

Tarnamid® T- 27 MS

Polyamide 6

Grupa Azoty S.A.

Message:

It is low-medium viscosity general purpose polyamide 6, containing release agent.

General Information				
Additive		Mold Release		
Features		General Purpose		
		Medium-low Viscosity		
Uses		Appliances		
		Automotive Applications		
		Electrical/Electronic Applications		
		Household Goods		
Appearance		Natural Color		
		White		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	120	--	cm ³ /10min	ISO 1133
Molding Shrinkage				ISO 294-4
Across Flow : 2.00 mm	1.4	--	%	
Flow : 2.00 mm	1.4	--	%	
Water Absorption				ISO 62
Saturation, 23°C	9.5	--	%	
Equilibrium, 23°C, 50% RH	3.0	--	%	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	165	75.0	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	1500	MPa	ISO 527-2/1
Tensile Stress (Yield)	82.0	45.0	MPa	ISO 527-2/50
Tensile Strain (Break)	40	100	%	ISO 527-2/50
Flexural Modulus ¹	2300	1100	MPa	ISO 178
Flexural Stress ²	80.0	30.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method

Charpy Notched Impact Strength				ISO 179/1eA
--	5.5	13	kJ/m ²	
-30°C	3.0	--	kJ/m ²	
Notched Izod Impact Strength				ISO 180
5.0		13	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)				ISO 75-2/A
60.0		50.0	°C	
Vicat Softening Temperature				ISO 306/B
195		180	°C	
Melting Temperature				ISO 11357-3
221		--	°C	
CLTE				ISO 11359-2
Flow : 23 to 55°C	1.1E-4	--	cm/cm/°C	
Transverse : 23 to 55°C	1.2E-4	--	cm/cm/°C	
Limit of Temperature - a few hours operation				°C
< 180		--		
Temperature Index				
20000 hr	70	--	°C	
5000 hr	85	--	°C	
Burning Rate				FMVSS 302
+		--		
ISO Type				ISO 1874
PA6, MR, 14-030N		--		
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+15	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+12	ohms·cm	IEC 60093
Electric Strength (2.00 mm)	21	24	kV/mm	IEC 60243-1
Dielectric Constant (1 Hz)	3.50	4.20		IEC 60250
Dissipation Factor (1 Hz)	0.022	0.20		IEC 60250
Comparative Tracking Index (Solution A)				IEC 60112
600		600	V	
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	V-2	--		
3.20 mm	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
2.00 mm	750	--	°C	
4.00 mm	850	--	°C	
Injection	Dry	Unit		
Drying Temperature	60.0 to 80.0		°C	
Drying Time	2.0 to 4.0		hr	
Suggested Max Moisture	< 0.10		%	
Suggested Max Regrind	10		%	
Processing (Melt) Temp	240 to 260		°C	

Mold Temperature	60.0 to 80.0	°C
Injection Pressure	80.0 to 110	MPa
Injection Rate	Fast	
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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