



PRODUCT INFORMATION

TAROMID B 280 MT6

Polyamide 6 medium viscosity 30% mineral filled, good dimensional stability, uniform shrinkage in all directions, good surface appearance, mechanical and thermal properties.

ISO short Form ISO 1043: PA6-MD30 Pellets

Key Features

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

Availability

- W: lubricated
- LP: laser printable
- L: UV stabilized
- HT: high resistance to heat
- H: heat stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	10E11		Cond.
Volume Resistivity	IEC 60093	Ohm cm	10E13		Dry
Surface Resistivity	IEC 60093	Ohm	10E10		Cond.
Dielectric Constant (1 MHz)	IEC 60250	-	6,5		Cond.
Dielectric Constant (1 MHz)	IEC 60250	-	3,5		Dry
Dissipation Factor Frequency (1 MHz)	IEC 60250	-	2		Cond.
Dissipation Factor Frequency (1 MHz)	IEC 60250	-	0,2		Dry
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		

PHYSICAL

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Density (+23°C)	ISO 1183	g/cm ³	1,37	
Filler content	ISO 3451	%	30	750°C - 1 h
Granule Humidity	Internal method	%	<0,10	
Water Absorption (24h / +23°C)	ISO 62	%	0,9	
Water Absorption at Saturation	ISO 62	%	6,5	
Mould Shrinkage (Parallel)	Internal method	%	0,5 - 0,9	
Mould Shrinkage (Normal)	Internal method	%	0,7 - 1,2	
Melting temperature (DSC)	ISO 11357	°C	222	

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	3400	Speed 1 mm/min	Cond.
Tensile Modulus	ISO 527-1,2	MPa	6200	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	10	Speed 50 mm/min	Cond.
Elongation at Break	ISO 527-1,2	%	3,5	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	48	Speed 50 mm/min	Cond.
Tensile Break Strength	ISO 527-1,2	MPa	75	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	2900	Speed 1 mm/min	Cond.
Flexural Modulus	ISO 178	MPa	5700	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	50	Speed 1 mm/min	Cond.
Flexural Break Strength	ISO 178	MPa	120	Speed 1 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	65		Cond.
IZOD Notched Impact (+23°C)	ASTM D256	J/m	45		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	6		Cond.
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	3,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	60		Cond.
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	40		Dry

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	210	50°C / h
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Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	185	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	170	
Continuous service temperature (20.000 h)	UL746 B	°C	70 (110 H/HT)	
Continuous service temperature (short term)	UL746 B	°C	100 (150 H/HT)	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	5x10E(-5)	-30°C /+30°C
Coefficient of linear thermal expansion (transversal)	ISO 11359-1,-2	K ⁻¹	4,5x10E(-5)	-30°C /+30°C
Thermal Conductivity	ISO 8302	W/(m K)	0,31	

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	750	
Glow Wire Ignition Temperature-GWIT (1,6 mm)	IEC 60695-2-13	°C	650	
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



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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 - 2,5
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.