

TAROMID B 280 R1

Polyamide 6

Taro Plast S.p.A.

Message:

Polyamide 6 elastomer modified, good impact resistance.
Available: all colors, UV stabilized (L), release agent (W).

General Information			
Additive	Mold Release		
	Unspecified Additive		
	UV Stabilizer		
Features	Good Impact Resistance		
	Good Mold Release		
	Good UV Resistance		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11 to 1.13	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/1.2 kg)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	1.1 to 1.6	%	
Across Flow	1.1 to 1.6	%	
Water Absorption			
23°C, 24 hr	1.8	%	ASTM D570, ISO 62
Saturation	8.5	%	ASTM D570
Saturation, 23°C	8.5	%	ISO 62
Granule Humidity	< 0.15	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2750	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	58.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	100	%	ASTM D638, ISO 527-2
Flexural Modulus	2400	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	4.5	kJ/m ²	ASTM D256, ISO 179
Charpy Unnotched Impact Strength ² (23°C)	No Break		ASTM D256, ISO 179
Notched Izod Impact (23°C, 3.20 mm)	75	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	70.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	195	°C	ISO 306/B50, ASTM D1525 ³
Melting Temperature	220	°C	ASTM D211, ISO 121
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.0E+15	ohms·cm	ASTM D257
Dielectric Strength (2.00 mm)	18	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.970 mm	HB		
1.60 mm	HB		
Oxygen Index	23	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0 to 90.0	°C	
Pre-heater	80.0 to 100	°C	
Drying Time			
--	1.0	hr	
Pre-heater	3.0	hr	
Processing (Melt) Temp	220 to 250	°C	
Mold Temperature	70.0 to 80.0	°C	
Injection Rate	Moderate		
NOTE			
1.	6x4x50 mm		
2.	6x4x50 mm		
3.	Rate A (50°C/h), Loading 2 (50 N)		

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