



PRODUCT INFORMATION

TAROMID A 280 MB3

Polyamide 66 medium viscosity, low coefficient of friction.

ISO short Form ISO 1043: PA66 Pellets

Key Features

- Designed for injection moulding applications
- Low coefficient of friction

Availability

- W: lubricated
- S: fast injection cycles
- H: heat stabilized
- Dark or black colour

Process

- INJECTION MOULDING

Application

- General purpose applications

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10exp(13)		
Dielectric Strength	IEC 60243-1	kV/mm	24	2 mm	
Dissipation Factor Frequency	IEC 60250	-	0,015		
Dielectric Constant	IEC 60250	-	3,40		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,14-1,16		
Granule Humidity	Internal method	%	<0,10		
Water Absorption (24h / +23°C)	ISO 62	%	1		
Water Absorption at Saturation	ISO 62	%	7		
Mould Shrinkage (Parallel)	Internal method	%	1,6-2,2		
Mould Shrinkage (Normal)	Internal method	%	1,6-2,5		
Melting temperature (DSC)	ISO 11357	°C	256		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	15	280°C - 1 kg	

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	3000	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	65	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	80	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	2900	Speed 1 mm/min	Dry
Flexural Max Strength	ISO 178	MPa	120	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	28	-20°C	Dry
IZOD Notched Impact	ASTM D256	J/m	40	+23°C	Dry
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.		Dry

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	240	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	90	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	205	
Continuous service temperature (20.000 h)	UL746 B	°C	90 (130 H)	
Continuous service temperature (short term)	UL746 B	°C	120 (160 H)	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	9x10exp(-5)	-30°C /+30°C

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



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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.