

Rilsamid™ PA 12 G **AMNO TLD** is a natural polyamide. This grade is designed for injection molding.

GENERAL PROPERTIES	METHOD	UNIT	TYPICAL VALUES
Nature & designation	ISO 1874	-	PA12, MHLR, 12-010
Density	ISO 1183	g/cm ³	1.02
Melting point	ISO 11357	°C	178
Melt Volume Index (235°C, 2.16 kg)	ISO 1133	cm ³ /10min	57
Shrinkage (after 24h, 2 mm, mold at 30°C) // ⊥	Internal method	% %	0.8 0.8
Hardness shore (*) after 15	ISO 868	Shore D	72
Tensile test (*) stress at yield strain at yield stress at break strain at break	ISO 527	MPa % MPa %	38 7 64 > 200
Flexural modulus (*)	ISO 178	MPa	1230
Charpy impact unnotched 23°C unnotched -30°C notched 23°C notched -30°C	ISO 179/1eU " ISO 179/1eA "	kJ/m ² " " "	No break No break 9 5

(*) Samples conditioned 15 days, 23°C - 50 % R.H.

PROCESSING CONDITIONS	TYPICAL VALUES
Drying (*) : time / temperature	4-6 hours / 80-90°C
Injection Temperature : min / recommended / max	230°C / 270°C / 290°C
Mold Temperature :	20-40°C

(*) Rilsamid™ is delivered dried in sealed packaging ready to be processed. Drying is only necessary for bags opened for more than 2 hours.

DPT/TDS/10278/October 2010

The information contained in this document is based on trials carried out by our Research Centres and data selected from the literature, but shall in no event be held to constitute or imply any warranty, undertaking, express or implied commitment from our part. Our formal specifications define the limit of our commitment. No liability whatsoever can be accepted by Arkema with regard to the handling, processing or use of the product or products concerned which must in all cases be employed in accordance with all relevant laws and/or regulations in force in the country or countries concerned.