

# Akulon® XP36-D1H

Polyamide 6  
DSM Engineering Plastics

Message:

Akulon® XP36-D1H is a Polyamide 6 (Nylon 6) material. It is available in Europe for extrusion or injection molding.  
Important attributes of Akulon® XP36-D1H are:  
Heat Stabilizer  
High Viscosity  
Nucleated  
Typical application of Akulon® XP36-D1H: Hose/Tubing

General Information	
Additive	Heat Stabilizer Nucleating Agent
Features	Heat Stabilized High Viscosity Nucleated
Uses	Tubing
Forms	Pellets
Processing Method	Extrusion Injection Molding

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm³	ISO 1183
Viscosity Number	197	cm³/g	ISO 307
Mechanical	Nominal Value		Test Method
Coefficient of Friction (vs. Itself - Dynamic)	0.80		ISO 8295
Thermal	Nominal Value	Unit	Test Method
CLTE - Flow	1.0E-4	cm/cm/°C	ISO 11359-2
Additional Information	Nominal Value		Test Method
RSV - formic acid <sup>1</sup>	3.00		Internal Method
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0 to 8.0	hr	
Dew Point	-40.0 to -30.0	°C	
Rear Temperature	265 to 285	°C	
Middle Temperature	275 to 290	°C	
Front Temperature	280 to 295	°C	
Nozzle Temperature	280 to 290	°C	
Processing (Melt) Temp	270 to 295	°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	
Extrusion	Nominal Value	Unit
Drying Temperature	75.0	°C
Drying Time	8.0 to 10	hr
Suggested Max Moisture	< 0.070	%
Cylinder Zone 1 Temp.	255	°C
Cylinder Zone 2 Temp.	260	°C
Cylinder Zone 3 Temp.	260	°C
Adapter Temperature	260	°C
Die Temperature	260	°C
NOTE		
1.	1g/100 ml	

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Recommended distributors for this material


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