RILSAN® HT

TECHNICAL DATA SHEET
RILSAN® HT CZM 30 LASER TLD

POLYPHTALAMIDE PELLET

RILSAN® HT CZM 30 LASER TLD is a polyphtalamide. It is partially produced from a renewable & sustainable source (castor oil). This black but laser transparent glass-reinforced grade is formulated and designed for injection molding in very demanding applications (high temperature or chemical resistance). It is specially used as a substitute to polyamide 12 for fittings & quick-connector body as it can be injected in same mold (same shrinkage).

Designation : **ISO 11396 - PA10T/X, GF30, M1G1HL, C16-090**

DESIGNATION

PA10T/X-GF31

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), 300°C / 2.16kg (572°F / 4.4 lb)	15 cm³/10min	ISO 1133
Shrinkage, Parallel (t+24h)	0.3 %	ISO 294-4
Shrinkage, Normal (t+24h)	1.0 %	ISO 294-4

MECHANICAL PROPERTIES

プロパティ	DRY / COND VALUE*	テスト基準
Tensile modulus, 23°C (73°F), 1 mm/min	8700 / 8700 MPa	ISO 527-1/-2
Stress at break, 23°C (73°F), 50 mm/min	150 / 150 MPa	ISO 527-1/-2
Charpy notched impact strength, 23°C (73°F)	9.1 / - kJ/m2	ISO 179 1eA
Charpy notched impact strength, -30°C (-22°F)	7.4 / - kJ/m2	ISO 179 1eA
Charpy unnotched impact strength, 23°C (73°F)	57 / - kJ/m2	ISO 179 1eU
Charpy unnotched impact strength, -30°C (-22°F)	54 / - kJ/m2	ISO 179 1eU

*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	240 °C	ISO 75-1/-2
Heat deflection temperature, 1.8 MPa	220 °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
Water absorption, 23°C(73°F), immersion, equilibrium	1.1 %	ISO 62
Moisture absorption, At equilibrium at 23°C (73°F) / 50%HR	0.2 %	ISO 62
Specific gravity, 23°C (73°F)	1.3 g/cm³	ISO 1183-1
Bio-based carbon content, Measured	68 %	ASTM D6866

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
- Laser transparent (weldable)

Headquarter: Arkema France
420, rue d'Estienne d'Orves
92705 Colombes Cedex – France
T +33 (0)1 49 00 80 80