

Rilsan® Clear **G170** is a high performance transparent polyamide with outstanding thermal resistance. This grade has been designed for extrusion and injection molding applications and for medical uses.

GENERAL PROPERTIES	METHOD	UNIT	TYPICAL VALUES
Density	ISO R 1183 D	g/cm ³	1.05
Water absorption at equilibrium at 23°C and 50 % RH	ISO 62	%	1.3
Water absorption at equilibrium at 23°C in water		%	3.2
Glass transition temperature (Tg)	ISO 11357	°C	168
Heat deflection temperature (HDT) under 0.45 MPa	ISO 75	°C	150
under 1.80 MPa		°C	136
Transparency (560 nm, 2mm)	ISO 13168-1,2	%	90.8
Hardness shore (*) instantaneous	ISO 868	Shore D	84
after 15 s		Shore D	79
Tensile test (*) stress at yield	ISO 527	MPa	74
strain at yield		%	9
stress at break		MPa	58
strain at break		%	> 100
Tensile modulus (*)	ISO 527	MPa	2020
Flexural modulus (*)	ISO 178	MPa	1980
Charpy impact unnotched 23°C	ISO 179/1eU	kJ/m ²	No break
unnotched -30°C	"		No break
notched 23°C	ISO 179/1eA		13
notched -30°C	"		13

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

PROCESSING CONDITIONS	TYPICAL VALUES
Drying (*) : time / temperature	4-6 hours / 80-90°C
Injection temperature : min / recommended / max	270°C / 290°C / 310°C
Extrusion temperature : min / recommended / max	270°C / 280°C / 290°C
Mold temperature :	40-80°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.

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