



PRODUCT INFORMATION

TAROMID B 280 MT5

Polyamide 6 medium viscosity 25% mineral filled, good dimensional stability, uniform shrinkage in all directions, good surface appearance, mechanical and thermal properties.

ISO short Form ISO 1043: PA6-MD25 Pellets

Key Features

- Designed for injection moulding applications
- Good flowability
- Mineral filled

Availability

- W: lubricated
- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- all colors

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10exp(15)		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,32-1,34		
Filler content	ISO 3451	%	25	750°C - 1 h	
Granule Humidity	Internal method	%	<0,10		
Water Absorption (24h / +23°C)	ISO 62	%	1		
Water Absorption at Saturation	ISO 62	%	6,8		
Mould Shrinkage (Parallel)	Internal method	%	0,4-0,6		
Mould Shrinkage (Normal)	Internal method	%	0,4-0,6		

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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	6500	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	2,8	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	78	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	6200	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	120	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	40	+23°C	Dry
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m ²	4		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	180	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	170	
Continuous service temperature (20.000 h)	UL746 B	°C	70 (110 H)	
Continuous service temperature (short term)	UL746 B	°C	100 (150 H)	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	4,5x10exp(-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	
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%



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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
Cushion	2 - 6 mm
Screw L/D Ratio	18 - 22
Screw Compression Ratio	2 - 2,5
Vent Depth	0,02 mm

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.