Bergamid™ BG6000-8038 RS HS BK001

Polyamide 6

PolyOne Corporation

Message:

Glass Fiber Reinforced PA6 Compound with Heat Stabilized.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight		
Features	Heat resistance, medium		
Appearance	Black		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.57	g/cm³	ASTM D792
Molding Shrinkage	0.10 - 0.50	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1]	195	MPa	ASTM D638
Flexural Modulus [2]	13500	MPa	ASTM D790
Flexural Strength [3]	300	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.20 mm)	170	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	215	°C	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	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.	5.0 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China