



PRODUCT INFORMATION

TAROMID B 280 G3

Polyamide 6 medium viscosity 15% glass fibres reinforced.

ISO short Form ISO 1043: PA6-GF15
Pellets

Key Features

- Designed for injection moulding applications
- Glass fibres reinforced

Availability

- W: lubricated
- LP: laser printable
- L: UV stabilized
- I: improved resistance to glycol-hydrolysis
- HT: high resistance to heat
- H: heat stabilized
- FA: food approval
- DB: dry blend coloured
- All colours

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	7x10E(15)		Dry
Dielectric Strength	IEC 60243-1	kV/mm	22	2 mm	
Dissipation Factor Frequency	IEC 60250	-	0,018		
Dielectric Constant	IEC 60250	-	4,10		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	550		

PHYSICAL

PRODUCT INFORMATION

TAROMID B 280 G3

Density (+23°C)	ISO 1183	g/cm ³	1,23	
Filler content	ISO 3451	%	15	750 °C - 1 h
Granule Humidity	Internal method	%	< 0,15	
Water Absorption (24h / +23°C)	ISO 62	%	1,1	
Water Absorption at Saturation	ISO 62	%	7	
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,5	
Mould Shrinkage (Normal)	Internal method	%	0,8 - 1,0	
Melting temperature (DSC)	ISO 11357	°C	222	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	15	250 °C - 2,16 kg

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	6100	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	4	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	125	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	5800	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	150	Speed 1 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	105		Cond.
IZOD Notched Impact (+23°C)	ASTM D256	J/m	60		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	5,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	35		Dry
CHARPY Unnotched Impact (-25°C)	ISO 179/1eU	kJ/m ²	25		Dry

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	210	VST/A/50
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	205	VST/B/50
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	190	120°C / h
Continuous service temperature (20.000 h)	UL746 B	°C	90 (H 130)	
Continuous service temperature (short term)	UL746 B	°C	140 (H 180)	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	4x10E(-5)	-30°C / +30°C

PRODUCT INFORMATION

TAROMID B 280 G3

FLAMMABILITY

Flame Behaviour (0,97 mm)	UL94	Class	HB
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	750
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	< 80 Thickness > 1,5 mm
Oxygen index	ASTM D2863	%	24

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 h
Drying Time (Desiccant Dryer)	2 - 4 h
Suggested Max Moisture	< 0,08 %
Suggested Max Regrind	< 15 %
Melt Temperature	240 - 270°C
Feed Temperature	230°C
Rear Temperature	240°C
Middle Temperature	255°C
Front Temperature	260°C
Nozzle Temperature	255°C
Mould Temperature	70 - 90°C
Injection Rate	Medium
Injection Pressure	40 - 100 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	5 - 10 Mpa
Screw Revolving Speed	50 - 100 rpm
Cushion	2 - 6 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.