

TEKAMID™ TA250GM

Polyamide 66

Mando Advanced Materials Co., Ltd.

Message:

TA250GM is GF/MF 40% reinforced PA66. TA250GM has good properties with good mechanical properties.

General Information			
Filler / Reinforcement	Glass \mineral, 40% filler by weight		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.70	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	123	MPa	ASTM D638
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Flexural Modulus ³	8340	MPa	ASTM D790
Flexural Strength ⁴	186	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	238	°C	ASTM D648
Peak Melting Temperature	260	°C	ASTM D3418
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 5.0	hr	
Rear Temperature	260 - 270	°C	
Middle Temperature	270 - 285	°C	
Front Temperature	270 - 295	°C	
Nozzle Temperature	270 - 295	°C	
Processing (Melt) Temp	270 - 295	°C	
Mold Temperature	80.0 - 100	°C	
Injection instructions			
Injection Speed: 40 to 70%Injection Pressure - 1st: 20 to 50%Injection Pressure - 2nd: 20 to 50%Injection Pressure - Back Pressure: 0 to 20%			
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		

3.	3.0 mm/min
4.	3.0 mm/min

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