PRODUCT INFORMATION

TAROMID A 260 S

Polyamide 66/6 medium viscosity, good processing and easy release, low post shrinkage and better dimensional stability, fast cycles, high rigidity.

ISO short ISO 1043: PA66
Form Pellets

Key Features

- Unfilled
- Containing nucleating agents for fast injection cycles time
- Designed for injection moulding applications
- Good flowability

Availability

- FA: food approval
- DB: dry blend coloured

Process

- INJECTION MOULDING

Application

- General purpose applications

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	9x10exp(15)		
Dielectric Strength	IEC 60243-1	kV/mm	3,40	2 mm	
Dissipation Factor Frequency	IEC 60250	-	0,015		
Dielectric Constant	IEC 60250	-	24		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	> 600		
Tracking Resistance (CTI - Method B)	IEC 60112	Volt	600M		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,13-1,14		
Granule Humidity	Internal method	%	< 0,15		
Water Absorption (24h / +23°C)	ISO 62	%	1,2		
Water Absorption at Saturation	ISO 62	%	7,4		
Mould Shrinkage (Parallel)	Internal method	%	1,6-2,1		
Mould Shrinkage (Normal)	Internal method	%	1,6-2,3		

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Melting temperature (DSC)	ISO 11357	°C	256		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	30	280°C - 1 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	1000	Speed 1 mm/min	Cond.
Tensile Modulus	ISO 527-1,2	MPa	3200	Speed 1 mm/min	Dry
Tensile Yield Strength	ISO 527-1,2	MPa	48	Speed 50 mm/min	Cond.
Tensile Yield Strength	ISO 527-1,2	MPa	82	Speed 50 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	> 50	Speed 50 mm/min	Cond.
Elongation at Break	ISO 527-1,2	%	30	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	80	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	1100	Speed 1 mm/min	Cond.
Flexural Modulus	ISO 178	MPa	3100	Speed 1 mm/min	Dry
Flexural Yield Strength	ISO 178	MPa	120	Speed 1 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	105		Cond.
IZOD Notched Impact (+23°C)	ASTM D256	J/m	40		Dry
IZOD Notched Impact (-25°C)	ASTM D256	J/m	30		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	24		Cond.
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	3,8		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	N.B.		Cond.
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	N.B.		Dry
THERMAL					
Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	248	50°C / h	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	235	50°C / h	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	85	120°C / h	
Ball Pressure Test	IEC 60695-10-2	°C	205		
Continuous service temperature (20.000 h)	UL746 B	°C	90		
Continuous service temperature (short term)	UL746 B	°C	120		

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Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	8x10exp(-5)	-30°C /+30°C

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	V2	
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	750	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	< 80	Thickness > 1,5 mm
Oxigen index	ASTM D2863	%	24	

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,08 %
Suggested Max Regrind	< 15 %
Melt Temperature	260 - 280°C
Feed Temperature	220°C
Rear Temperature	260°C
Middle Temperature	270°C
Front Temperature	275°C
Nozzle Temperature	270°C
Mould Temperature	70 - 90°C
Injection Rate	Medium
Packing Pressure	30 - 80 Mpa
Back Pressure	As low as possible (0,3 - 0,6 Mpa)
Screw Revolving Speed	50 - 100 rpm
Cushion	3 - 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.