

TAROMID B 280

Polyamide 6

Taro Plast S.p.A.

Message:

Polyamide 6, medium viscosity, general purpose grade.
Available: all colors, UV stabilized (L), heat stabilized (H), fast cycles (S) and with release agent (W).

General Information			
Additive	Heat Stabilizer		
	Mold Release		
	UV Stabilizer		
Features	Fast Molding Cycle		
	General Purpose		
	Good Mold Release		
	Good UV Resistance		
	Heat Stabilized		
	Medium Viscosity		
Uses	General Purpose		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13 to 1.14	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/1.2 kg)	13	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	1.1 to 1.6	%	
Across Flow	1.1 to 1.6	%	
Water Absorption			
23°C, 24 hr	2.0	%	ASTM D570, ISO 62
Saturation	9.0	%	ASTM D570
Saturation, 23°C	9.0	%	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	2900	MPa	ASTM D638, ISO 527-2
Tensile Strength			ASTM D638, ISO 527-2
Yield	75.0	MPa	

Break	64.0	MPa	
Tensile Elongation (Break)	100	%	ASTM D638, ISO 527-2
Flexural Modulus	2750	MPa	ASTM D790, ISO 178
Flexural Stress			
--	100	MPa	ISO 178
Yield	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	3.2	kJ/m ²	ASTM D256, ISO 179
Notched Izod Impact (23°C, 3.20 mm)	50	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	74.0	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ²	80.0	°C	
-- ³	120	°C	
Vicat Softening Temperature			
--	210	°C	ASTM D1525, ISO 306/A50 ⁴
--	200	°C	ASTM D1525, ISO 306/B50 ⁵
Ball Pressure Test (165°C)	Pass		VDE 0470
Melting Temperature	220	°C	ASTM D211, ISO 121
CLTE - Flow (-30 to 30°C)	7.0E-5 to 8.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.0E+15	ohms · cm	ASTM D257
Comparative Tracking Index (Solution A)	> 600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.970 mm)	V-2		UL 94
Glow Wire Ignition Temperature (2.00 mm)	750	°C	IEC 60695-2-13
Oxygen Index	23	%	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	220 to 240	°C	
Mold Temperature	70.0 to 80.0	°C	
Injection Rate	Moderate		
NOTE			
1.	6x4x50 mm		
2.	20000 hrs		

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

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