

Tarnamid® T-27 GF25 MT15

Polyamide 6

Grupa Azoty S.A.

Message:

It is 25% glass fibres and 15% mineral reinforced polyamide 6 compound, heat stabilised.

General Information				
Filler / Reinforcement		Glass Fiber,25% Filler by Weight Mineral,15% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Uses		Appliances Automotive Applications Electrical/Electronic Applications Household Goods		
Appearance		Black Colors Available Natural Color		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.44	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	30.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				ISO 294-4
Across Flow : 2.00 mm	0.90	--	%	
Flow : 2.00 mm	0.30	--	%	
Water Absorption				ISO 62
Saturation, 23°C	7.0	--	%	
Equilibrium, 23°C, 50% RH	2.0	--	%	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	220	150	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	11300	8600	MPa	ISO 527-2/1
Tensile Stress (Yield)	135	100	MPa	ISO 527-2/5
Tensile Strain (Break)	4.0	5.0	%	ISO 527-2/5
Flexural Modulus ¹	10200	7800	MPa	ISO 178

Flexural Stress ²	200	160	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
--	6.0	9.0	kJ/m ²	
-30°C	5.0	5.0	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
--	55	65	kJ/m ²	
-30°C	45	45	kJ/m ²	
Notched Izod Impact Strength	7.0	8.0	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	210	200	°C	ISO 75-2/A
Vicat Softening Temperature	215	205	°C	ISO 306/B
Melting Temperature	221	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	1.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	9.0E-5	--	cm/cm/°C	
Limit of Temperature - a few hours operation	< 200	--	°C	
Temperature Index				
20000 hr	110	--	°C	
5000 hr	120	--	°C	
Burning Rate	+	--		FMVSS 302
ISO Type	PA6, MHR, 14-090, GF25MD15 --			ISO 1874
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+16	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+13	ohms·cm	IEC 60093
Electric Strength (2.00 mm)	31	27	kV/mm	IEC 60243-1
Dielectric Constant (1 Hz)	3.70	4.70		IEC 60250
Dissipation Factor (1 Hz)	0.016	0.13		IEC 60250
Comparative Tracking Index (Solution A)	525	525	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.20 mm)	HB	--		UL 94
Glow Wire Flammability Index (2.00 mm)	650	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature	< 80.0		°C	
Suggested Max Moisture	< 0.10		%	
Suggested Max Regrind	10		%	

Processing (Melt) Temp	240 to 260	°C
Mold Temperature	80.0 to 100	°C
Injection Pressure	80.0 to 110	MPa
Injection Rate	Moderate	

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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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



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