

TAROMID A 280

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity, general purpose.
Available: all colors, lubricated (W), heat stabilized (H) and UV-stabilized (L), laser printable (LP)improved glyco-hydrolysis stability (I).

General Information			
Additive	Heat Stabilizer		
	Lubricant		
	UV Stabilizer		
Features	General Purpose		
	Good UV Resistance		
	Heat Stabilized		
	Hydrolysis Resistant		
	Laser Markable		
	Lubricated		
	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 1.15	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/1.2 kg)	30	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	1.6 to 2.2	%	
Across Flow	1.6 to 2.5	%	
Water Absorption			
23°C, 24 hr	1.0	%	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)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ASTM D638, ISO 527-2
Tensile Strength			ASTM D638, ISO 527-2

Yield	88.0	MPa	
Break	85.0	MPa	
Tensile Elongation (Break)	60	%	ASTM D638, ISO 527-2
Flexural Modulus	3100	MPa	ASTM D790, ISO 178
Flexural Stress			
--	130	MPa	ISO 178
Break	130	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	4.0	kJ/m ²	ASTM D256, ISO 179
Charpy Unnotched Impact Strength ²			ISO 179, ASTM D256
-20°C	> 300	kJ/m ²	
23°C	> 300	kJ/m ²	
Notched Izod Impact			ISO 180, ASTM D256
-20°C, 3.20 mm	30	J/m	
23°C, 3.20 mm	42	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	90.0	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ³	90.0	°C	
-- ⁴	120	°C	
-- ⁵	130	°C	
-- ⁶	160	°C	
Vicat Softening Temperature			
--	254	°C	ASTM D1525, ISO 306/A50 ⁷
--	240	°C	ASTM D1525, ISO 306/B50 ⁸
Ball Pressure Test (165°C)	Pass		VDE 0470
Melting Temperature	256	°C	ASTM D211, ISO 121
CLTE - Flow (-30 to 30°C)	8.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	9.0E+15	ohms · cm	ASTM D257
Dielectric Strength (2.00 mm)	24	kV/mm	ASTM D149
Comparative Tracking Index			IEC 60112
Solution A	> 600	V	
Solution B	600	V	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Ignition Temperature (2.00 mm)	750	°C	IEC 60695-2-13
Oxygen Index	26	%	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	250 to 280	°C
Mold Temperature	70.0 to 90.0	°C
Injection Rate	Moderate	

NOTE

- | | |
|----|-----------------------------------|
| 1. | 6x4x50 mm |
| 2. | 6x4x50 mm |
| 3. | 20000 hrs |
| 4. | Short Term |
| 5. | Heat Stabilized, 20000 hrs |
| 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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