



Bergamid™ NI-15GF/000 FR GR002

Polyamide 610

Key Characteristics

Product Description	
Glass fiber reinforced, flame retardant PA610 compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Features	• Flame Retardant
Appearance	• Grey
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.49	1.49	ASTM D792
Molding Shrinkage	0.40 to 0.70 %	0.40 to 0.70 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	13800 psi	95.0 MPa	ASTM D638
Flexural Modulus ³	798000 psi	5500 MPa	ASTM D790
Flexural Strength ³	20300 psi	140 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)	1.1 ft-lb/in	60 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)	383 °F	195 °C	
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 (0.0630 in (1.60 mm))	V-0	V-0	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 194 °F	80.0 to 90.0 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	149 to 185 °F	65.0 to 85.0 °C

Injection Notes

Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

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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)

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