PRODUCT INFORMATION

TAROMID B 280 Z2 G6

Polyamide 6 medium viscosity 30% glass fibres reinforced, elastomer modified.

ISO short ISO 1043: PA66-IGF30
Form Pellets

Key Features

- Improved impact resistance
- Designed for injection moulding applications
- Glass fibres reinforced

Availability

- W: lubricated
- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Electrical
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	1x10exp(15)		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	550		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,31		
Filler content	ISO 3451	%	30	750°C - 1 h	
Granule Humidity	Internal method	%	< 0,15		
Water Absorption (24h / +23°C)	ISO 62	%	0,7 - 0,9		
Water Absorption at Saturation	ISO 62	%	5,5		
Mould Shrinkage (Parallel)	Internal method	%	0,25 - 0,35		
Mould Shrinkage (Normal)	Internal method	%	0,6 - 0,8		
Melting temperature (DSC)	ISO 11357	°C	222		

PRODUCT INFORMATION

TAROMID B 280 Z2 G6

Melt Flow Rate (MFR)	ISO 1133	g/10 min	4	250°C - 2,16 kg	

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	8000	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	105	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	7000	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	140	Speed 1 mm/min	Dry
IZOD Notched Impact (+23°C)	ASTM D256	J/m	170		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	200	120°C / h
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	3x10exp(-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	650
Oxigen index	ASTM D2863	%	23

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 h
Suggested Max Moisture	< 0,08%
Suggested Max Regrind	< 10%
Melt Temperature	240 - 280°C
Feed Temperature	230°C
Rear Temperature	240°C
Middle Temperature	255°C
Front Temperature	270°C
Nozzle Temperature	265°C
Mould Temperature	70 - 90°C
Injection Rate	Medium

PRODUCT INFORMATION

TAROMID B 280 Z2 G6

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.