

# Akulon® Fuel Lock FL-LP

Polyamide 6

DSM Engineering Plastics

## Message:

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

General Information				
Additive	UV Stabilizer			
Features	Fuel Resistant			
Uses	Fuel Tanks			
Processing Method	Injection Molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.07	--	g/cm <sup>3</sup>	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C	7.0	--	%	
Equilibrium, 23°C, 50% RH	2.5	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1800	--	MPa	ISO 527-2
Tensile Stress (Yield)	50.0	--	MPa	ISO 527-2
Tensile Strain (Yield)	4.0	--	%	ISO 527-2
Nominal Tensile Strain at Break	> 50	--	%	ISO 527-2
Flexural Modulus	1600	--	MPa	ISO 178
Flexural Stress	65.0	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	18	25	kJ/m <sup>2</sup>	
23°C	65	75	kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	No Break		
23°C	No Break	No Break		
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	130	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	50.0	--	°C	ISO 75-2/A
CLTE				ISO 11359-2
Flow	1.2E-4	--	cm/cm/°C	
Transverse	1.2E-4	--	cm/cm/°C	

Injection	Dry	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	

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