

TEKAMID™ TA210HS

Polyamide 66

Mando Advanced Materials Co., Ltd.

Message:

TA210HS is a heat stabilized, lubricated unreinforced polyamide 66 for injection molding.

General Information			
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.5	%	ASTM D955
Water Absorption (23°C, 24 hr)	1.3	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	81.4	MPa	ASTM D638
Tensile Elongation ² (Break)	60	%	ASTM D638
Flexural Modulus ³	2940	MPa	ASTM D790
Flexural Strength ⁴	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	230	°C	ASTM D648
1.8 MPa, not annealed	80.0	°C	ASTM D648
Peak Melting Temperature	260	°C	ASTM D3418
Flammability	Nominal Value	Test Method	
Flame Rating	V-2	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 5.0	hr	
Rear Temperature	255 - 270	°C	
Middle Temperature	260 - 275	°C	
Front Temperature	260 - 275	°C	
Nozzle Temperature	260 - 280	°C	
Processing (Melt) Temp	260 - 280	°C	

Mold Temperature	60.0 - 90.0	°C
Injection instructions		
Injection Speed: 20 to 50%Injection Pressure - 1st: 30 to 60%Injection Pressure - 2nd: 30 to 60%Injection Pressure - Back Pressure: 0 to 20%		
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	3.0 mm/min	
4.	3.0 mm/min	

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