

# RILSAMID® AMN BLACK T6LD

PA12, MHLR, 12-010

Rilsamid® AMN BLACK T6LD resin is a black colored polyamide 12. This grade is designed for injection molding.

PROPERTIES	DRY / COND	UNIT	TEST STANDARD
<b>RHEOLOGICAL PROPERTIES</b>			
Melt Volume-Flow Rate	57 / *	cm <sup>3</sup> /10 min	ISO 1133
Temperature	235 / *	°C	-
	455 / *	°F	
Load	2.16 / *	kg	-
	4.76 / *	lb	
Molding Shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
Molding Shrinkage, normal	1.8 / *	%	ISO 294-4, 2577
<b>MECHANICAL PROPERTIES</b>			
Tensile Modulus	- / 1440	MPa	ISO 527-1/-2
	- / 209000	psi	
Yield Stress	- / 46	MPa	ISO 527-1/-2
	- / 6670	psi	
Yield Strain	- / 6	%	ISO 527-1/-2
Nominal Strain at Break	- / >50	%	ISO 527-1/-2
Shore D Hardness, after 15 s	69 / *	-	ISO 868
Charpy Impact Strength, +23°C	- / No Break	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy Impact Strength, -30°C	- / No Break	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy Notched Impact Strength, +23°C	- / 4	kJ/m <sup>2</sup>	ISO 179/1eA
	- / 1.9	ftlb/in <sup>2</sup>	
Charpy Notched Impact Strength, -30°C	- / 5	kJ/m <sup>2</sup>	ISO 179/1eA
	- / 2.38	ftlb/in <sup>2</sup>	
<b>THERMAL PROPERTIES</b>			
Melting Temperature, 10°C/min	178 / *	°C	ISO 11357-1/-3
<b>OTHER PROPERTIES</b>			
Density	1020 / -	kg/m <sup>3</sup>	ISO 1183
	1.02 / -	g/cm <sup>3</sup>	

## APPLICATION PROPERTIES

### Shelf life:

Two years from the date of delivery, For any use above this limit please refer to our technical services.

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## Processing conditions, Injection:

- Typical melt temperature (Min / Recommended / Max) : 230°C / 250°C / 270°C.
- Mold temperature : 20 - 40°C
- Drying time and temperature (only necessary for bags opened for more than two hours) : 4-6 hours at 80 - 90°C.

<b>PROCESSING</b>	Headquarters: Arkema France 420 rue d'Estienne d'Orves 92705 Colombes Cedex France T +33 (0)1 49 00 80 80 hpp.arkema.com
Injection Molding	
<b>DELIVERY FORM</b>	
Pellets	
<b>ADDITIVES</b>	Arkema Inc. – High Performance Polymers 900 First Avenue King of Prussia, PA 19406 Tel.: +1 610 205 7000 hpp.arkema.com
Release agent	
<b>SPECIAL CHARACTERISTICS</b>	
Heat Stabilized, Light Stabilized	
<b>REGIONAL AVAILABILITY</b>	
North America, Europe, Asia Pacific, South and Central America, Near East/Africa	

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