

TAROMID B 280 R3

Polyamide 6

Taro Plast S.p.A.

Message:

Polyamide 6 elastomer modified, very high impact resistance, no conditioning required.
Available: all colours, UV stabilised (L), release agent (W).

General Information			
Additive	Mold Release		
	Unspecified Additive		
	UV Stabilizer		
Features	Good Mold Release		
	Good UV Resistance		
	Ultra High Impact Resistance		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/1.0 kg)	6.0	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	0.80	%	ASTM D570, ISO 62
Saturation	6.0	%	ASTM D570
Saturation, 23°C	6.0	%	ISO 62
Granule Humidity	< 0.10	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	50.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	75	%	ASTM D638, ISO 527-2
Flexural Modulus	1800	MPa	ASTM D790, ISO 178
Flexural Stress			
--	80.0	MPa	ISO 178
Break	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹			

23°C ²	40	kJ/m ²	ASTM D256
23°C	40	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-25°C, 3.20 mm	480	J/m	ISO 180, ASTM D256
23°C, 3.20 mm	500	J/m	ISO 180, ASTM D256
23°C ³	> 35	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	60.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	170	°C	ISO 306/B50, ASTM D1525 ⁴
Melting Temperature	218	°C	ASTM D211, ISO 121
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	5.0E+15	ohms·cm	ASTM D257
Dielectric Strength (2.00 mm)	18	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
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 250	°C	
Mold Temperature	70.0 to 80.0	°C	
Injection Rate	Moderate		
NOTE			
1.	4 mm		
2.	Type 1, Edgewise, Notch A		
3.	4 mm		
4.	Rate A (50°C/h), Loading 2 (50 N)		

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