

TECHNICAL DATA SHEET

RILSAMID® AESN BLACK P302 TL

POLYAMIDE 12 PELLET

RILSAMID® AESN BLACK P302 TL is a polyamide 12 compound. This plasticized an impact-modified grade is designed for tube extrusion. It is a market standard to produce air brake tubing (HIPHL) lines.

Designation : ISO 16396 - PA12-IP, EG1HL, C22-004

DESIGNATION

PA12-IP

DELIVERY FORM

- Pellets

TRANSFORMATION PROCESSES

- Extrusion - General
- Tube Extrusion

ADDITIVES

- Heat Stabilized
- Light Stabilized
- Plasticizer

RHEOLOGICAL PROPERTIES

속성	값	테스트 표준
Melt volume flow rate (MVR), 235°C / 5 kg (455°F / 11 lb)	18 cm ³ /10min	ISO 1133

MECHANICAL PROPERTIES

속성	DRY / COND VALUE*	테스트 표준
Tensile modulus, 23°C (73°F), 1 mm/min	400 / 430 MPa	ISO 527-1/-2
Yield stress, 23°C (73°F), 50 mm/min	- / 25 MPa	ISO 527-1/-2
Yield strain, 23°C (73°F), 50 mm/min	- / 26 %	ISO 527-1/-2
Nominal strain at break, 23°C (73°F), 50 mm/min	- / > 50 %	ISO 527-1/-2
Flexural modulus, 23°C (73°F)	- / 374 MPa	ISO 178
Charpy unnotched impact strength, 23°C (73°F)	- / No Break	ISO 179 1eU
Charpy unnotched impact strength, -30°C (-22°F)	- / No Break	ISO 179 1eU
Charpy notched impact strength, 23°C (73°F)	No Break / No Break	ISO 179 1eA
Charpy notched impact strength, -30°C (-22°F)	- / 6 kJ/m ²	ISO 179 1eA

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

속성	값	테스트 표준
Melting temperature, 10°C/min	172 °C	ISO 11357-1/-3

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OTHER PROPERTIES

속성	값	테스트 표준
Specific gravity, 23°C (73°F)	1.03 g/cm ³	ISO 1183-1

PACKAGING

This grade is delivered dried in sealed packaging ready to be processed. Available packaging:

- 26 kg / 55 lb bags
- 551 kg rigid containers

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: 230°C / 250°C / 270°C (445°F / 480°F / 520°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

Headquarter: Arkema France
420, rue d'Estienne d'Orves
92705 Colombes Cedex – France
T +33 (0)1 49 00 80 80

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