

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

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

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

DPT/TDS/049107/October 2009

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