

Product Texts

ISO 16396 - PA12, GF50, M1GHLR, C16-120

Rilsamid® AZM 50 BLACK T6LD resin is a fiberglass reinforced polyamide.
This black colored grade is designed for injection molding.

Packaging :

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

Shelf life :

Two years from the delivery.

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

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	6 / *	cm ³ /10min	ISO 1133
Temperature	235 / *	°C	-
Load	5 / *	kg	-
^[C] Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	12000 / 12100	MPa	ISO 527
^[C] Stress at break	152 / 144	MPa	ISO 527
^[C] Strain at break	4.6 / 4.9	%	ISO 527
^[C] Charpy impact strength, +23°C	84 / 80	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	90 / 84	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	22 / 21	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	15 / 15	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	175 / *	°C	ISO 11357-1/-3

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1470 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics**Processing**

Injection Molding

Delivery form

Granules, Black

Additives

Release agent

Special Characteristics

Light stabilized or stable to light, Heat stabilized or stable to heat

Regional Availability

North America, Europe, Asia Pacific, South and Central America

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.