

Akulon® F136-DH

Polyamide 6
DSM Engineering Plastics

Message:

Akulon® F136-DH is a Polyamide 6 (Nylon 6) material. It is available in Europe for extrusion or profile extrusion.
Important attributes of Akulon® F136-DH are:
Flame Rated
Heat Stabilizer
High Viscosity
Nucleated
Typical application of Akulon® F136-DH: Hose/Tubing

General Information			
UL YellowCard	E47960-257294		
Additive	Heat Stabilizer		
	Nucleating Agent		
Features	Heat Stabilized		
	High Viscosity		
	Nucleated		
Uses	Tubing		
Forms	Pellets		
Processing Method	Extrusion		
	Profile Extrusion		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
	Secant Modulus vs. Strain (ISO 11403-1)		
	Shear Modulus vs. Temperature (ISO 11403-1)		
	Specific Volume vs Temperature (ISO 11403-2)		
	Viscosity vs. Shear Rate (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Water Absorption			ISO 62
Saturation, 23°C	9.5	%	
Equilibrium, 23°C, 50% RH	2.5	%	
Viscosity Number	245	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3150	MPa	ISO 527-2
Tensile Stress (Yield)	85.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.0	%	ISO 527-2

Nominal Tensile Strain at Break	45	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	170	°C	ISO 75-2/B
1.8 MPa, Unannealed	60.0	°C	ISO 75-2/A
Melting Temperature ¹	220	°C	ISO 11357-3
CLTE - Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength	25	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.40		
1 MHz	3.10		
Dissipation Factor			IEC 60250
100 Hz	6.5E-3		
1 MHz	0.017		
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification (1.60 mm)	HB		IEC 60695-11-10, -20
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		

1. 10°C/min

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