

Rilsan® PA 11 G **BMNO MED** is a polyamide produced from a renewable source. This grade offers the highest quality and it is specially designed to meet the stringent requirements of the medical applications such as minimally invasive devices. RILSAN® PA 11 G **BMNO MED** also offers an excellent combination of properties. Upon request letters regarding USP Class VI testing can be provided.

GENERAL PROPERTIES	METHOD	UNIT	TYPICAL VALUES
Nature & designation	ISO 1874	-	PA11, MHLR, 12-010
Bio Based Carbon (calculation)	ASTM 6866	%	100 %
Density	ISO R 1183 D	g/cm ³	1.03
Melting point	ISO 11357	°C	189
Shrinkage after 24h, mold at 30°C, thickness =2 mm // ⊥	Internal method	% %	0.4 0.8
Hardness shore (*) instantaneous after 15 s	ISO 868	Shore D Shore D	75 68
Tensile test (*) stress at yield strain at yield stress at break strain at break	ISO 527	MPa % MPa %	41 5 58 > 200
Tensile modulus (*)	ISO 527	MPa	1280
Flexural modulus (*)	ISO 178	MPa	1140
Charpy impact unnotched 23°C unnotched -30°C notched 23°C notched -30°C	ISO 179/1eU " ISO 179/1eA "	kJ/m ² " " "	No break No break 20 10

(*) 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	240°C / 270°C / 290°C
Mold Temperature :	20-60°C

(*) Rilsan® 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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