PRODUCT INFORMATION

TAROMID A 280 MT6

Polyamide 66 medium viscosity 30% mineral filled, high dimensional stability, high stiffness, good mechanical and thermal properties, good surface appearance.

ISO short ISO 1043: PA66-MD30
Form Pellets

Key Features

- Designed for injection moulding applications
- Mineral filled
- High dimensional stability

Availability

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

Process

- INJECTION MOULDING

Application

- General purpose applications
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10exp(15)		
Dielectric Strength	IEC 60243-1	kV/mm	24	2 mm	
Dissipation Factor Frequency	IEC 60250	-	0,020		
Dielectric Constant	IEC 60250	-	3,80		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	500		
Tracking Resistance (CTI - Method B)	IEC 60112	Volt	350M		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,36-1,38		
Filler content	ISO 3451	%	30	750°C - 1 h	
Granule Humidity	Internal method	%	<0,10		
Water Absorption (24h / +23°C)	ISO 62	%	0,6		

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Water Absorption at Saturation	ISO 62	%	5		
Mould Shrinkage (Parallel)	Internal method	%	0,8-1,1		
Mould Shrinkage (Normal)	Internal method	%	0,8-1,1		
Melting temperature (DSC)	ISO 11357	°C	256		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	280°C - 1 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	7200	Speed 1 mm/min	Dry
Tensile Yield Strength	ISO 527-1,2	MPa	85	Speed 50 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	2,5	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	74	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	7000	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	150	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	40	+23°C	Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	4		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	25		Dry
CHARPY Unnotched Impact (-25°C)	ISO 179/1eU	kJ/m^2	18		Dry
THERMAL					
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	235	50°C / h	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	190	120°C / h	
Ball Pressure Test	IEC 60695-10-2	°C	205		
Continuous service temperature (20.000 h)	UL746 B	°C	80 (120 H)		
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	4,5x10exp(-5)	-30°C /+30°C	
FLAMMABILITY					
Flame Behaviour (0,97 mm)	UL94	Class	HB		
Flame Behaviour (1,6 mm)	UL94	Class	HB		
Flame Behaviour (3,2 mm)	UL94	Class	HB		
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	750		

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Oxigen index	ASTM D2863	%	26

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 Regrind	<15 %
Melt Temperature	280 - 310°C
Feed Temperature	100°C
Rear Temperature	275°C
Middle Temperature	290°C
Front Temperature	295°C
Nozzle Temperature	285°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.