



PRODUCT INFORMATION

**TAROMID A 280 Z3**

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

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

**Key Features**

- Improved impact resistance

**Availability**

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

**Process**

- INJECTION MOULDING

**Application**

- General purpose applications

Property	Method	Unit	Value	Condition	State
<b>ELECTRICAL</b>					
Volume Resistivity	IEC 60093	Ohm cm	1x10exp(15)		
Dissipation Factor Frequency	IEC 60250	-	0,016		
Dielectric Constant	IEC 60250	-	3,20		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
<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	%	1,2		
Water Absorption at Saturation	ISO 62	%	6		
Mould Shrinkage (Parallel)	Internal method	%	1,50-1,70		
Melting temperature (DSC)	ISO 11357	°C	256		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	6	280°C - 2,16 kg	

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**MECHANICAL**

Tensile Modulus	ISO 527-1,2	MPa	2400	Speed 1 mm/min	Dry
Tensile Yield Strength	ISO 527-1,2	MPa	55	Speed 50 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	50	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	2000	Speed 1 mm/min	Dry
Flexural Max Strength	ISO 178	MPa	75	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	640	-25°C	Dry
IZOD Notched Impact	ASTM D256	J/m	700	+23°C	Dry
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m <sup>2</sup>	60		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	55		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	66	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K <sup>-1</sup>	7-10x10exp(-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

**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



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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)
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**