

TAROMID A 280 H G6 X0

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity, 30% glass fiber reinforced, UL94 V0 self extinguishing, heat stabilized, very good flame proofing also at low thickness. High mechanical and thermal properties, low shrinkage and high dimensional stability, high tracking resistance. Material PBDE/PBDF free. UL94 V0 approved - All color at 0,88 mm - NC,BK, thickness 0,75 mm - UL 746B approved - CTI UL94 class 1. Available: different colors, release agent (W).

General Information			
UL YellowCard	E143048-223241		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
	Mold Release		
Features	Flame Retardant		
	Good Dimensional Stability		
	Good Mold Release		
	Heat Stabilized		
	Low Shrinkage		
	Medium Viscosity		
	Self Extinguishing		
	Tracking Resistant		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56 to 1.58	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 3.20 mm	0.30 to 0.50	%	
Across Flow : 3.20 mm	0.45 to 0.75	%	
Water Absorption			ASTM D570, ISO 62
23°C, 24 hr	0.50	%	
Saturation, 23°C	4.5	%	
Granule Humidity	< 0.15	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Break)	145	MPa	ASTM D638, ISO 527-2

Tensile Elongation (Break)	2.2	%	ASTM D638, ISO 527-2
Flexural Modulus	9000	MPa	ASTM D790, ISO 178
Flexural Stress			
--	200	MPa	ISO 178
Break	200	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	7.2	kJ/m ²	ASTM D256, ISO 179
Notched Izod Impact (23°C, 3.20 mm)	75	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	240	°C	ASTM D648
1.8 MPa, Unannealed	240	°C	ISO 75-2/A
Continuous Use Temperature			
-- ²	100	°C	UL 746B
-- ³	120	°C	UL 746B
-- ⁴	140	°C	UL 746B
-- ⁵	140	°C	UL 746B
-- ⁶	140	°C	UL 746B
-- ⁷	180	°C	IEC 60216
Vicat Softening Temperature	242	°C	ISO 306/B50, ASTM D1525 8
Ball Pressure Test (205°C)	Pass		VDE 0470
Melting Temperature	250 to 256	°C	ASTM D211, ISO 121
CLTE - Flow (-30 to 30°C)	2.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength (2.00 mm)	26	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	> 400	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm, Natural, Black	V-0		
0.880 mm, All Colors	V-0		
Glow Wire Flammability Index (1.20 mm)	850	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (1.20 mm)	775	°C	IEC 60695-2-13
Oxygen Index	30	%	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	260 to 270	°C
Mold Temperature	80.0 to 110	°C
Injection Rate	Moderate	

NOTE

1.	6x4x50 mm
2.	M. with imp.0,75 mm
3.	M. with imp. 3 mm
4.	E. 0,75 mm
5.	M. w/o imp. 3 mm
6.	M. w/o imp.0,75 mm
7.	Short Term
8.	Rate B (120°C/h), Loading 2 (50 N)

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