PRODUCT INFORMATION

TAROLOX 200 G6

PBT/ASA alloy 30% glass fibres reinforced. Good flow, excellent surface aspect, good combination of mechanical and thermal properties, good dimensional stability.

ISO short ISO 1043: PBT+ASA-GF30
Form Pellets

Key Features

- Designed for injection moulding applications
- Glass fibres reinforced
- Good flowability
- Good dimensional stability

Availability

- W: lubricated
- H: heat stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Consumer
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	500		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,43		
Filler content	ISO 3451	%	30	750°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Water Absorption at Saturation	ISO 62	%	0,2		
Mould Shrinkage (Parallel)	Internal method	%	0,2-0,4		
Mould Shrinkage (Normal)	Internal method	%	0,3-0,5		
Melting temperature (DSC)	ISO 11357	°C	220		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	5	250°C - 2,16 kg	

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	9300	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	2,5	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	130	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	8200	Speed 1 mm/min
Flexural Break Strength	ISO 178	MPa	180	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	75	+23°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	7,0	

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	150	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	180	120°C / h
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	1 x 10(-4)	Transversal
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	2,5 x 10(-5)	Parallel

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	650	
Oxigen index	ASTM D2863	%	20	

INJECTION MOULDING	Value
Drying Temperature (Circulating Air Oven)	80 - 120°C
Drying Temperature (Desiccant Dryer)	80 - 120°C
Drying Time (Circulating Air Oven)	3 - 6 h
Drying Time (Desiccant Dryer)	2 - 4 h
Suggested Max Moisture	< 0,04%
Suggested Max Regrind	< 20%
Melt Temperature	250 - 270°C
Feed Temperature	60°C
Rear Temperature	235°C
Middle Temperature	245°C
Front Temperature	255°C

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design. Values are valid for natural coloured version only.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.

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Nozzle Temperature	260°C
Mould Temperature	60 - 100°C
Injection Rate	Medium to Fast
Injection Pressure	40 - 100 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	0,5 - 1 Mpa
Screw Revolving Speed	70 rpm @ Diameter 60 mm
Screw Revolving Speed	95 rpm @ Diameter 45 mm
Screw Revolving Speed	140 rpm @ Diameter 30 mm
Screw Revolving Speed	220 rpm @ Diameter 20 mm
Screw Revolving Speed	300 rpm @ Diameter 15 mm
Cushion	2 - 6 mm
Screw L/D Ratio	18 - 22
Screw Compression Ratio	2:1 - 2,5:1
Vent Depth	0,02 mm

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.