+135-3858-6433 (GuangDong)
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RILSAMID®

TECHNICAL DATA SHEET

RILSAMID® AMNO P20 TLD

POLYAMIDE 12 PELLET

RILSAMID® AMNO P20 TLD is a polyamide 12 compound. This natural plasticized grade is designed for injection molding.

Designation : ISO 16396 - PA12-P, M1G1HLR, C12-005

TYPE

PA12-P

MAIN APPLICATIONS

- Industry - Distribution
- Auto - Fluid Connectors
- Auto - Others Injection

DELIVERY FORM

- Pellets

TRANSFORMATION PROCESSES

- Injection Molding

ADDITIVES

- Heat Stabilized
- Light Stabilized
- Plasticizer
- Release agent

RHEOLOGICAL PROPERTIES

PROPERTIES	VALUE	UNIT	TEST STANDARD
Melt volume flow rate (MVR), 235°C / 2.16 kg (455°F / 4.4 lb)	44	cm³/10min	ISO 1133
Shrinkage, Parallel (t+24h)	1.3	%	ISO 294-4
Shrinkage, Normal (t+24h)	1.5	%	ISO 294-4

MECHANICAL PROPERTIES

PROPERTIES	DRY / COND VALUE*	UNIT	TEST STANDARD
Charpy unnotched impact strength, 23°C (73°F)	No Break / No Break		ISO 179 1eU
Charpy unnotched impact strength, -30°C (-22°F)	No Break / No Break		ISO 179 1eU
Nominal strain at break, 23°C (73°F), 50 mm/min	> 50 / > 50	%	ISO 527-1/-2
Yield strain, 23°C (73°F), 50 mm/min	20 / 20	%	ISO 527-1/-2
Yield stress, 23°C (73°F), 50 mm/min	31 / 30	MPa	ISO 527-1/-2
Tensile modulus, 23°C (73°F), 1 mm/min	620 / 550	MPa	ISO 527-1/-2
Charpy notched impact strength, 23°C (73°F)	- / 9	kJ/m2	ISO 179 1eA
Charpy notched impact strength, -30°C (-22°F)	3 / 4	kJ/m2	ISO 179 1eA
Flexural modulus, 23°C (73°F)	- / 500	MPa	ISO 178

*DRY: Dry As Molded (DAM) if pellet / Dry if powder.
COND: Conditionned.

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THERMAL PROPERTIES

PROPERTIES	VALUE	UNIT	TEST STANDARD
Vicat softening temperature, 50N at 50°C/h	134	°C	ISO 306
Heat deflection temperature, 0.45 MPa	130	°C	ISO 75-1/-2
Heat deflection temperature, 1.8 MPa	48	°C	ISO 75-1/-2
Melting temperature, 10°C/min	173	°C	ISO 11357-1/-3

ELECTRICAL PROPERTIES

PROPERTIES	DRY / COND VALUE*	UNIT	TEST STANDARD
Surface resistivity, 23°C (73°F)	- / 1.0E+12	Ohm/sq	IEC 62631-3-2
Volumic (transversal) resistivity, 23°C (73°F)	- / 1.0E+10	Ohm.m	IEC 62631-3-1
Comparative tracking index, 23°C (73°F)	- / 600		IEC 60112
Dielectric stress, 23°C (73°F)	- / 26	kV/mm	IEC 60243-1
Relative permittivity, 100Hz	- / 8		IEC 62631-2-1
Relative permittivity, 1Mhz	- / 4		IEC 62631-2-1
Dissipation factor, 100Hz	- / 2010	E-4	IEC 62631-2-1
Dissipation factor, 1Mhz	- / 2010	E-4	IEC 62631-2-1

*DRY: Dry As Molded (DAM) if pellet / Dry if powder.
COND: Conditionned.

OTHER PROPERTIES

PROPERTIES	VALUE	UNIT	TEST STANDARD
Water absorption, 23°C (73°F), immersion, equilibrium	1.4	%	ISO 62
Specific gravity, 23°C (73°F)	1.02	g/cm³	ISO 1183-1

PACKAGING

Available packaging:
- 25 kg / 55 lb bags

SHELF LIFE

Two years from the date of delivery, when stored properly (sealed bags, appropriate moisture, UV protection and temperature). For any use above this limit, please refer to our technical services.

PROCESSING CONDITIONS:

- Typical melt temperature (Min / Recommended / Max) - Injection Molding: 210°C / 230°C / 260°C (410°F / 445°F / 500°F)
- Typical mold temperature - Injection molding: 20-60°C (70-140°F)
- Drying time and temperature: 80-90°C (175-195°F) / 4-6 hours

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DIAGRAMS