

TECHNICAL DATA SHEET

RILSAN® HT CSR 13

POLYPHTALAMIDE PELLET

RILSAN® HT CSR 13 is polyphthalamide compound. It is partially produced from a renewable & sustainable source (castor oil). This black reinforced grade is designed for injection molding & is used to produce high temperature and high chemical resistance automotive fittings & quick connectors, the incorporation of carbon fiber leading to a product with same rigidity as a 30% glass fiber reinforced grade & electrostatic discharge (ESD) performance for conductive parts.

Designation : ISO 16396 - PA10T/X, CF13, M1G1HL, C16-080

DESIGNATION

PA10T/X-CF15

MAIN APPLICATIONS

- Auto - Fluid Connectors

DELIVERY FORM

- Pellets

TRANSFORMATION PROCESSES

- Injection Molding

ADDITIVES

- Heat Stabilized
- Light Stabilized
- Release agent

RHEOLOGICAL PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Melt volume flow rate (MVR), 275°C / 2.16 kg (527°F / 4.4 lb)	12 cm ³ /10min	ISO 1133
Shrinkage, Parallel (t+24h)	0.3 %	ISO 294-4
Shrinkage, Normal (t+24h)	0.6 %	ISO 294-4

MECHANICAL PROPERTIES

PROPERTIES	DRY / COND VALUE*	TEST STANDARD
Charpy unnotched impact strength, 23°C (73°F)	- / 40 kJ/m ²	ISO 179 1eU
Charpy unnotched impact strength, -30°C (-22°F)	- / 32 kJ/m ²	ISO 179 1eU
Tensile modulus, 23°C (73°F), 1 mm/min	7600 / 7600 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)	- / 4 kJ/m ²	ISO 179 1eA

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

THERMAL PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Heat deflection temperature, 0.45 MPa	235 °C	ISO 75-1/-2
Heat deflection temperature, 1.8 MPa	195 °C	ISO 75-1/-2
Melting temperature, 10°C/min	255 °C	ISO 11357-1/-3

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OTHER PROPERTIES

PROPERTIES	VALUE	TEST STANDARD
Bio-based carbon content, Measured	52 %	ASTM D6866
Specific gravity, 23°C (73°F)	1.15 g/cm ³	ISO 1183-1

PACKAGING

This grade is delivered dried in sealed packaging ready to be processed. 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: 270°C / 290°C / 310°C (520°F / 555°F / 590°F)
- Typical mold temperature - Injection molding: 90-110°C (195-230°F)
- Drying time and temperature: 100-110°C (210-230°F) / 4-8 hours

SPECIAL CHARACTERISTICS

- Bio-based
- Electrostatic discharge (ESD)

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