

Tarnamid® T-27 GF 15 MW 25

Polyamide 6

Grupa Azoty S.A.

Message:

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

General Information				
Filler / Reinforcement		Glass Fiber,15% Filler by Weight Mineral,25% 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	1.40	--	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	1.0	--	%	
Flow : 2.00 mm	0.10	--	%	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	255	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8700	--	MPa	ISO 527-2/1
Tensile Stress (Yield)	125	--	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	--	%	ISO 527-2/5
Flexural Modulus ¹	7800	--	MPa	ISO 178
Flexural Stress ²	185	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA

--	4.5	--	kJ/m ²	
-30°C	3.0	--	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
--	50	--	kJ/m ²	
-30°C	45	--	kJ/m ²	
Notched Izod Impact Strength	5.0	--	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	195	--	°C	ISO 75-2/A
Vicat Softening Temperature	210	--	°C	ISO 306/B
Melting Temperature	221	--	°C	ISO 11357-3
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, GF15MD25 --			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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