

Product Texts

PA12-P, MHLR, 12-004

Rilsamid® AMN BLACK P40 TLD resin is a black colored polyamide. This black grade is plasticized and designed for injection molding.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	51 / *	cm ³ /10min	ISO 1133
Temperature	235 / *	°C	-
Load	2.16 / *	kg	-
^[C] Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.9 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	- / 460	MPa	ISO 527
^[C] Yield stress	- / 24	MPa	ISO 527
^[C] Yield strain	- / 26	%	ISO 527
^[C] Nominal strain at break	- / >50	%	ISO 527
^[C] Charpy notched impact strength, +23°C	- / 25	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	- / 4	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	172 / *	°C	ISO 11357-1/-3

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1040 / 1040	kg/m ³	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) : 230°C / 250°C / 270°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.