

Rilsamid™ PA 12 G **AMNO P20 TLD** is a natural polyamide. This grade is plasticized and designed for injection molding.

GENERAL PROPERTIES	METHOD	UNIT	TYPICAL VALUES
Nature & designation	ISO 1874	-	PA12-P, MHLR, 12-005
Density	ISO 1183	g/cm <sup>3</sup>	1.02
Melting point	ISO 11357	°C	174
Melt Volume Index (235°C, 2.16 kg)	ISO 1133	cm <sup>3</sup> /10min	57
Shrinkage (after 24h, 2 mm, mold at 30°C) // ⊥	Internal method	%	1.1
		%	1.0
Hardness shore (*) instantaneous after 15 s	ISO 868	Shore D	69
		"	62
Tensile test (*) stress at yield strain at yield stress at break strain at break	ISO 527	MPa	29
		%	20
		MPa	58
		%	> 200
Tensile modulus (*)	ISO 527	MPa	545
Flexural modulus (*)	ISO 178	MPa	500
Charpy impact unnotched 23°C unnotched -30°C notched 23°C notched -30°C	ISO 179/1eU	kJ/m <sup>2</sup>	No break
	"	"	No break
	ISO 179/1eA	"	14
	"	"	3

(\*) 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 / 250°C / 270°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.

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