

# Bergamid™ B70 G25 BK034

Polyamide 6

PolyOne Corporation

Message:

Glass fiber reinforced PA6 compound

| General Information                                                                        |                                                       |                   |                 |
|--------------------------------------------------------------------------------------------|-------------------------------------------------------|-------------------|-----------------|
| Filler / Reinforcement                                                                     | Glass fiber reinforced material, 25% filler by weight |                   |                 |
| Appearance                                                                                 | Black                                                 |                   |                 |
| Processing Method                                                                          | Injection molding                                     |                   |                 |
| Physical                                                                                   | Nominal Value                                         | Unit              | Test Method     |
| Specific Gravity                                                                           | 1.32                                                  | g/cm <sup>3</sup> | ASTM D792       |
| Molding Shrinkage                                                                          | 0.30 - 0.80                                           | %                 | ASTM D955       |
| Mechanical                                                                                 | Nominal Value                                         | Unit              | Test Method     |
| Tensile Strength <sup>1</sup>                                                              | 150                                                   | MPa               | ASTM D638       |
| Flexural Modulus <sup>2</sup>                                                              | 7200                                                  | MPa               | ASTM D790       |
| Flexural Strength <sup>3</sup>                                                             | 230                                                   | MPa               | ASTM D790       |
| Impact                                                                                     | Nominal Value                                         | Unit              | Test Method     |
| Notched Izod Impact                                                                        | 130                                                   | J/m               | ASTM D256       |
| Thermal                                                                                    | Nominal Value                                         | Unit              | Test Method     |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)                           | 200                                                   | °C                | ASTM D648       |
| Electrical                                                                                 | Nominal Value                                         | Unit              | Test Method     |
| Surface Resistivity                                                                        | > 1.0E+12                                             | ohms              | ASTM D257       |
| Flammability                                                                               | Nominal Value                                         | Unit              | Test Method     |
| Flame Rating (3.20 mm)                                                                     | HB                                                    |                   | Internal method |
| Injection                                                                                  | Nominal Value                                         | Unit              |                 |
| Drying Temperature                                                                         | 80.0 - 90.0                                           | °C                |                 |
| Drying Time                                                                                | 2.0 - 4.0                                             | hr                |                 |
| Processing (Melt) Temp                                                                     | 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.                                                                                         | 5.0 mm/min                                            |                   |                 |
| 2.                                                                                         | 1.3 mm/min                                            |                   |                 |
| 3.                                                                                         | 1.3 mm/min                                            |                   |                 |

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