



Bergamid™ BG6000-8039 RS BK001

Polyamide 6

Key Characteristics

Product Description

Glass Beads Reinforced PA6 Compound

General

Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Bead, 30% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.35	1.35	ASTM D792
Molding Shrinkage	0.50 to 0.90 %	0.50 to 0.90 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	10200 psi	70.0 MPa	ASTM D638
Flexural Modulus ³	508000 psi	3500 MPa	ASTM D790
Flexural Strength ³	14500 psi	100 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)	0.75 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)	158 °F	70.0 °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	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	464 to 536 °F	240 to 280 °C
Middle Temperature	464 to 536 °F	240 to 280 °C
Front Temperature	464 to 536 °F	240 to 280 °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)