Akulon® XP36-C1

Polyamide 6

DSM Engineering Plastics

Message:

Akulon®XP36-C1 is a polyamide 6 (nylon 6) material. This product is available in Europe, and the processing method is: film extrusion.
Akulon®The main features of the XP36-C1 are:
Lubrication
Medium viscosity
Akulon®The typical application fields of XP36-C1 are: movies

General Information			
Additive	Lubricant		
Features	Lubrication Medium viscosity		
Uses	Films		
Forms	Particle		
Processing Method	Film extrusion		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.13	g/cm³	ISO 1183
Viscosity Number	194	cm³/g	ISO 307
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Coefficient of Friction			ISO 8295
With itself-dynamic, cast film	1.0		ISO 8295
With itself-static, cast film	1.2		ISO 8295
Films	**Nominal Value**	**Unit**	**Test Method**
Film Thickness - Tested	50	µm	
Tensile Modulus [1] (50 µm, Cast Film)	490	MPa	Internal method
Tensile Stress - MD			ISO 527-3
Yield, 50 µm, cast film	33.0	MPa	ISO 527-3
50 µm, cast film	85.0	MPa	ISO 527-3
Tensile Elongation - MD (Broken, 50 µm, cast film)	340	%	ISO 527-3
Trouser Tear Resistance - MD (50 µm, Cast Film)	23.0	N/mm	ISO 6383-1
Water Vapor Transmission Rate (23°C, 85% RH, 50 µm, cast film)	35	g/m²/24 hr	DIS 15106-1/-3
Oxygen Transmission Rate [2]			DIS 15105-1/-2
0% RH : 23°C, 50.0 µm	26	cm³/m²/bar/24 hr	DIS 15105-1/-2
85% RH : 23°C, 50.0 µm	38	cm³/m²/bar/24 hr	DIS 15105-1/-2
Specific Heat Capacity			
--	1550	J/kg/°C	

Average: 20 to 150°C	2250	J/kg/°C	
Puncture Resistance (50.0 µm) [3]	12.5	J/cm	Internal method
RSV [4]	3.00		Internal method
Thermal	**Nominal Value**	**Unit**	**Test Method**
CLTE - Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Optical	**Nominal Value**	**Unit**	**Test Method**
Transmittance (50.0 µm, Cast Film)	83.0	%	Internal method
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Melt Viscosity (260°C)	2740	Pa·s	Internal method
Additional Information	**Nominal Value**	**Unit**	**Test Method**
Processing parameters for cast film test specimen: Extruder Temperature: 270°C Die Temperature: 270°C Chill Roll Temperature: 110°C			
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0	°C	
Drying Time	4.0 - 8.0	hr	
Rear Temperature	230 - 235	°C	
Middle Temperature	235 - 250	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	240 - 270	°C	
Processing (Melt) Temp	240 - 275	°C	
Mold Temperature	50.0 - 80.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	3.00 - 10.0	MPa	
Screw Compression Ratio	2.5:1.0		
NOTE			
1.	50 mm/min		
2.	Cast Film		
3.	Cast Film		
4.	Formic Acid, 1g/100 ml		

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