

## TECHNICAL DATA SHEET

# RILSAMID® AMNO MED

## POLYAMIDE 12 PELLET

RILSAN® AMNO MED is a polyamide 12 resin. This natural grade is designed for injection molding and is approved in medical applications. Upon request, letters regarding USP Class VI compliance can be provided.

**Designation :** ISO 16396 - PA12, M, C12-010

### DESIGNATION

PA12

### MAIN APPLICATIONS

- Health - Consumable - Others
- Health - Consumable - Catheters

### DELIVERY FORM

- Pellets

### TRANSFORMATION PROCESSES

- Injection Molding

## RHEOLOGICAL PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Shrinkage, Parallel (t+24h)	1.1 %	ISO 294-4
Shrinkage, Normal (t+24h)	1.2 %	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

PROPERTIES	DRY / COND VALUE*	TEST STANDARD
Charpy notched impact strength, 23°C (73°F)	- / 5 kJ/m <sup>2</sup>	ISO 179 1eA
Charpy notched impact strength, -30°C (-22°F)	- / 6 kJ/m <sup>2</sup>	ISO 179 1eA
Flexural modulus, 23°C (73°F)	- / 920 MPa	ISO 178

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

## THERMAL PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Melting temperature, 10°C/min	180 °C	ISO 11357-1/-3

## OTHER PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Specific gravity, 23°C (73°F)	1.01 g/cm <sup>3</sup>	ISO 1183-1

## PACKAGING

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

- 20 kg / 44 lb bags

# RILSAMID® AMNO MED

## 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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