

## TECHNICAL DATA SHEET

# RILSAMID® AMN BLACK T6LD

## POLYAMIDE 12 PELLET

RILSAMID® AMN BLACK T6LD is a polyamide 12 compound. This grade is designed for injection molding.

Designation : ISO 16396 - PA12, M1G1HLR, C12-010

### DESIGNATION

PA12

### DELIVERY FORM

- Pellets

### TRANSFORMATION PROCESSES

- Injection Molding

### ADDITIVES

- Heat Stabilized
- Light Stabilized
- Release agent

## RHEOLOGICAL PROPERTIES

| 속성  | 값                         | 테스트 표준    |
|---|---------------------------|-----------|
| Shrinkage, Parallel (t+24h)                                   | 1.9 %                     | ISO 294-4 |
| Shrinkage, Normal (t+24h)                                     | 1.8 %                     | ISO 294-4 |
| Melt volume flow rate (MVR), 235°C / 2.16 kg (455°F / 4.4 lb) | 57 cm <sup>3</sup> /10min | ISO 1133  |

## MECHANICAL PROPERTIES

| 속성  | DRY / COND VALUE*       | 테스트 표준       |
|---|-------------------------|--------------|
| Hardness, Shore D, 15 s                         | - / 69                  | ISO 868      |
| 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  |
| Nominal strain at break, 23°C (73°F), 50 mm/min | - / > 50 %              | ISO 527-1/-2 |
| Yield strain, 23°C (73°F), 50 mm/min            | - / 6 %                 | ISO 527-1/-2 |
| Yield stress, 23°C (73°F), 50 mm/min            | - / 46 MPa              | ISO 527-1/-2 |
| Tensile modulus, 23°C (73°F), 1 mm/min          | 1440 / 1440 MPa         | ISO 527-1/-2 |
| Charpy notched impact strength, 23°C (73°F)     | - / 4 kJ/m <sup>2</sup> | ISO 179 1eA  |
| Charpy notched impact strength, -30°C (-22°F)   | - / 5 kJ/m <sup>2</sup> | ISO 179 1eA  |
| Flexural modulus, 23°C (73°F)                   | - / 1300 MPa            | ISO 178      |

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

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| 속성                            | 값      | 테스트 표준         |
|-------------------------------|--------|----------------|
| Melting temperature, 10°C/min | 178 °C | ISO 11357-1/-3 |

## OTHER PROPERTIES

| 속성                            | 값                      | 테스트 표준     |
|-------------------------------|------------------------|------------|
| Specific gravity, 23°C (73°F) | 1.02 g/cm <sup>3</sup> | ISO 1183-1 |

## PACKAGING

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

- 26 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

**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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