*PRODUCT INFORMATION*

# TAROMID A 280 R2

Polyamide 66 medium viscosity elastomer modified, high impact resistance, low moisture absorption, very good chemical resistance to oils, solvents and other chemical substances.

**ISO short** ISO 1043: PA66
**Form** Pellets

## Key Features

- Unfilled
- Improved impact resistance
- Designed for injection moulding applications
- Good flowability

## Availability

- W: lubricated
- S: fast injection cycles
- LP: laser printable
- L: UV stabilized
- HT: high resistance to heat
- All colours

## Process

- INJECTION MOULDING

## Application

- Household
- Furniture
- Electrical
- Consumer
- Automotive

| Property | Method | Unit | Value | Condition | State |
|---|---|---|---|---|---|
| **ELECTRICAL** | | | | | |
| Tracking Resistance (CTI - Method A) | IEC 60112 | Volt | 550 | | |
| **PHYSICAL** | | | | | |
| Density (+23°C) | ISO 1183 | g/cm^3 | 1,09 | | |
| Granule Humidity | Internal method | % | <0,10 | | |
| Water Absorption (24h / +23°C) | ISO 62 | % | 0,75 | | |
| Water Absorption at Saturation | ISO 62 | % | 5,5 | | |
| Mould Shrinkage (Parallel) | Internal method | % | 1,35-1,9 | | |
| Mould Shrinkage (Normal) | Internal method | % | 1,4-1,8 | | |

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|---|---|---|---|---|---|
| Melting temperature (DSC) | ISO 11357 | °C | 256 | | |
| Melt Flow Rate (MFR) | ISO 1133 | g/10 min | 8 | 280°C - 1 kg | |
| **MECHANICAL** | | | | | |
| Tensile Yield Strength | ISO 527-1,2 | MPa | 62 | Speed 50 mm/min | Dry |
| Elongation at Break | ISO 527-1,2 | % | 75 | Speed 50 mm/min | Dry |
| Flexural Modulus | ISO 178 | MPa | 2100 | Speed 1 mm/min | Dry |
| Flexural Max Strength | ISO 178 | MPa | 90 | Speed 1 mm/min | Dry |
| IZOD Notched Impact | ASTM D256 | J/m | 100 | +23°C | Dry |
| **THERMAL** | | | | | |
| Softening Temperature - 5 kg (VST/B/50) | ISO 306 | °C | 215 | 50°C / h | |
| Deflection Temperature 1,80 MPa (HDT A) | ISO 75A | °C | 70 | 120°C / h | |
| **FLAMMABILITY** | | | | | |
| Flame Behaviour (0,97 mm) | UL94 | Class | HB | | |
| Oxigen index | ASTM D2863 | % | 23 | | |

| **INJECTION MOULDING** | **Value** |
|---|---|
| Drying Temperature (Desiccant Dryer) | 70 - 80°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 |
| Injection Rate | Medium |
| Packing Pressure | 30 - 80 Mpa |
| Back Pressure | As low as possible (0,3 - 0,6 Mpa) |

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| | |
|---|---|
| Screw Revolving Speed | 50 - 100 rpm |
| Cushion | 3 - 6 mm |
| Screw L/D Ratio | 18 - 22 |
| Screw Compression Ratio | 2 - 2,5 |
| Vent Depth | 0,02 mm |

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