

Bergamid™ BG6000-8031 HI BK001

Polyamide 6

PolyOne Corporation

Message:

PA6 Compound with Impact Modified.

General Information			
Additive	Impact modifier		
Features	Impact modification		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage	1.2 - 1.6	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	60.0	MPa	ASTM D638
Flexural Modulus ²	2050	MPa	ASTM D790
Flexural Strength ³	70.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	65.0	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	240 - 280	°C	
Middle Temperature	240 - 280	°C	
Front Temperature	240 - 280	°C	
Mold Temperature	65.0 - 85.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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