



PRODUCT INFORMATION

## TAROMID B 240 MT2 Y2

Polyamide 6 medium low viscosity 10% mineral filled, halogen free flame retardant UL94 V2, good flame proofing also at low thicknesses, good flow and good mechanical properties. Very high CTI value.

**ISO short** ISO 1043: PA6-MD10 FR(30)  
**Form** Pellets  
**UL file** E143048

### Key Features

- Designed for injection moulding applications
- Halogen free
- Flame retardant
- Good flowability
- Mineral filled
- Antimony trioxide free

### Compliance

- UL94 V2 approved all colours at 0,97 and 1,5 mm. UL746 B approved.

### Availability

- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- All colours

### Process

- INJECTION MOULDING

### Application

- Electronic
- Electrical

Property	Method	Unit	Value	Condition	State
<b>ELECTRICAL</b>					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,23		
Filler content	ISO 3451	%	10	850°C - 1 h	
Granule Humidity	Internal method	%	<0,10		
Water Absorption (24h / +23°C)	ISO 62	%	2,0		
Water Absorption at Saturation	ISO 62	%	6,5		
Mould Shrinkage (Parallel)	Internal method	%	0,7		
Mould Shrinkage (Normal)	Internal method	%	0,8		

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design. Values are valid for natural coloured version only.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

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Melting temperature (DSC)	ISO 11357	°C	222	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	12	250°C - 2,16 kg

**MECHANICAL**

Tensile Modulus	ISO 527-1,2	MPa	4100	Speed 1 mm/min	Dry
Elongation at Break	ISO 527-1,2	%	4,0	Speed 50 mm/min	Dry
Tensile Break Strength	ISO 527-1,2	MPa	72	Speed 50 mm/min	Dry
Flexural Modulus	ISO 178	MPa	3800	Speed 1 mm/min	Dry
Flexural Break Strength	ISO 178	MPa	110	Speed 1 mm/min	Dry
IZOD Notched Impact	ASTM D256	J/m	35	+23°C	Dry
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m <sup>2</sup>	3,5		Dry
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	2,5		Dry
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	30		Dry

**THERMAL**

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	200	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	160	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	170	

**FLAMMABILITY**

Flame Behaviour (0,97 mm)	UL94	Class	V2	UL approved
Flame Behaviour (1,5 mm)	UL94	Class	V2	UL approved
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	960	
Glow Wire Ignition Temperature-GWIT (1 mm)	IEC 60695-2-13	°C	775	

**INJECTION MOULDING**

	Value
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,08 %
Suggested Max Re grind	< 10 %
Melt Temperature	230 - 260°C
Feed Temperature	210°C

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Rear Temperature	235°C
Middle Temperature	245°C
Front Temperature	255°C
Nozzle Temperature	250°C
Mould Temperature	70 - 100°C
Injection Rate	Medium to Fast
Injection Pressure	3 - 12 Mpa
Packing Pressure	5 - 15 Mpa
Screw Revolving Speed	50 rpm @ Diameter 40 mm
Screw Revolving Speed	35 rpm @ Diameter 55 mm
Screw Revolving Speed	25 rpm @ Diameter 75 mm
Cushion	> 3 mm
Screw L/D Ratio	18 - 22
Screw Compression Ratio	2:1 - 2,5:1
Vent Depth	0,02 mm

**Notes** During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.

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