

**Product Texts**

ISO 16396 - PA12, GF23, M1GHLR, 16-060

**Rilsamid® AZM 23 BLACK T6LD resin** is a fiberglass reinforced polyamide.

This black colored grade is designed for injection moulding.

**Packaging:**

This grade is delivered dried in sealed packaging (25 kg bags / 450 kg rigid containers) ready to be processed

**Shelf life:**

Two years from the delivery.

For any use above this limit please refer to our technical services.

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	<b>13 / *</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>235 / *</b>	°C	-
Load	<b>5 / *</b>	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	<b>0.2 / *</b>	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	<b>0.4 / *</b>	%	ISO 294-4, 2577

[C]: CAMPUS

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>5500 / 5070</b>	MPa	ISO 527
<sup>[C]</sup> Stress at break	<b>95 / 100</b>	MPa	ISO 527
<sup>[C]</sup> Strain at break	<b>5 / 5.2</b>	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	<b>66 / 77</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	<b>66 / 83</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	<b>15 / 19</b>	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	<b>8 / 12</b>	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	<b>179 / *</b>	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	<b>165 / *</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	<b>173 / *</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	<b>165 / *</b>	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	<b>60 / *</b>	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

<b>Electrical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	<b>5 / -</b>	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	<b>5 / -</b>	-	IEC 62631-2-1

**Rilsamid® AZM 23 BLACK T6LD**

PA12-GF23

ARKEMA

[C] Dissipation factor, 100Hz	<b>1170 / -</b>	E-4	IEC 62631-2-1
[C] Dissipation factor, 1MHz	<b>364 / -</b>	E-4	IEC 62631-2-1

[C]: CAMPUS

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
[C] Water absorption	<b>1.3 / *</b>	%	Sim. to ISO 62
[C] Humidity absorption	<b>0.5 / *</b>	%	Sim. to ISO 62
[C] Density	<b>1180 / 1170</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Black

**Additives**

Release agent

**Special Characteristics**

Light stabilized or stable to light, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

**Other text information****Injection molding****Processing conditions:**

- Typical melt temperature (Min / Recommended / Max) : 250°C / 265°C / 280°C.
- Typical mold temperature : 40 – 90°C.
- Drying time and temperature (only necessary for bags opened for more than two hours) : 4-8 hours at 80-90°C.