Akulon® Fuel Lock FLE-LP BK29011

PA6-I — Envalior

Product Texts

Low fuel permeation PA6 suitable for use in injection molding/welding of small engine fuel tanks

ISO 1043 PA6-I

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
[C] Melt volume-flow rate, MVR	**13 / ***	cm³/10min	ISO 1133
Temperature	**250 / ***	°C	-
Load	**2.16 / ***	kg	-
[C] Molding shrinkage, parallel	**2.1 / ***	%	ISO 294-4, 2577
[C] Molding shrinkage, normal	**1.9 / ***	%	ISO 294-4, 2577
[C] Density of melt	**869**	kg/m³	-
[C] Thermal conductivity of melt	**0.22**	W/(m K)	-
[C] Spec. heat capacity of melt	**2740**	J/(kg K)	-
[C] Eff. thermal diffusivity	**9.37E-8**	m²/s	-

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**1750 / 560**	MPa	ISO 527
[C] Yield stress	**43 / -**	MPa	ISO 527
[C] Yield strain	**4.2 / -**	%	ISO 527
[C] Nominal strain at break	**>50 / -**	%	ISO 527
[C] Charpy impact strength, +23°C	**N / N**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**N / N**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**90 / N**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**20 / 20**	kJ/m²	ISO 179/1eA
[C] Puncture - maximum force, +23°C	**3300 / -**	N	ISO 6603-2
[C] Puncture energy, +23°C	**48 / -**	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Temp. of deflection under load, 1.80 MPa	**55 / ***	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**100 / ***	°C	ISO 75-1/-2
[C] Vicat softening temperature, B	**130 / ***	°C	ISO 306
[C] Coeff. of linear therm. expansion, parallel	**110 / ***	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**120 / ***	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**7 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**2.5 / ***	%	Sim. to ISO 62
[C] Density	**1060 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Release agent

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather

Features

Weldable

Regional Availability
North America, Europe, Asia Pacific

Other text information

Injection molding
Injection Molding Recommendations
Steel recommendations for molds screws and barrels
Trouble shooting guideline for injection molding