

Bergamid™ XP6042701

Polyamide 6
PolyOne Corporation

Message:

Bergamid™XP6042701 is a polyamide 6 (nylon 6) product, which contains fillers of 30% glass fiber reinforced materials and 10% carbon fiber reinforced materials. It can be processed by injection molding and is available in the Asia-Pacific region. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
	Carbon fiber reinforced material, 10% filler by weight		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	165	MPa	ASTM D638
Flexural Modulus	9000	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	90.0	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	215	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+9	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm, ALL)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	100 - 110	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	230 - 240	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	240 - 260	°C	
Mold Temperature	70.0 - 90.0	°C	
Injection Pressure	100 - 150	MPa	
Holding Pressure	50.0 - 80.0	MPa	
Back Pressure	0.300 - 0.500	MPa	
Screw Speed	80 - 160	rpm	
Injection instructions			

Injection Speed: 50 to 80% Holding Time: 3 to 9 sec Injection Time: 1 to 3.5 sec Cycle Time: 18 to 60 sec

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