

Bergamid™ B70 TM-Y BK138

Polyamide 6

PolyOne Corporation

Message:

Impact modified, High heat resistance

General Information			
Additive	Impact modifier		
Features	Impact modification		
	Heat resistance, high		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow	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)	350	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		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	4.0	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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