

TAROMID A 280 H G9 DX0 TR1

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity 45% glass fibres reinforced, flame retardant UL94 V0, heat stabilized, very good flame proofing also at low thickness. Very high mechanical and thermal properties, very low shrinkage and high dimensional stability, high tracking resistance.

General Information			
UL YellowCard	E143048-223242		
Filler / Reinforcement	Glass fiber reinforced material, 45% filler by weight		
Additive	heat stabilizer		
	Flame retardancy		
Features	Good dimensional stability		
	Track Resistance		
	Thermal Stability		
	Low shrinkage		
	Medium viscosity		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.61 - 1.63	g/cm ³	ISO 1183
Molding Shrinkage			Internal method
Vertical flow direction	0.25 - 0.50	%	Internal method
Flow direction	0.15 - 0.30	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	0.40	%	ISO 62
Saturated, 23°C	3.0	%	ISO 62
Granule Humidity ¹		%	
Reinforcement Content ² (850°C)	45	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	12000	MPa	ISO 527-2/1
Tensile Stress (Break)	170	MPa	ISO 527-2/50
Tensile Strain (Break)	1.5	%	ISO 527-2/50
Flexural Modulus ³	11000	MPa	ISO 178
Flexural Stress ⁴	230	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	kJ/m ²	ISO 179/1eU

Notched Izod Impact (23°C)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed)	244	°C	ISO 75-2/A
Continuous Use Temperature ⁶	180	°C	IEC 60216
Vicat Softening Temperature	246	°C	ISO 306/B50
Ball Pressure Test (230°C)	Pass		IEC 60695-10-2
Melting Temperature	250 - 256	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Dielectric Strength (2.00 mm)	28	kV/mm	IEC 60243-1
Dielectric Constant	3.70		IEC 60250
Comparative Tracking Index (Solution A)	> 400	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.60 mm	V-0		UL 94
3.20 mm	V-0		UL 94
Glow Wire Flammability Index (1.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (1.00 mm)	875	°C	IEC 60695-2-13
Oxygen Index	36	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	1.0	hr	
Processing (Melt) Temp	270 - 300	°C	
Mold Temperature	90.0 - 110	°C	
Injection Rate	Moderate		
Injection instructions			
Pre-heat Temperature: 80 to 100°CPre-heat Time: 3 hr			
NOTE			
1.	TARO 002		
2.	1 hr		
3.	1.0 mm/min		
4.	1.0 mm/min		
5.	120°C/hr		
6.	Short term		

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