

TAROMID B 280 MT5

Polyamide 6

Taro Plast S.p.A.

Message:

Polyamide 6 medium viscosity 25% mineral filled, good dimensional stability, uniform shrinkage in all directions, good surface appearance, mechanical and thermal properties.

General Information			
Filler / Reinforcement	Mineral filler, 25% filler by weight		
Features	Good dimensional stability		
	Excellent appearance		
	Medium viscosity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.32 - 1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	10	g/10 min	ISO 1133
Molding Shrinkage			Internal method
Vertical flow direction	0.40 - 0.60	%	Internal method
Flow direction	0.40 - 0.60	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	1.0	%	ISO 62
Saturated, 23°C	6.8	%	ISO 62
Granule Humidity ¹		%	
Reinforcement Content ² (750°C)	25	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6500	MPa	ISO 527-2/1
Tensile Stress (Break)	78.0	MPa	ISO 527-2/50
Tensile Strain (Break)	2.8	%	ISO 527-2/50
Flexural Modulus ³	6200	MPa	ISO 178
Flexural Stress ⁴	120	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	40	J/m	ASTM D256
Notched Izod Impact (23°C)	4.00	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed)	180	°C	ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ⁶	70.0	°C	IEC 60216
-- ⁷	100	°C	IEC 60216

Vicat Softening Temperature	210	°C	ISO 306/B50
Ball Pressure Test (170°C)	Pass		IEC 60695-10-2
Melting Temperature	222	°C	ISO 11357-3
CLTE - Flow (-30 to 30°C)	4.5E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	750	°C	IEC 60695-2-12
Oxygen Index	24	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0	hr	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	80.0 - 100	°C	
Injection Rate	Moderate-Fast		
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.	20,000 hr, 110 H		
7.	Short term, 150 H		

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