PRODUCT INFORMATION

TAROMID A 280 H MG6 DX0

Polyamide 66 medium viscosity 30% mineral filled, heat stabilized, flame retardant UL94 V0.

ISO short	ISO 1043: PA66-MF30 FR(17)
Form	Pellets
UL file	E143048

Key Features

- Designed for injection moulding applications
- Improved heat resistance
- Flame retardant
- Good dimensional stability

Availability

- W: lubricated
- All colours

Compliance

- UL94 V0 approved - NC only at 0,75 mm

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10exp(15)		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>400		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,58-1,60		
Filler content	ISO 3451	%	30	850°C - 1 h	
Granule Humidity	Internal method	%	<0,15		
Water Absorption (24h / +23°C)	ISO 62	%	0,5		
Water Absorption at Saturation	ISO 62	%	4,5		
Mould Shrinkage (Parallel)	Internal method	%	0,65		
Mould Shrinkage (Normal)	Internal method	%	0,65		
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	8000	Speed 1 mm/min	Dry

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Elongation at Break	ISO 527-1,2	%	2,6	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	80	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	8200	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	50	+23°C	Dry
THERMAL					
Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	254	50°C / h	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	242	50°C / h	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	232	120°C / h	
Ball Pressure Test	IEC 60695-10-2	°C	230		
Continuous service temperature	UL746 B	°C	130		
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	2,8x10exp(-5)	-30°C /+30°C	
FLAMMABILITY					
Flame Behaviour (0,75 mm)	UL94	Class	V0	UL approved	
Flame Behaviour (3,2 mm)	UL94	Class	V0		
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	960		
Oxigen index	ASTM D2863	%	30		

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	270 - 290°C
Feed Temperature	220°C
Rear Temperature	260°C
Middle Temperature	275°C
Front Temperature	280°C
Nozzle Temperature	275°C
Mould Temperature	80 - 100°C
Injection Rate	Medium

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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.