DATA SHEET

TAROMID B 280 G3 K3

Polyamide 6 fibers/beads 30% reinforced, good dimensional stability combined to good mechanical properties.

Available: all colors, UV stabilized (L), heat stabilized (H), release agent (W).

	DRYING - conditions		
Pre-heater:	80 - 100°C - 3 h	**Melt temperature:**	220 - 250°C
Dryer:	80 - 90°C - 1 h	**Mould temperature:**	80 - 100°C
		Rate of injection:	MEDIUM

PROPERTY	METHOD	DIN	ISO	ASTM	unit	VALUE	condition
ELECTRICAL							
Volume Resistivity		5348		D257	Ohm cm	***7x10exp(15)***	
Tracking Resistance (CTI - Method A)	IEC 112				Volt	***550***	
PHYSICAL							
Melt Flow Index		5373	R292	D123	g/10'	***15***	250°C - 2,16 Kg
Reinforcing Charges				D258	%	***30***	750°C - 1 h
Granule Humidity	TARO 002				%	***<0,10***	
Density (23 °C)		5347	R118	D792	Mg/m^3	***1,35-1,37***	
Water Absorption (24h / 23°C)		5349	R62	D570	%	***0,94***	
Water Absorption at Saturation		5349	R62	D570	%	***6,5***	
Mould Shrinkage (Parallel)				D955	%	***0,30-0,40***	
Mould Shrinkage (Normal)				D955	%	***0,60-0,80***	
Melting Point			R121	D211	°C	***222***	
MECHANICAL							
IZOD Notched Impact		-	180	D256	J/m	***60***	+23°C - 3,2 mm
CHARPY Notched Impact		5345	R179	D256	kJ/m^2	***5,5***	+23°C - 6x4x50 mm
Tensile Modulus		5345	R527	D638	N/mm^2	***6000***	
Flexural Modulus		5345	R178	D790	N/mm^2	***6500***	
Elongation at Break		5345	R527	D638	%	***5***	
Flexural Break Strength		5345	R178	D790	N/mm^2	***160***	
Tensile Break Strength		5345	R527	D638	N/mm^2	***118***	
ROCKWELL Hardness				D785	scala R	***115***	
FLAMMABILITY							
Oxigen index				D286	%	***24***	
Flame Behaviour (1,6 mm)	UL 94					***HB***	
Glow Wire Test (2 mm)	IEC 695-2-1				°C	***750***	
THERMAL							
VICAT Temperature (1 kg)		5346	R306	D152	°C	***206***	50°C / h
VICAT Temperature (5 kg)		5346	R306	D152	°C	***195***	50°C / h
Heat Deflection Temperature (1,82 N/mm^2)		5346	R75	D648	°C	***185***	120°C / h
Ball Pressure Test	VDE 0470				°C	***165***	
Continuous service temperature (20.000 h)	IEC 216				°C	***80***	
Continuous service temperature (short term)	IEC 216				°C	***120***	
Coefficient of linear thermal expansion		5375		D696	K^-1	***3,8x10exp(-5)***	-30°C /+30°C

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.