



PRODUCT INFORMATION

TAROMID A 280 G3 K3

Polyamide 66 medium viscosity 30% glass beads/glass fibres reinforced, very good surface finish and dimensional stability.

ISO short Form ISO 1043: PA66-(GB+GF)30 Pellets

Key Features

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

Availability

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

Process

- INJECTION MOULDING

Application

- Household
- General purpose applications
- Electronic
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	7x10exp(15)		
Dielectric Strength	IEC 60243-1	kV/mm	21	2 mm	
Dissipation Factor Frequency	IEC 60250	-	0,018		
Dielectric Constant	IEC 60250	-	3,80		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	500		
Tracking Resistance (CTI - Method B)	IEC 60112	Volt	300M		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,33-1,35		
Filler content	ISO 3451	%	30	750°C - 1 h	
Granule Humidity	Internal method	%	<0,15		
Water Absorption (24h / +23°C)	ISO 62	%	0,5		

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Water Absorption at Saturation	ISO 62	%	5,3	
Mould Shrinkage (Parallel)	Internal method	%	0,45-0,55	
Mould Shrinkage (Normal)	Internal method	%	0,8-1,0	
Melting temperature (DSC)	ISO 11357	°C	255	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	15	280°C - 2,16 kg

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	5700	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	5	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	100	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	5400	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	160	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	45	+23°C	Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	4,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	18		Dry

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	245	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	230	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	217	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	205	
Continuous service temperature (20.000 h)	UL746 B	°C	90 (H120)	
Continuous service temperature (short term)	UL746 B	°C	130 (H 160)	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	4x10exp(-5)	-30°C /+30°C

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	750
Oxygen index	ASTM D2863	%	27

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INJECTION MOULDING	Value
Drying Temperature (Circulating Air Oven)	80 - 90°C
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Circulating Air Oven)	3 - 6 hours
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,08 %
Suggested Max Re grind	< 15 %
Melt Temperature	270 - 300°C
Feed Temperature	100°C
Rear Temperature	275°C
Middle Temperature	285°C
Front Temperature	285°C
Nozzle Temperature	280°C
Mould Temperature	80 - 120°C
Injection Rate	Medium to fast (50 - 150 mm/sec)
Injection Pressure	80 - 130 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	0,3 - 0,7 Mpa
Screw Revolving Speed	50 - 100 rpm
Cushion	2 - 6 mm
Screw L/D Ratio	18 - 22
Screw Compression Ratio	2:1 - 3:1
Vent Depth	0,02 mm

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