



DATA SHEET

TAROMID B 280 S

Polyamide 6 medium viscosity, general purpose grade, fast cycles.

Available: natural colour.

	DRYING - conditions	Melt temperature:	220 - 240°C
Pre-heater:	80 - 100°C / 3 h	Mould temperature:	70 - 80°C
Dryer:	80 - 90°C / 1 h	Rate of injection:	MEDIUM

PROPERTY	METHOD	unit	VALUE	condition
ELECTRICAL				
Volume Resistivity	IEC 60093	Ohm cm	5x10exp(15)	
Dielectric Constant	IEC 60250	-	3,60	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600	
Tracking Resistance (CTI - Method B)	IEC 60112	Volt	600M	
Electric Strength	IEC 60243-1	kV/mm	18	2 mm
PHYSICAL				
Melt Flow Rate (MFR)	ISO 1133	g/10 min	12	250°C - 1,2 kg
Granule Humidity	TARO 002	%	<0,15	
Density (23 °C)	ISO 1183	g/cm ³	1,13-1,14	
Water Absorption (24h / 23°C)	ISO 62	%	2	
Water Absorption at Saturation	ISO 62	%	9	
Mould Shrinkage (Parallel)	Internal method	%	1,1-1,6	
Mould Shrinkage (Normal)	Internal method	%	1,1-1,6	
Melting temperature (DSC)	ISO 11357	°C	220	
MECHANICAL				
IZOD Notched Impact	ASTM D256	J/m	50	+23°C
Tensile Modulus	ISO 527-1,2	Mpa	2900	Speed 1 mm/min
Flexural Modulus	ISO 178	Mpa	2800	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	100	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	Mpa	64	Speed 50 mm/min
Tensile Yield Strength	ISO 527-1,2	Mpa	75	Speed 50 mm/min
Flexural Max Strength	ISO 178	Mpa	110	Speed 1 mm/min
CHARPY Unnotched Impact (-25°C)	ISO 179/1eU	KJ/m ²	N.B.	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	KJ/m ²	3,2	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	KJ/m ²	N.B.	
FLAMMABILITY				
Oxygen index	ASTM D2863	%	23	
Flame Behaviour (0,97 mm)	UL94	Class	V2	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	750	
THERMAL				
Softening Temperature - 1 kg (VST/A/50)		°C	210	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	200	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	74	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	165	

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PROPERTY	METHOD	unit	VALUE	condition
Continuous service temperature (20.000 h)	IEC 60216	°C	80	
Continuous service temperature (short term)	IEC 60216	°C	100	
Coefficient of linear thermal expansion	ISO 11359-1,-2	K ⁻¹	7-8x10exp(-5)	-30°C /+30°C

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