

TECHNICAL DATA SHEET

RILSAN® BUM 30 BLACK

POLYAMIDE 11 PELLET

RILSAN® BUM 30 BLACK is a polyamide 11 compound. It is produced from a renewable & sustainable source (castor oil). This reinforced grade is designed for injection molding, the incorporation of glass beads yielding a virtually isotropic reinforced product.

Designation : ISO 16396 - PA11, GB30, M1G1HLR, C18-020

TYPE

PA11-GB30

MAIN APPLICATIONS

- Industry - Distribution
- Auto - Fluid Connectors

DELIVERY FORM

- Pellets

TRANSFORMATION PROCESSES

- Injection Molding

RHEOLOGICAL PROPERTIES

PROPERTIES	VALUE	UNIT	TEST STANDARD
Shrinkage, Parallel (t+24h)	1.8	%	ISO 294-4
Shrinkage, Normal (t+24h)	1.6	%	ISO 294-4
Melt volume flow rate (MVR), 235°C / 5 kg (455°F / 11 lb)	20	cm³/10min	ISO 1133

MECHANICAL PROPERTIES

PROPERTIES	DRY / COND VALUE*	UNIT	TEST STANDARD
Hardness, Shore D, 15 s	- / 71		ISO 868
Charpy unnotched impact strength, 23°C (73°F)	- / 96	kJ/m²	ISO 179 1eU
Charpy unnotched impact strength, -30°C (-22°F)	- / 96	kJ/m²	ISO 179 1eU
Tensile modulus, 23°C (73°F), 1 mm/min	1850 / 1850	MPa	ISO 527-1/-2
Charpy notched impact strength, 23°C (73°F)	- / 6	kJ/m²	ISO 179 1eA
Charpy notched impact strength, -30°C (-22°F)	- / 5	kJ/m²	ISO 179 1eA
Flexural modulus, 23°C (73°F)	- / 1600	MPa	ISO 178

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

THERMAL PROPERTIES

PROPERTIES	VALUE	UNIT	TEST STANDARD
Melting temperature, 10°C/min	189	°C	ISO 11357-1/-3

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OTHER PROPERTIES

PROPERTIES	VALUE	UNIT	TEST STANDARD
Specific gravity, 23°C (73°F)	1.23	g/cm ³	ISO 1183-1

PACKAGING

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: 250°C / 270°C / 290°C (480°F / 520°F / 555°F)
- Typical mold temperature - Injection molding: 40-90°C (105-195°F)
- Drying time and temperature: 80-90°C (175-195°F) / 4-6 hours

SPECIAL CHARACTERISTICS

- Bio-based
- Low oligomers