

TAROMID B 280 G3

Polyamide 6

Taro Plast S.p.A.

Message:

Polyamide 6 glass fibre reinforced 15%.
Available: all colours, UV stabilised (L), heat stabilised (H), release agent (W).

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	Heat Stabilizer		
	Mold Release		
	UV Stabilizer		
Features	Good Mold Release		
	Good UV Resistance		
	Heat Stabilized		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19 to 1.21	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	15	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	0.40 to 0.50	%	
Across Flow	0.80 to 1.0	%	
Water Absorption			
23°C, 24 hr	1.1	%	ASTM D570, ISO 62
Saturation	7.0	%	ASTM D570
Saturation, 23°C	7.0	%	ISO 62
Granule Humidity	< 0.15	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Break)	125	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	5800	MPa	ASTM D790, ISO 178
Flexural Stress			
--	150	MPa	ISO 178

Break	150	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	5.0	kJ/m ²	ASTM D256, ISO 179
Charpy Unnotched Impact Strength ²			ASTM D256, ISO 179
-20°C	25	kJ/m ²	
23°C	32	kJ/m ²	
Notched Izod Impact (23°C, 3.20 mm)	60	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	190	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ³	90.0	°C	
-- ⁴	130	°C	
-- ⁵	140	°C	
-- ⁶	180	°C	
Vicat Softening Temperature			
--	210	°C	ASTM D1525, ISO 306/A50 ⁷
--	205	°C	ASTM D1525, ISO 306/B50 ⁸
Melting Temperature	222	°C	ASTM D211, ISO 121
CLTE - Flow (-30 to 30°C)	4.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	7.0E+15	ohms·cm	ASTM D257
Dielectric Strength (2.00 mm)	22	kV/mm	ASTM D149
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 Ignition Temperature (2.00 mm)	750	°C	IEC 60695-2-13
Oxygen Index	24	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0 to 90.0	°C	
Pre-heater	80.0 to 100	°C	
Drying Time			
--	1.0	hr	
Pre-heater	3.0	hr	
Processing (Melt) Temp	230 to 250	°C	
Mold Temperature	70.0 to 90.0	°C	
Injection Rate	Moderate		
NOTE			
1.	6x4x50 mm		
2.	6x4x50 mm		

3.	20000 hrs
4.	Heat Stabilized, 20000 hrs
5.	Short Term
6.	Heat Stabilized, Short Term
7.	Rate A (50°C/h), Loading 1 (10 N)
8.	Rate A (50°C/h), Loading 2 (50 N)

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