

**Product Texts**

PA12-P, MHLR, 12-005

Rilsamid® AMN BLACK P20 TLD resin is a black colored polyamide. This grade is plasticized and designed for injection molding.

**Processing/Physical Characteristics**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	44 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	235 / *	°C	-
Load	2.16 / *	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	1.9 / *	%	ISO 294-4, 2577

[C]: CAMPUS

**Mechanical properties**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	- / 550	MPa	ISO 527
<sup>[C]</sup> Yield stress	- / 31	MPa	ISO 527
<sup>[C]</sup> Yield strain	- / 19	%	ISO 527
<sup>[C]</sup> Nominal strain at break	- / >50	%	ISO 527
<sup>[C]</sup> Charpy notched impact strength, +23°C	- / 18	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	- / 4	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

**Thermal properties**

	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	174 / *	°C	ISO 11357-1/-3

[C]: CAMPUS

**Other properties**

	dry / cond	Unit	Test Standard
<sup>[C]</sup> Density	1020 / 1020	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Black

**Additives**

Release agent, Plasticizer

**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, Injection:**

- Typical melt temperature (Min / Recommended / Max) : 250°C / 270°C / 290°C.
- Mold temperature : 20 - 40°C
- Drying time and temperature (only necessary for bags opened for more than two hours) : 4-6 hours at 80 - 90°C.