



Bergamid™ B70 G33 H Natural

Polyamide 6

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• Europe
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Features	• Good Stiffness • Heat Stabilized • Good Strength • High Impact Resistance
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.37 g/cm ³	1.37 g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow	1.0 to 1.2 %	1.0 to 1.2 %	
Flow	0.20 to 0.40 %	0.20 to 0.40 %	
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus	1.41E+6 psi	9750 MPa	ISO 527-2/1
Tensile Stress	23200 psi	160 MPa	ISO 527-2/5
Tensile Strain (Break)	3.0 %	3.0 %	ISO 527-2/5
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact Strength	6.7 ft-lb/in ²	14 kJ/m ²	ISO 180/A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Heat Deflection Temperature 66 psi (0.45 MPa), Unannealed	421 °F	216 °C	ISO 75-2/B
Heat Deflection Temperature 264 psi (1.8 MPa), Unannealed	381 °F	194 °C	ISO 75-2/A
Vicat Softening Temperature	414 °F	212 °C	ISO 306

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
Rear Temperature	455 to 473 °F	235 to 245 °C
Middle Temperature	464 to 482 °F	240 to 250 °C
Front Temperature	473 to 491 °F	245 to 255 °C
Nozzle Temperature	482 to 500 °F	250 to 260 °C
Mold Temperature	149 to 185 °F	65 to 85 °C

Notes

¹ Typical values are not to be construed as specifications.

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