



PRODUCT INFORMATION

TAROMID A 260 Y0

PA66/6 medium viscosity, halogen free flame retardant UL94 V0.
Low density, good flow and high tracking resistance.

ISO short ISO 1043: PA66 FR(30)
Form Pellets
UL file E143048

Key Features

- Halogen free
- Flame retardant
- Good flowability
- Low density
- Antimony trioxide free

Availability

- W: lubricated
- S: fast injection cycles
- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- All colours

Compliance

- UL94 V0 approved all colours at 0,55 - 1,60 - 3,0 mm.

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10E(11)		Cond.
Volume Resistivity	IEC 60093	Ohm cm	>10E(14)		Dry
Dissipation Factor Frequency	IEC 60250	-	0,03		
Surface Resistivity	IEC 60093	Ohm	10E(15)		Cond.
Dielectric Constant	IEC 60250	-	3,00		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		Cond.
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,16		

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Water Absorption (24h / +23°C)	ISO 62	%	1,7
Water Absorption at Saturation	ISO 62	%	7,5
Mould Shrinkage (Parallel)	Internal method	%	1,00 - 1,50
Mould Shrinkage (Normal)	Internal method	%	1,50 - 2,50
Melting temperature (DSC)	ISO 11357	°C	260

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	1800	Speed 1 mm/min	Cond.
Tensile Modulus	ISO 527-1,2	MPa	3600	Speed 1 mm/min	Dry
Elongation at Yield	ISO 527-1,2	%	15	Speed 50 mm/min	Cond.
Elongation at Yield	ISO 527-1,2	%	3,5	Speed 50 mm/min	Dry
Tensile Yield Strength	ISO 527-1,2	MPa	50	Speed 50 mm/min	Cond.
Tensile Yield Strength	ISO 527-1,2	MPa	78	Speed 50 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	4,5	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	75	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	1700	Speed 2 mm/min	Cond.
Flexural Modulus	ISO 178	MPa	3400	Speed 2 mm/min	Dry
Flexural Max Strength	ISO 178	MPa	55	Speed 10 mm/min	Cond.
Flexural Max Strength	ISO 178	MPa	115	Speed 10 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	40		Dry
IZOD Notched Impact (-25°C)	ASTM D256	J/m	20		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	4		Cond.
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	2,8		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	110		Cond.
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	50		Dry

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	240
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	225

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Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	80	
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	215	
Ball Pressure Test	IEC 60695-10-2	°C	190	
Continuous service temperature (20.000 h)	UL746 B	°C	90	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	8x10E(-5)	- 30°C / + 30°C

FLAMMABILITY

Flame Behaviour (0,55 mm)	UL94	Class	V0	UL approved
Flame Behaviour (1,6 mm)	UL94	Class	V0	UL approved
Flame Behaviour (3,0 mm)	UL94	Class	V0	UL approved
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	960	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	960	
Glow Wire Ignition Temperature-GWIT (1 mm)	IEC 60695-2-13	°C	750	
Glow Wire Ignition Temperature-GWIT (2 mm)	IEC 60695-2-13	°C	700	
Oxygen index	ASTM D2863	%	31	

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	< 10 %
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



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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.