



## Bergamid™ PA6-MW30 GR002

### Polyamide 6

#### Key Characteristics

| Product Description                                 |                                                |
|-----------------------------------------------------|------------------------------------------------|
| Glass fiber and glass beads reinforced PA6 compound |                                                |
| General                                             |                                                |
| Material Status                                     | • Commercial: Active                           |
| Regional Availability                               | • Asia Pacific                                 |
| Filler / Reinforcement                              | • Glass Bead\Glass Fiber, 30% Filler by Weight |
| Appearance                                          | • Green                                        |
| Processing Method                                   | • Injection Molding                            |

#### Technical Properties <sup>1</sup>

| Physical                                                                               | Typical Value (English) | Typical Value (SI) | Test Method     |
|----------------------------------------------------------------------------------------|-------------------------|--------------------|-----------------|
| Density / Specific Gravity                                                             | 1.41                    | 1.41               | ASTM D792       |
| Molding Shrinkage                                                                      | 0.20 to 0.60 %          | 0.20 to 0.60 %     | ASTM D955       |
| Ash Content                                                                            | 32.0 to 38.0 %          | 32.0 to 38.0 %     | Internal Method |
| Moisture                                                                               | 0.19 %                  | 0.19 %             | Internal Method |
| Mechanical                                                                             | Typical Value (English) | Typical Value (SI) | Test Method     |
| Tensile Strength <sup>2</sup>                                                          | 16700 psi               | 115 MPa            | ASTM D638       |
| Flexural Modulus <sup>3</sup>                                                          | 943000 psi              | 6500 MPa           | ASTM D790       |
| Flexural Strength <sup>3</sup>                                                         | 26100 psi               | 180 MPa            | ASTM D790       |
| Impact                                                                                 | Typical Value (English) | Typical Value (SI) | Test Method     |
| Notched Izod Impact<br>73°F (23°C), 0.126 in (3.20 mm)                                 | 1.5 ft-lb/in            | 80 J/m             | ASTM D256       |
| Thermal                                                                                | Typical Value (English) | Typical Value (SI) | Test Method     |
| Deflection Temperature Under Load<br>264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm) | 356 °F                  | 180 °C             | ASTM D648       |
| Electrical                                                                             | Typical Value (English) | Typical Value (SI) | Test Method     |
| Surface Resistivity                                                                    | > 1.0E+12 ohms          | > 1.0E+12 ohms     | ASTM D257       |
| Flammability                                                                           | Typical Value (English) | Typical Value (SI) | Test Method     |
| Flame Rating (0.13 in (3.2 mm))                                                        | HB                      | HB                 | Internal Method |

#### Processing Information

| Injection              | Typical Value (English) | Typical Value (SI) |
|------------------------|-------------------------|--------------------|
| Drying Temperature     | 176 to 194 °F           | 80 to 90 °C        |
| Drying Time            | 2.0 to 4.0 hr           | 2.0 to 4.0 hr      |
| Processing (Melt) Temp | 464 to 536 °F           | 240 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**

<sup>1</sup> Typical values are not to be construed as specifications.

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<sup>2</sup> 0.20 in/min (5.0 mm/min)

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<sup>3</sup> 0.051 in/min (1.3 mm/min)