PRODUCT INFORMATION

TAROMID B 280 G6 Y0

Polyamide 6 medium viscosity 30% glass fibres reinforced, halogen free flame retardant UL94 V0, good flow, high electrical and mechanical properties, good dimensional stability.

ISO short	ISO 1043: PA6-GF30 FR(30)
Form	Pellets

Key Features

- Designed for injection moulding applications
- Halogen free
- Glass fibres reinforced
- Flame retardant

Availability

- LP: laser printable
- L: UV stabilized
- I: improved resistance to glycol-hydrolysis
- All colours

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Automotive

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	1,40		
Filler content	ISO 3451	%	30	850°C - 1 h	
Granule Humidity	Internal method	%	< 0,15		
Water Absorption (24h / +23°C)	ISO 62	%	1,5		
Water Absorption at Saturation	ISO 62	%	7,0		
Mould Shrinkage (Parallel)	Internal method	%	0,25 - 0,35		
Mould Shrinkage (Normal)	Internal method	%	0,40 - 0,70		
Melting temperature (DSC)	ISO 11357	°C	222		
MECHANICAL					

PRODUCT INFORMATION

TAROMID B 280 G6 Y0

Tensile Modulus	ISO 527-1,2	MPa	8800	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	2,5	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	130	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	8300	Speed 2 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	180	Speed 10 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	90		Dry
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m^2	7,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	35		Dry
THERMAL					
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	220		
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	215		
Ball Pressure Test	IEC 60695-10-2	°C	170		
FLAMMABILITY					
Flame Behaviour (0,97 mm)	UL94	Class	V0		
Flame Behaviour (1,6 mm)	UL94	Class	V0		
Flame Behaviour (3,2 mm)	UL94	Class	V0		
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	960		
Glow Wire Ignition Temperature-GWIT (1,5 mm)	IEC 60695-2-13	°C	800		
Oxigen index	ASTM D2863	%	30		

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,08 %
Melt Temperature	230 - 260°C
Feed Temperature	210°C
Rear Temperature	235°C
Middle Temperature	245°C
Front Temperature	255°C

PRODUCT INFORMATION

TAROMID B 280 G6 Y0

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