

TAROMID A 280 Z1 G6

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity 30% glass fibres reinforced, elastomer modified, very good mechanical properties, good dimensional stability and low water absorption.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier		
Features	Good dimensional stability		
	Impact modification		
	Low or no water absorption		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28 - 1.30	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/2.16 kg)	8.0	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.20 - 0.35	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	0.50	%	ISO 62
Saturated, 23°C	4.5	%	ISO 62
Granule Humidity ¹		%	
Reinforcement Content ² (750°C)	30	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8400	MPa	ISO 527-2/1
Tensile Stress (Break)	140	MPa	ISO 527-2/50
Tensile Strain (Break)	4.0	%	ISO 527-2/50
Flexural Modulus ³	8000	MPa	ISO 178
Flexural Stress ⁴	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-25°C	9.0	kJ/m ²	ISO 179/1eA
23°C	18	kJ/m ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
-20°C	90	J/m	ASTM D256
23°C	160	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵ (1.8 MPa, Unannealed)	215	°C	ISO 75-2/A

Continuous Use Temperature			IEC 60216
-- ⁶	100	°C	IEC 60216
-- ⁷	140	°C	IEC 60216
Vicat Softening Temperature	225	°C	ISO 306/B50
Ball Pressure Test (205°C)	Pass		IEC 60695-10-2
Melting Temperature	256	°C	ISO 11357-3
CLTE - Flow (-30 to 30°C)	3.2E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	8.0E+15	ohms·cm	IEC 60093
Dielectric Strength (2.00 mm)	22	kV/mm	IEC 60243-1
Comparative Tracking Index (Solution A)	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.970 mm)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	1.0	hr	
Processing (Melt) Temp	260 - 280	°C	
Mold Temperature	80.0 - 110	°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, 130 H		
7.	Short term, 180 H		

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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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