



PRODUCT INFORMATION

TAROMID B 240 MT2 Y2

Polyamide 6 medium low viscosity 10% mineral filled, halogen free flame retardant UL94 V2, good flame proofing also at low thicknesses, good flow and good mechanical properties. Very high CTI value.

ISO short ISO 1043: PA6-MD10 FR(30)
Form Pellets
UL file E143048

Key Features

- Designed for injection moulding applications
- Halogen free
- Flame retardant
- Good flowability
- Mineral filled
- Antimony trioxide free

Availability

- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- All colours

Compliance

- UL94 V2 approved all colours at 0,97 and 1,5 mm. UL746 B approved.

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,23		
Filler content	ISO 3451	%	10	850°C - 1 h	
Granule Humidity	Internal method	%	<0,10		
Water Absorption (24h / +23°C)	ISO 62	%	2,0		
Water Absorption at Saturation	ISO 62	%	6,5		
Mould Shrinkage (Parallel)	Internal method	%	0,7		
Mould Shrinkage (Normal)	Internal method	%	0,8		

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Melting temperature (DSC)	ISO 11357	°C	222	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	12	250°C - 2,16 kg

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	4100	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	4,0	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	72	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	3800	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	110	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	35	+23°C	Dry
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m ²	3,5		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	2,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	30		Dry

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	200	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	160	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	170	

FLAMMABILITY

Flame Behaviour (0,97 mm)	UL94	Class	V2	UL approved
Flame Behaviour (1,5 mm)	UL94	Class	V2	UL approved
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	960	
Glow Wire Ignition Temperature-GWIT (1 mm)	IEC 60695-2-13	°C	775	

INJECTION MOULDING

	Value
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,08 %
Suggested Max Re grind	< 10 %
Melt Temperature	230 - 260°C
Feed Temperature	210°C



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Rear Temperature	235°C
Middle Temperature	245°C
Front Temperature	255°C
Nozzle Temperature	250°C
Mould Temperature	70 - 100°C
Injection Rate	Medium to Fast
Injection Pressure	3 - 12 Mpa
Packing Pressure	5 - 15 Mpa
Screw Revolving Speed	50 rpm @ Diameter 40 mm
Screw Revolving Speed	35 rpm @ Diameter 55 mm
Screw Revolving Speed	25 rpm @ Diameter 75 mm
Cushion	> 3 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.