

Rilsan® CLEAR G 350

Polyamide Copolymer

Arkema

Message:

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

MAIN APPLICATIONS

Sun, optical, reading glass frames.

Mobile phone covers.

Watch covers.

General Information			
Uses	Cell Phones		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	0.990	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow : 40°C, 24 hr, 4.00 mm	0.64	%	
Flow : 40°C, 24 hr, 4.00 mm	0.60	%	
Water Absorption			ISO 62
23°C, 24 hr	3.0	%	
Equilibrium, 23°C, 50% RH	1.1	%	
Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore D	81		
Shore D, 15 sec	78		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1480	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Yield	51.0	MPa	
Break	50.0	MPa	
Tensile Strain			ISO 527-2
Yield	8.0	%	
Break	> 150	%	
Flexural Modulus	1340	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	10	kJ/m ²	
23°C	12	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		

23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	120	°C	ISO 75-2/B
1.8 MPa, Unannealed	105	°C	ISO 75-2/A
Glass Transition Temperature	145	°C	ISO 11357-2
Optical	Nominal Value	Unit	Test Method
Transmittance (2000 µm, 560 nm)	91.5	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	90.0	°C	
Drying Time	4.0 to 6.0	hr	
Processing (Melt) Temp	250 to 300	°C	
Mold Temperature	20.0 to 80.0	°C	

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