

Akulon[®] F128

PA6

Film Extrusion, Medium Viscosity, Food Contact Quality

Print Date: 2024-03-27

| PROPERTIES | TYPICAL DATA | UNIT | TEST METHOD |
|--|--------------|--------------------|----------------------------|
| MATERIAL SPECIFIC PROPERTIES | | VALUE | |
| Viscosity number | 181 | cm ³ /g | ISO 307, 1157, 1628 |
| RSV formic acid, 1g/100ml | 2.85 | – | Envalior Method |
| Melt Viscosity (260 °C) | 560 | Pa s | Envalior Method, 260 °C |
| Density | 1130 | kg/m ³ | ISO 1183 |
| THERMAL PROPERTIES | | VALUE | |
| Coeff. of linear therm. expansion (parallel) | 0.9 | E-4/°C | ISO 11359-1/-2 |
| Spec. heat capacity | 1550 | J/(kg K) | – |
| Average spec. heat capacity 20–150 °C | 2250 | J/(kg K) | |
| MECHANICAL PROPERTIES (FILM) | | VALUE | |
| Modulus of elasticity | 460 | MPa | Envalior Method, 50 mm/min |
| Stress at yield, parallel | 32 | MPa | ISO 527-3 |
| Maximum stress, parallel | 80 | MPa | ISO 527-3 |
| Maximum strain, parallel | 350 | % | ISO 527-3 |
| Trouser Tear resistance, parallel | 32 | – | ISO 6383-1 |
| Puncture resistance | 1150 | J/m | Envalior Method |
| Static coefficient of friction | 1.5 | – | ISO 8295 |
| Dynamic coefficient of friction | 1.2 | – | ISO 8295 |
| OTHER PROPERTIES (FILM) | | VALUE | |

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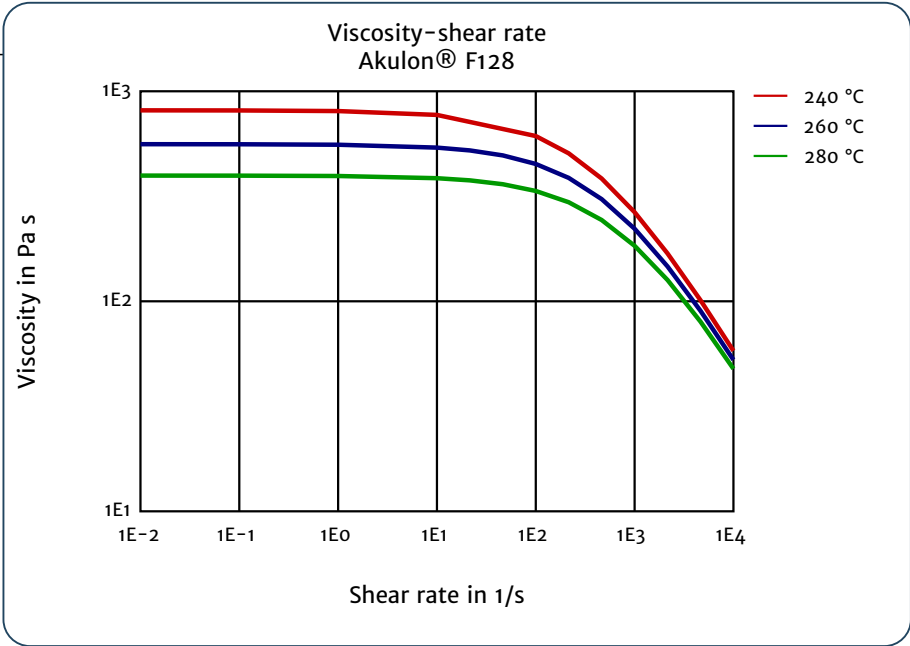
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|---|--------------|----------------|-----------------|
| Transparency/Clarity | 83 | % | Envalior Method |
| Oxygen transmission rate at 23°C/0%r.h. | 26 | cm³/(m²*d*bar) | DIS 15105-1/-2 |
| Oxygen transmission rate at 23°C/85%r.h. | 38 | cm³/(m²*d*bar) | DIS 15105-1/-2 |
| Water Vapor Transmission Rate at 23°C/85%r.h. | 35 | g/(m²*d) | DIS 15106-1/-3 |

| TEST SPECIMEN PRODUCTION (FILM) | VALUE | | |
|---------------------------------|-------|----|---|
| Type of extrusion | cast | — | — |
| Thickness of specimen | 0.05 | mm | — |
| Extruder temperature | 270 | °C | |
| Die temperature | 270 | °C | |
| Chill Roll Temperature | 110 | °C | |

Viscosity—shear rate



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