

TAROMID A 280S

Polyamide 66

Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity, good processing and easy release, low post shrinkage and better dimensional stability, short cycles, high rigidity. Available: natural and colored dry blend (DB).

General Information			
Filler / Reinforcement	Calcium Carbonate		
Additive	Mold Release		
Features	Fast Molding Cycle		
	Good Dimensional Stability		
	Good Mold Release		
	Good Processability		
	High Rigidity		
	Low Shrinkage		
	Medium Viscosity		
Appearance	Natural Color		
	Unspecified Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13 to 1.15	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/1.2 kg)	35	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	1.6 to 2.2	%	
Across Flow	1.6 to 2.5	%	
Water Absorption			
23°C, 24 hr	1.0	%	ASTM D570, ISO 62
Saturation	7.0	%	ASTM D570
Saturation, 23°C	7.0	%	ISO 62
Granule Humidity	< 0.15	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3300	MPa	ASTM D638, ISO 527-2
Tensile Strength			ASTM D638, ISO 527-2
Yield	88.0	MPa	

Break	88.0	MPa	
Tensile Elongation (Break)	40	%	ASTM D638, ISO 527-2
Flexural Modulus	3250	MPa	ASTM D790, ISO 178
Flexural Stress			
--	130	MPa	ISO 178
Yield	130	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	3.4	kJ/m ²	ASTM D256, ISO 179
Charpy Unnotched Impact Strength ² (23°C)	> 300	kJ/m ²	ASTM D256, ISO 179
Notched Izod Impact			
-20°C, 3.20 mm	24	J/m	ISO 180, ASTM D256
23°C, 3.20 mm	35	J/m	ASTM D256, ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	90.0	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ³	80.0 to 90.0	°C	
-- ⁴	120	°C	
Vicat Softening Temperature			
--	254	°C	ASTM D1525, ISO 306/A50 5 ⁵
--	240	°C	ASTM D1525, ISO 306/B50 6 ⁶
Ball Pressure Test (165°C)	Pass		VDE 0470
Melting Temperature	256	°C	ASTM D211, ISO 121
CLTE - Flow (-30 to 30°C)	8.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	9.0E+15	ohms · cm	ASTM D257
Dielectric Strength (2.00 mm)	24	kV/mm	ASTM D149
Comparative Tracking Index			IEC 60112
Solution A	> 600	V	
Solution B	600	V	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Ignition Temperature (2.00 mm)	750	°C	IEC 60695-2-13
Oxygen Index	26	%	ASTM D2863
Injection	Nominal Value	Unit	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	70.0 to 90.0	°C	
Injection Rate	Moderate		
NOTE			
1.	6x4x50 mm		

2.	6x4x50 mm
3.	20000 hrs
4.	Short Term
5.	Rate A (50°C/h), Loading 1 (10 N)
6.	Rate A (50°C/h), Loading 2 (50 N)

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