

Tarnamid® T- 27 GF25 FRV0

Polyamide 6

Grupa Azoty S.A.

Message:

25% glass reinforced, heat stabilised, flame retardant, halogens and red phosphorus free.

General Information				
Filler / Reinforcement		Glass Fiber,25% Filler by Weight		
Additive		Flame Retardant		
		Heat Stabilizer		
Features		Flame Retardant		
		Halogen Free		
		Heat Stabilized		
		Low (to None) Phosphorus Content		
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	1.35	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	25.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				ISO 294-4
Across Flow : 2.00 mm	1.1	--	%	
Flow : 2.00 mm	0.20	--	%	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	220	130	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9500	6600	MPa	ISO 527-2/1
Tensile Stress (Yield)	140	95.0	MPa	ISO 527-2/5
Tensile Strain (Break)	4.0	6.0	%	ISO 527-2/5
Flexural Modulus ¹	8000	4600	MPa	ISO 178

Flexural Stress ²	200	120	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	7.0	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	65	70	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength	9.0	13	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	200	185	°C	ISO 75-2/A
Vicat Softening Temperature	210	200	°C	ISO 306/B
Melting Temperature	221	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	2.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	1.0E-4	--	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, MFHR, 14-080, GF20	--		ISO 1874
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+12	--	ohms	IEC 60093
Volume Resistivity	1.0E+12	--	ohms·cm	IEC 60093
Electric Strength (2.00 mm)	20	--	kV/mm	IEC 60243-1
Dielectric Constant (1 Hz)	4.40	--		IEC 60250
Dissipation Factor (1 Hz)	0.088	--		IEC 60250
Comparative Tracking Index (Solution A)	525	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	V-0	--		
3.20 mm	V-0	--		
Glow Wire Flammability Index (2.00 mm)	960	--	°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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