



## Bergamid™ B70 G15 Natural 70

### Polyamide 6

#### Key Characteristics

General			
Material Status	• Commercial: Active		
Regional Availability	• Europe		
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Features	• Good Hardness • Good Impact Resistance	• Good Processability • Good Stiffness	• Good Strength • Medium Viscosity
Uses	• Appliances • Automotive Applications	• Consumer Applications • General Purpose	• Industrial Applications
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.22 g/cm <sup>3</sup>	1.22 g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			Internal Method
Across Flow	0.90 to 1.2 %	0.90 to 1.2 %	
Flow	0.40 to 0.70 %	0.40 to 0.70 %	
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus	798000 psi	5500 MPa	ISO 527-2/1
Tensile Stress	17400 psi	120 MPa	ISO 527-2/5
Tensile Strain (Break)	3.5 %	3.5 %	ISO 527-2/5
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact Strength	2.9 ft·lb/in <sup>2</sup>	6.0 kJ/m <sup>2</sup>	ISO 180/A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Heat Deflection Temperature			ISO 75-2/A
264 psi (1.8 MPa), Unannealed	383 °F	195 °C	
Vicat Softening Temperature	419 °F	215 °C	ISO 306 <sup>2</sup>
Melting Temperature (DSC)	428 to 437 °F	220 to 225 °C	ISO 3146
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 °F	80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	446 to 464 °F	230 to 240 °C
Middle Temperature	455 to 473 °F	235 to 245 °C
Front Temperature	464 to 482 °F	240 to 250 °C
Nozzle Temperature	482 to 500 °F	250 to 260 °C
Mold Temperature	176 °F	80 °C

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## Notes

<sup>1</sup> Typical values are not to be construed as specifications.<sup>2</sup> 120°C/h, A (10N)

## CONTACT INFORMATION

## Americas

United States - Avon Lake  
+1 440 930 1000United States - McHenry  
+1 815 385 8500

## Asia

China - Guangzhou  
+86 20 8732 7260China - Shenzhen  
+86 755 2969 2888China - Suzhou  
+86 512 6823 24 38China - Suzhou  
+86 512 6265 2600Hong Kong -  
+852 2690 5332Taiwan - Yonghe City,  
+886 9396 99740, +886 2929 1849

## Europe

Germany - Gaggenau  
+49 7225 6802 0Spain - Barbastro (Huesca)  
+34 974 310 314*Beyond Polymers.**Better Business Solutions.™*

www.polyone.com

## PolyOne Americas

33587 Walker Road  
Avon Lake, Ohio 44012  
United States  
+1 440 930 1000  
+1 866 POLYONE

## PolyOne Asia

No. 88 Guoshoujing Road  
Z.J Hi-tech Park, Pudong  
Shanghai, 201203, China  
+86 21 5080 1188

## PolyOne Europe

6 Giällewee  
+352 269 050 35

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