Product Description			
Impact modified			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East	• Asia Pacific	• Europe
Filler / Reinforcement	• Mineral, 40% Filler by Weight		
Additive	• Impact Modifier		
Features	• Impact Modified		
Appearance	• Natural Color		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.32	1.32	ASTM D792
Density	1.33 g/cm³	1.33 g/cm³	ISO 1183
Molding Shrinkage - Flow	5.0E-3 to 0.010 in/in	0.50 to 1.0 %	ASTM D955
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Modulus	696000 psi	4800 MPa	ISO 527-2
Tensile Strength [2]	5800 psi	40.0 MPa	ASTM D638
Tensile Stress	7250 psi	50.0 MPa	ISO 527-2
Tensile Strain (Break)	> 4.0 %	> 4.0 %	ISO 527-2
Flexural Modulus [3]	725000 psi	5000 MPa	ASTM D790
Flexural Modulus	696000 psi	4800 MPa	ISO 178
Flexural Strength [3]	18100 psi	125 MPa	ASTM D790
Flexural Stress	12300 psi	85.0 MPa	ISO 178
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Charpy Notched Impact Strength (73°F (23°C))	1.7 ft·lb/in²	3.5 kJ/m²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
73°F (23°C)	31 ft·lb/in²	65 kJ/m²	
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	0.75 ft·lb/in	40 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)	167 °F	75.0 °C	
Electrical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating (0.06 in (1.6 mm))	HB	HB	UL 94

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 212 °F	80 to 100 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	446 to 518 °F	230 to 270 °C
Middle Temperature	446 to 518 °F	230 to 270 °C
Front Temperature	446 to 518 °F	230 to 270 °C
Mold Temperature	158 to 194 °F	70 to 90 °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)