Bergamid™ PA6-GL30 BK356

Polyamide 6

Key Characteristics

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

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Ash Content	30 %	30 %	ISO 3451
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress			ISO 527-2/5
Break, 73°F (23°C), 0.157 in (4.00 mm)	22500 psi	155 MPa	
Flexural Stress	34100 psi	235 MPa	ISO 178
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Charpy Notched Impact Strength [2] (73°F (23°C))	4.8 ft·lb/in²	10 kJ/m²	DIN 53453
Charpy Unnotched Impact Strength [2]			DIN 53453
73°F (23°C)	21 ft·lb/in²	45 kJ/m²	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Ball Indentation Hardness	27600 psi	190 MPa	ISO 2039-1
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)	401 °F	205 °C	

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	464 to 518 °F	240 to 270 °C
Middle Temperature	464 to 518 °F	240 to 270 °C
Front Temperature	482 to 536 °F	250 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] specimen size:50*6*4(mm)