

Bergamid™ NI-15GF/000 FR GR002

Polyamide 610
PolyOne Corporation

Message:
Glass fiber reinforced, flame retardant PA610 compound

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Features	Flame retardancy		
Appearance	Grey		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage	0.40 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	95.0	MPa	ASTM D638
Flexural Modulus ²	5500	MPa	ASTM D790
Flexural Strength ³	140	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	60	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	195	°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 (1.60 mm)	V-0		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	260 - 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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