

# Akulon® F236-C

Polyamide 6  
DSM Engineering Plastics

Message:

Akulon® F236-C is a Polyamide 6 (Nylon 6) material. It is available in Europe.  
Important attributes of Akulon® F236-C are:  
High Viscosity  
Lubricated

General Information			
UL YellowCard	E47960-240086		
Additive	Lubricant		
Features	High Viscosity		
	Lubricated		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm³	ISO 1183
Water Absorption			ISO 62
Saturation, 23°C	9.5	%	
Equilibrium, 23°C, 50% RH	2.5	%	
Viscosity Number	244	cm³/g	ISO 307
Thermal	Nominal Value	Unit	Test Method
Melting Temperature <sup>1</sup>	220	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	230 to 235	°C	
Middle Temperature	235 to 250	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	240 to 270	°C	
Processing (Melt) Temp	240 to 275	°C	
Mold Temperature	50.0 to 80.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	3.00 to 10.0	MPa	
Screw Compression Ratio	2.5:1.0		
NOTE			
1.	10°C/min		

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Recommended distributors for this material

## Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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