

TAROMID A 280 G6 Y0

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity 30% glass fibres reinforced, heat stabilized, flame retardant UL94 V0, good flow, high electrical and mechanical properties, good dimensional stability.

General Information			
UL YellowCard	E143048-100072694		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
	Flame retardancy		
Features	Good dimensional stability		
	Good electrical performance		
	Good liquidity		
	Thermal Stability		
	Medium viscosity		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Molding Shrinkage			Internal method
Vertical flow direction	0.50 - 0.85	%	Internal method
Flow direction	0.35 - 0.55	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	0.60	%	ISO 62
Saturated, 23°C	4.8	%	ISO 62
Granule Humidity ¹		%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9300	MPa	ISO 527-2/1
Tensile Stress (Break)	135	MPa	ISO 527-2/50
Tensile Strain (Break)	2.4	%	ISO 527-2/50
Flexural Modulus ²	8800	MPa	ISO 178
Flexural Stress ³	200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	35	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	80	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed)	242	°C	ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ⁵	125	°C	IEC 60216
-- ⁶	160	°C	IEC 60216
Vicat Softening Temperature	246	°C	ISO 306/B50
Ball Pressure Test (210°C)	Pass		IEC 60695-10-2
Melting Temperature	256	°C	ISO 11357-3
CLTE - Flow (-30 to 30°C)	3.0E-5	cm/cm/°C	ISO 11359-2

Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	PLC 0		UL 746
Comparative Tracking Index (Solution A)	600	V	IEC 60112

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.850 mm	V-0		UL 94
1.50 mm	V-0		UL 94
3.00 mm	V-0		UL 94
Glow Wire Flammability Index (3.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (3.00 mm)	775	°C	IEC 60695-2-13
Oxygen Index	30	%	ASTM D2863

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 90.0	°C
Drying Time	1.0	hr
Processing (Melt) Temp	260 - 270	°C
Mold Temperature	70.0 - 90.0	°C
Injection Rate	Moderate	

Injection instructions

Pre-heat Temperature: 80 to 100°CPre-heat Time: 3 hr

NOTE	
1.	TARO 002
2.	1.0 mm/min
3.	1.0 mm/min
4.	120°C/hr
5.	20,000 hr
6.	Short term

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