



PRODUCT INFORMATION

**TAROMID A 280 R3**

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

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

**Key Features**

- Unfilled
- Improved impact resistance
- Good flowability

**Availability**

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

**Process**

- INJECTION MOULDING

**Application**

- Household
- Furniture
- Electrical
- Consumer
- Automotive

Property	Method	Unit	Value	Condition	State
<b>ELECTRICAL</b>					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	550		
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,08		
Granule Humidity	Internal method	%	<0,15		
Water Absorption (24h / +23°C)	ISO 62	%	0,75		
Water Absorption at Saturation	ISO 62	%	5,5		
Mould Shrinkage (Parallel)	Internal method	%	1,3-1,8		

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Mould Shrinkage (Normal)	Internal method	%	1,2-1,8	
Melting temperature (DSC)	ISO 11357	°C	258	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	5	280°C - 1 kg

**MECHANICAL**

Tensile Yield Strength	ISO 527-1,2	MPa	60	Speed 50 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	80	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	2050	Speed 1 mm/min	Dry
Flexural Max Strength	ISO 178	MPa	85	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	180	+23°C	Dry

**THERMAL**

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	210	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
Oxygen 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



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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 - 2,5
Vent Depth	0,02 mm

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