



**DATA SHEET**

**TAROMID A 280 G10**

Polyamide 66 medium viscosity 50% glass fibres reinforced, high mechanical and thermal properties, very high stiffness, very low shrinkage.

UL94 HB approved at 0,75 mm - NC (HW version only).

Available: all colours, UV stabilized (L), heat stabilized (H), high heat stabilized (HT), release agent (W), improved glycol-hydrolysis stability (I)

	<b>DRYING - conditions</b>	<b>Melt temperature:</b>	270 - 300°C
<b>Pre-heater:</b>	80 - 100°C / 3 h	<b>Mould temperature:</b>	80 - 120°C
<b>Dryer:</b>	80 - 90°C / 1 h	<b>Rate of injection:</b>	HIGH

PROPERTY	METHOD	unit	VALUE	condition
<b>ELECTRICAL</b>				
Volume Resistivity	IEC 60093	Ohm cm	<b>8x10exp(15)</b>	
Dielectric Constant	IEC 60250	-	<b>4,10</b>	
Tracking Resistance ( CTI - Method A )	IEC 60112	Volt	<b>550</b>	
Electric Strength	IEC 60243-1	kV/mm	<b>28</b>	2 mm
<b>PHYSICAL</b>				
Melt Flow Rate (MFR)	ISO 1133 - ASTM D1238	g/10 min	<b>5</b>	280°C - 2,16 kg
Reinforcing Charges	ISO 3451	%	<b>50</b>	750°C - 1 h
Granule Humidity	Internal method	%	<b>&lt;0,15</b>	
Density ( +23°C )	ISO 1183	g/cm <sup>3</sup>	<b>1,56-1,58</b>	
Water Absorption ( 24h / +23°C )	ISO 62	%	<b>0,5-0,6</b>	
Water Absorption at Saturation	ISO 62	%	<b>3</b>	
Mould Shrinkage (Parallel)	Internal method	%	<b>0,15-0,25</b>	+23°C - 3,2 mm
Mould Shrinkage (Normal)	Internal method	%	<b>0,3-0,5</b>	+23°C - 3,2 mm
Melting temperature (DSC)	ISO 11357	°C	<b>256</b>	
<b>MECHANICAL</b>				
IZOD Notched Impact	ASTM D256	J/m	<b>150</b>	+23°C
Tensile Modulus	ISO 527-1,2	Mpa	<b>15500</b>	Speed 1 mm/min
Flexural Modulus	ISO 178	Mpa	<b>15000</b>	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	<b>2,5</b>	Speed 50 mm/min
Flexural Break Strength	ISO 178	Mpa	<b>310</b>	Speed 1 mm/min
Tensile Break Strength	ISO 527-1,2	Mpa	<b>220</b>	Speed 50 mm/min
CHARPY Unnotched Impact (-25°C)	ISO 179/1eU	kJ/m <sup>2</sup>	<b>48</b>	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	<b>16</b>	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	<b>90</b>	
<b>FLAMMABILITY</b>				
Oxygen index	ASTM D2863	%	<b>27</b>	
Flame Behaviour (0,75 mm)	UL94	Class	<b>HB</b>	UL approved
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	<b>750</b>	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	<b>&lt;100</b>	
<b>THERMAL</b>				

These value are for natural color only. Colorant or other additives may alter some or all of these property. The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits nor used alone as the basis of design.



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PROPERTY	METHOD	unit	VALUE	condition
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	<b>255</b>	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	<b>250</b>	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	<b>230</b>	
Continuous service temperature (20.000 h)	UL746 B	°C	<b>110 (H 130)</b>	
Continuous service temperature (short term)	UL746 B	°C	<b>140 (H 180)</b>	
Coefficient of linear thermal expansion	ISO 11359-1,-2	K <sup>-1</sup>	<b>1,5x10exp(-5)</b>	-30°C /+30°C

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