

TECHNICAL DATA SHEET RILSAMID® AMNO

POLYAMIDE 12 PELLET

RILSAMID® AMNO is a polyamide 12 resin. This natural grade without additive is designed for tube extrusion.

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

Designation

- PA12

Delivery Form

- Pellets

Transformation Processes

- Injection Molding

RHEOLOGICAL PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Melt volume flow rate (MVR), 235°C / 2.16 kg (455°F / 4.4 lb)	57 cm ³ /10min	ISO 1133
Shrinkage, Parallel (t+24h)	1.1 %	ISO 294-4
Shrinkage, Normal (t+24h)	1.2 %	ISO 294-4

MECHANICAL PROPERTIES

PROPERTIES	DRY / COND VALUE*	TEST STANDARD
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	- / 8 %	ISO 527-1/-2
Yield stress, 23°C (73°F), 50 mm/min	- / 37 MPa	ISO 527-1/-2
Tensile modulus, 23°C (73°F), 1 mm/min	- / 1100 MPa	ISO 527-1/-2
Charpy notched impact strength, 23°C (73°F)	- / 5 kJ/m ²	ISO 179 1eA
Charpy notched impact strength, -30°C (-22°F)	- / 6 kJ/m ²	ISO 179 1eA
Flexural modulus, 23°C (73°F)	- / 920 MPa	ISO 178

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

PROPERTIES	VALUE	TEST STANDARD
Melting temperature, 10°C/min	180 °C (356 °F)	ISO 11357-1/-3

RILSAMID[®] AMNO

OTHER PROPERTIES

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

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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