

Rilsan® Clear **G350** is a high performance transparent polyamide. This grade has been specially designed for injection molding applications, ideally suited for optics as high end eyewear frames.

GENERAL PROPERTIES	METHOD	UNIT	TYPICAL VALUES
Density	ISO R 1183 D	g/cm ³	0.99
Water absorption at equilibrium at 23°C and 50 % RH	ISO 62	%	1.1
Water absorption at equilibrium at 23°C in water		%	3
Glass transition temperature (Tg)	ISO 11357	°C	145
Heat deflection temperature (HDT) under 0.45 MPa under 1.80 MPa	ISO 75	°C	120
		°C	105
Transparency (560 nm, 2mm)	ISO 13168-1,2	%	91.5
Shrinkage (after 24h, 2 mm, mould at 40°C) // ⊥	Internal method	%	0.4
		%	0.8
Hardness shore (*) instantaneous after 15 s	ISO 868	Shore D	81
		Shore D	78
Tensile test (*) stress at yield strain at yield stress at break strain at break	ISO 527	MPa	51
		%	8
		MPa	50
		%	> 150
Tensile modulus (*)	ISO 527	MPa	1480
Flexural modulus (*)	ISO 178	MPa	1340
Charpy impact unnotched 23°C unnotched -30°C notched 23°C notched -30°C	ISO 179/1eU	kJ/m ²	No break
	"	"	No break
	ISO 179/1eA	"	12
	"	"	10

(*) Samples conditioned 15 days, 23°C - 50 % R.H.

PROCESSING CONDITIONS	TYPICAL VALUES
Drying (*) : time / temperature	4-6 hours / 80°C
Injection temperature : min / recommended / max	250°C / 280°C / 300°C
Mold temperature :	20-80°C

(*) Rilsan® Clear is delivered dried in sealed packaging ready to be processed. Drying is only necessary for bags opened for more than 2 hours.

Note that during the development stage, product is also named M-G350