

TAROMID A 280 K6

Polyamide 66

Taro Plast S.p.A.

Message:

Polyamide 6,6 30% glass beads, good dimensional stability, good surface finish and good mechanical and thermal properties.
Available: all colors, UV-stabilized (L), heat stabilized (H), release agent (W).

General Information			
Filler / Reinforcement	Glass Bead,30% Filler by Weight		
Additive	Heat Stabilizer		
	Mold Release		
	UV Stabilizer		
Features	Good Dimensional Stability		
	Good Mold Release		
	Good Surface Finish		
	Good UV Resistance		
	Heat Stabilized		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35 to 1.37	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/1.0 kg)	10	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	0.90 to 1.1	%	
Across Flow	0.90 to 1.1	%	
Water Absorption			
23°C, 24 hr	0.50	%	ASTM D570, ISO 62
Saturation	5.5	%	ASTM D570
Saturation, 23°C	5.5	%	ISO 62
Granule Humidity	< 0.10	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5400	MPa	ASTM D638, ISO 527-2
Tensile Strength (Break)	80.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	6.5	%	ASTM D638, ISO 527-2
Flexural Modulus	4800	MPa	ASTM D790, ISO 178
Flexural Stress			
--	120	MPa	ISO 178

Break	120	MPa	ASTM D790
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)	25	kJ/m ²	ASTM D256, ISO 179
Notched Izod Impact (23°C, 3.20 mm)	30	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	90.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	235	°C	ISO 306/B50, ASTM D1525 ³
Ball Pressure Test (165°C)	Pass		VDE 0470
Melting Temperature	256	°C	ASTM D211, ISO 121
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (Solution A)	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		
3.20 mm	HB		
Glow Wire Ignition Temperature (2.00 mm)	650	°C	IEC 60695-2-13
Oxygen Index	27	%	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	260 to 280	°C	
Mold Temperature	80.0 to 110	°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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