PRODUCT INFORMATION

TAROMID B 280 R1

Polyamide 6 medium viscosity elastomer modified, good impact resistance.

ISO short ISO 1043: PA6-I
Form Pellets

Key Features

- Unfilled
- Improved impact resistance
- Designed for injection moulding applications
- Good flowability

Availability

- W: lubricated
- L: UV stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Household
- Furniture
- Electrical
- Consumer
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	5x10exp(15)		
Dielectric Strength	IEC 60243-1	kV/mm	18	2 mm	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,11-1,13		
Granule Humidity	Internal method	%	<0,15		
Water Absorption (24h / +23°C)	ISO 62	%	1,8		
Water Absorption at Saturation	ISO 62	%	8,5		
Mould Shrinkage (Parallel)	Internal method	%	1,1-1,6		
Mould Shrinkage (Normal)	Internal method	%	1,1-1,6		

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Melting temperature (DSC)	ISO 11357	°C	220		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	250°C - 1 kg	

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	2750	Speed 1 mm/min	Dry
Tensile Yield Strength	ISO 527-1,2	MPa	58	Speed 50 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	100	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	2400	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	75	+23°C	Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	4,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	N.B.		Dry

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	195	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	70	120°C / h

FLAMMABILITY

Flame Behaviour (0,97 mm)	UL94	Class	HB
Flame Behaviour (1,6 mm)	UL94	Class	HB
Oxigen index	ASTM D2863	%	23

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 - 260°C
Feed Temperature	220°C
Rear Temperature	235°C
Middle Temperature	245°C
Front Temperature	250°C

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Nozzle Temperature	245°C
Mould Temperature	70 - 80°C
Injection Rate	Medium to Fast
Injection Pressure	40 - 100 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	0,5 - 2,5 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.