

TAROMID A 280 G7 Y0

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity 35% glass fibres reinforced, heat stabilized, halogen free 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, 35% filler by weight		
Additive	heat stabilizer		
	Flame retardancy		
Features	Good dimensional stability		
	Good electrical performance		
	Good liquidity		
	Thermal Stability		
	Halogen-free		
	Medium viscosity		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.45 - 1.47	g/cm ³	ISO 1183
Molding Shrinkage			Internal method
Vertical flow direction	0.45 - 0.75	%	Internal method
Flow direction	0.30 - 0.50	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	0.50	%	ISO 62
Saturated, 23°C	4.8	%	ISO 62
Granule Humidity ¹		%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10000	MPa	ISO 527-2/1
Tensile Stress (Break)	150	MPa	ISO 527-2/50
Tensile Strain (Break)	2.2	%	ISO 527-2/50
Flexural Modulus ²	9600	MPa	ISO 178
Flexural Stress ³	220	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)	38	kJ/m ²	ISO 179/1eU

Notched Izod Impact (23°C)	90	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed)	245	°C	ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ⁵	130	°C	IEC 60216
-- ⁶	160	°C	IEC 60216
Vicat Softening Temperature	247	°C	ISO 306/B50
Ball Pressure Test (230°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
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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

