


**Akulon® F136-E1**  
**PA6** DSM Engineering Plastics
**Product Texts**

Very High Viscosity, Lubricated, Nucleated, Film Extrusion

ISO 1043 PA6

[Akulon website](#)

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature (10°C/min)	220	°C	ISO 11357-1/-3
Coeff. of linear therm. expansion, parallel	90	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Water absorption	9	%	Sim. to ISO 62
Humidity absorption	2.5	%	Sim. to ISO 62
Density	1130	kg/m³	ISO 1183

Film Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Stress at yield, parallel	34	MPa	ISO 527-3
Maximum stress, parallel	94	MPa	ISO 527-3
Maximum strain, parallel	350	%	ISO 527-3
Trouser Tear resistance, parallel	32	N/mm	ISO 6383-1
Dynamic coefficient of friction	0.8	-	ISO 8295
WVTR, 23°C/85%r.h.	35	g/(m²*d)	DIS 15106-1/-2
Oxygen transmission rate, 23°C/0%r.h.	23	cm³/(m²*d*bar)	DIS 15105-1/-2
Oxygen transmission rate, 23°C/85%r.h.	33	cm³/(m²*d*bar)	DIS 15105-1/-2
Type of extrusion	cast	-	-
Thickness of specimen	0.05	mm	-

Material specific properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Viscosity number	245	cm³/g	ISO 307, 1157, 1628

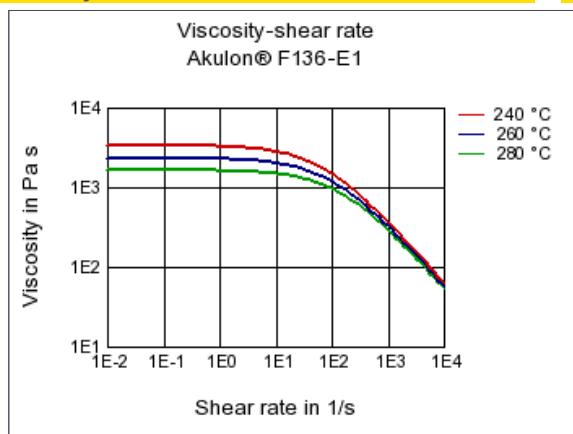
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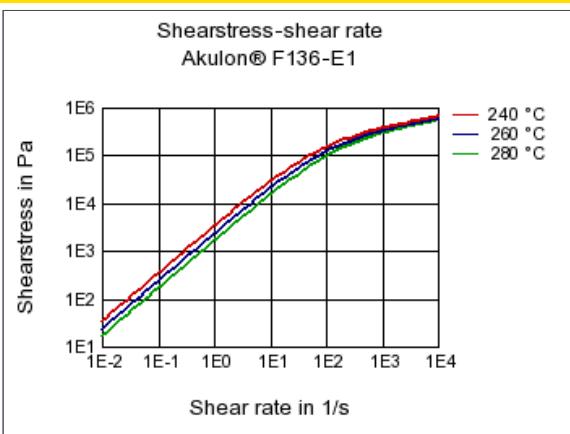
DSM Engineering Plastics

## Diagrams

### Viscosity-shear rate



### Shearstress-shear rate



## Characteristics

### Processing

Film Extrusion, Other Extrusion

### Additives

Lubricants

### Delivery form

Pellets

## Other text information

### Injection Molding

[Injection Molding Recommendations](#)

### Film extrusion

[Processing of Akulon film grades](#)