

Product Texts

PA11/10T,,M,C16-020

Rilsan® HT CMNO is a polyphthalamide produced from a renewable source.

Main applications:

- Glass fiber compound for electronic
- automotive & transportation applications etc
- Filament

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	10 / *	cm ³ /10min	ISO 1133
Temperature	255 / *	°C	-
Load	2.16 / *	kg	-
^[C] Molding shrinkage, parallel	1.3 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.2 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	- / 2400	MPa	ISO 527
^[C] Yield stress	- / 64	MPa	ISO 527
^[C] Yield strain	- / 4	%	ISO 527
^[C] Charpy impact strength, +23°C	- / 38	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	- / 59	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	- / 6	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	- / 8	kJ/m ²	ISO 179/1eA
^[C] Shore D hardness	81 / *	-	ISO 7619-1

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	255 / *	°C	ISO 11357-1/-3
^[C] Glass transition temperature, 10°C/min	82 / *	°C	ISO 11357-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1100 / -	kg/m ³	ISO 1183
Biobased content	65	%	-

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	4 - 8	h	-
Melt temperature	270 - 300	°C	-

Mold temperature **80 - 110** °C -

Characteristics

Processing

Injection Molding, Profile Extrusion, Other Extrusion

Certifications

Contains renewable resources

Delivery form

Pellets

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) : 270°C / 280°C / 300°C.
- Typical mold temperature : 80 - 110°C.
- Drying time and temperature (only for bags opened for more than two hours) : 4 - 8 hours at 100 - 110°C.

Profile extrusion

Processing conditions :

- Typical melt temperature (Min / Recommended / Max) : 270°C / 280°C / 290°C.
- Drying time and temperature (only for bags opened for more than two hours) : 8 - 12 hours at 70 °C.