

TAROMID A 280 G10

Polyamide 66
Taro Plast S.p.A.

Message:

Polyamide 66 medium viscosity glass fiber reinforced 50%, high mechanical and thermal properties, very high rigidity, very low shrinkage.
UL94 HB approved at 0,75 mm - NC
Available: all colors, UV stabilized (L), heat stabilised (H), release agent (W).

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Additive	Heat Stabilizer		
	Mold Release		
	UV Stabilizer		
Features	Good Mold Release		
	Good UV Resistance		
	Heat Stabilized		
	High Rigidity		
	Low Shrinkage		
	Medium Viscosity		
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
Melt Mass-Flow Rate (MFR) (280°C/2.16 kg)	5.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	0.15 to 0.25	%	
Across Flow	0.30 to 0.50	%	
Water Absorption			
23°C, 24 hr	0.50 to 0.60	%	ASTM D570, ISO 62
Saturation	3.0	%	ASTM D570
Saturation, 23°C	3.0	%	ISO 62
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	15500	MPa	ASTM D638, ISO 527-2
Tensile Strength (Break)	220	MPa	ASTM D638, ISO 527-2

Tensile Elongation (Break)	1.5	%	ASTM D638, ISO 527-2
Flexural Modulus	15000	MPa	ASTM D790, ISO 178
Flexural Stress			
--	310	MPa	ISO 178
Break	310	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹ (23°C)	16	kJ/m ²	ASTM D256, ISO 179
Charpy Unnotched Impact Strength ²			ISO 179, ASTM D256
-20°C	45	kJ/m ²	
23°C	70	kJ/m ²	
Notched Izod Impact (23°C, 3.20 mm)	150	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	250	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature			IEC 60216
-- ³	110	°C	
-- ⁴	130	°C	
-- ⁵	140	°C	
-- ⁶	180	°C	
Vicat Softening Temperature	255	°C	ISO 306/A50, ASTM D1525 ⁷
Ball Pressure Test (165°C)	Pass		VDE 0470
Melting Temperature	256	°C	ASTM D211, ISO 121
CLTE - Flow (-30 to 30°C)	1.5E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	8.0E+15	ohms · cm	ASTM D257
Dielectric Strength (2.00 mm)	28	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	550	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	HB		UL 94
Glow Wire Ignition Temperature (2.00 mm)	750	°C	IEC 60695-2-13
Oxygen Index	27	%	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	270 to 300	°C	
Mold Temperature	80.0 to 120	°C	
Injection Rate	Fast		
NOTE			

1.	6x4x50 mm
2.	6x4x50 mm
3.	20000 hrs
4.	Heat Stabilized, 20000 hrs
5.	Short Term
6.	Heat Stabilized, Short Term
7.	Rate A (50°C/h), Loading 1 (10 N)

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

