

RILSAMID®

AMN BLACK P20 TLD

PA12-P, MHLR, 12-005

Rilsamid® AMN BLACK P20 TLD resin is a black colored polyamide. This grade is plasticized and designed for injection molding.

PROPERTIES	DRY / COND	UNIT	TEST STANDARD
RHEOLOGICAL PROPERTIES			
Melt Volume-Flow Rate	44 / *	cm ³ /10min	ISO 1133
Temperature	235 / *	°C	-
	455 / *	°F	-
Load	2.16 / *	kg	-
	4.76 / *	lb	-
Molding Shrinkage, parallel	1.0 / *	%	ISO 294-4, 2577
Molding Shrinkage, normal	1.2 / *	%	ISO 294-4, 2577
MECHANICAL PROPERTIES			
Tensile Modulus	- / 550	MPa	ISO 527-1/-2
	- /	psi	
Yield stress	79800	MPa	ISO 527-1/-2
	- / 31	psi	
	- / 4500	psi	
Yield strain	- / 19	%	ISO 527-1/-2
Nominal Strain at Break	- / >50	%	ISO 527-1/-2
Charpy Impact Strength, +23°C	- / No Break	kJ/m ²	ISO 179/1eU
Charpy Impact Strength, -30°C	- / No Break	kJ/m ²	ISO 179/1eU
Charpy Notched Impact Strength, +23°C	- / 18	kJ/m ²	ISO 179/1eA
	- / 8.56	ftlb/in ²	
Charpy Notched Impact Strength, -30°C	- / 4	kJ/m ²	ISO 179/1eA
	- / 1.9	ftlb/in ²	
THERMAL PROPERTIES			
Melting Temperature, 10°C/min	174 / *	°C	ISO 11357-1/-3
OTHER PROPERTIES			
Density	1020 / 1020	kg/m ³	ISO 1183
	1.02 / 1.02	g/cm ³	

Processing conditions, Injection:

- Typical melt temperature (Min / Recommended / Max) : 250°C / 270°C / 290°C.
- Mold temperature : 20 - 40°C
- Drying time and temperature (only necessary for bags opened for more than two hours) : 4-6 hours at 80 - 90°C.

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AMN BLACK P20 TLD

PROCESSING Injection Molding	
DELIVERY FORM Pellets	
ADDITIVES Release agent, Plasticizer	
SPECIAL CHARACTERISTICS Heat Stabilized, Light Stabilized	
REGIONAL AVAILABILITY North America, Europe, Asia Pacific, South and Central America, Near East/Africa	