

## TECHNICAL DATA SHEET

# RILSAN® HT CSR 13

### POLYPHTALAMIDE PELLETT

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

| プロパティ   | 価値                        | テスト基準     |
|---|---------------------------|-----------|
| Melt volume flow rate (MVR), 275°C / 2.16 kg (527°F / 4.4 lb) | 12 cm <sup>3</sup> /10min | ISO 1133  |
| Shrinkage, Parallel (t+24h)                                   | 0.3 %                     | ISO 294-4 |
| Shrinkage, Normal (t+24h)                                     | 0.6 %                     | ISO 294-4 |

### MECHANICAL PROPERTIES

| プロパティ   | DRY / COND VALUE*        | テスト基準        |
|---|--------------------------|--------------|
| Charpy unnotched impact strength, 23°C (73°F)   | - / 40 kJ/m <sup>2</sup> | ISO 179 1eU  |
| Charpy unnotched impact strength, -30°C (-22°F) | - / 32 kJ/m <sup>2</sup> | 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 <sup>2</sup>  | ISO 179 1eA  |
| Charpy notched impact strength, -30°C (-22°F)   | - / 4 kJ/m <sup>2</sup>  | ISO 179 1eA  |

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

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## THERMAL PROPERTIES

| プロパティ                                 | 価値     | テスト基準          |
|---------------------------------------|--------|----------------|
| 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 |

## OTHER PROPERTIES

| プロパティ                              | 価値                     | テスト基準      |
|------------------------------------|------------------------|------------|
| Bio-based carbon content, Measured | 52 %                   | ASTM D6866 |
| Specific gravity, 23°C (73°F)      | 1.15 g/cm <sup>3</sup> | ISO 1183-1 |

## 包装

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

- 25 kg / 55 lb bags

## 賞味期限

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:

- 典型的な溶融温度 (最小 / 推奨 / 最大) - 射出成形: 270°C / 290°C / 310°C (520°F / 555°F / 590°F)
- 典型的な金型温度 - 射出成形: 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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