

Bergamid™ B70 TM-Z NC237

Polyamide 6

PolyOne Corporation

Message:

Impact modified PA6 compound

General Information			
Features	Impact modification		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Molding Shrinkage	1.2 - 1.6	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	45.0	MPa	ASTM D638
Flexural Modulus ²	1500	MPa	ASTM D790
Flexural Strength ³	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	45.0	°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-HIGH Hold Pressure: MED-HIGH Screw Speed: MODERATE Back Pressure: LOW

NOTE

1.	5.0 mm/min
2.	1.3 mm/min
3.	1.3 mm/min

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