PRODUCT INFORMATION

TAROMID B 280 G5

Polyamide 6 medium viscosity 25% glass fibres reinforced, good mechanical properties and dimensional stability.

ISO short ISO 1043: PA6-GF25
Form Pellets

Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Glass fibres reinforced
- Good dimensional stability

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

- Household
- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	7x10E15		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	550		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,32		
Filler content	ISO 3451	%	25	750°C - 1 h	
Granule Humidity	Internal method	%	< 0,10		

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Water Absorption (24h / +23°C)	ISO 62	%	1,0		
Water Absorption at Saturation	ISO 62	%	6,5		
Mould Shrinkage (Parallel)	Internal method	%	0,3 - 0,4		
Mould Shrinkage (Normal)	Internal method	%	0,6 - 0,8		
Melting temperature (DSC)	ISO 11357	°C	222		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	250°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	8300	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	170	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	8000	Speed 2 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	240	Speed 10 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	120		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	10,5		Dry
THERMAL					
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	220	50°C / h	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	210	120°C / h	
Continuous service temperature (20.000 h)	UL746 B	°C	100 (130H/HT)		
Continuous service temperature (short term)	UL746 B	°C	140 (180H/HT)		
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	3,5x10E(-5)	-30°C /+30°C	
FLAMMABILITY					
Flame Behaviour (1,6 mm)	UL94	Class	HB		
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	750		
Oxigen index	ASTM D2863	%	24		

INJECTION MOULDING	**Value**
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 h

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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. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry and design.