

Rilsamid® PA 12 G **AESN Black P401TL** is a black coloured polyamide 12. This grade is plasticized and designed for tube extrusion.

GENERAL PROPERTIES	METHOD	UNIT	TYPICAL VALUES
Nature & designation	ISO 1874	-	PA12- P, EHL, 22-004
Density	ISO 1183	-	1.03
Melting point	ISO 11357	°F (°C)	356 (180)
Melt Volume Index (455°F (235°C) , 2.16kg)	ISO 1133	cm ³ /10min	8
Hardness (*) instantaneous after 15 s	ISO 868	Shore D "	69 61
Tensile test (*) stress at break strain at break	ISO 527	psi (MPa) %	6,380 (44) > 200
Tensile modulus (*)	ISO 527	psi (MPa)	50,000 (345)
Flexural modulus (*)	ISO 178	psi (MPa)	47,900 (330)
Charpy impact (*) unnotched 73°F (23°C) unnotched -22°F (-30°C) notched 73°F (23°C) notched -22°F (-30°C)	ISO 179/1eU " ISO 179/1eA "	ft-lb/in ² (kJ/m ²) " " "	No break No break No break 2.38 (5)

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

PROCESSING CONDITIONS	TYPICAL VALUES
Drying (*): time / temperature	4-6 hours / 176°F (80°C)
Extrusion temperature: min / recommended / max	374°F / 410°F / 446°F 190°C / 210°C / 230°C

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

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