LUVOCOM® 1850/PL/15/BK

Polybutylene Terephthalate

Lehmann & Voss & Co.

Message:

LUVOCOM®1850/PL/15/BK is a polybutene terephthalate (PBT) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.
LUVOCOM®The main features of 1850/PL/15/BK are:
flame retardant/rated flame
Wear-resistant
Lubrication
Typical application areas include:
Electrical/electronic applications
Reflector
textile/fiber
engineering/industrial accessories
Automotive Industry

General Information	
Additive	PTFE lubricant
Features	Low friction coefficient Good wear resistance Lubrication
Uses	Electrical/Electronic Applications Reflector Textile applications Engineering accessories Switch Application in Automobile Field Business equipment spool
Appearance	Black

Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm³	ISO 1183
Molding Shrinkage	1.4 - 2.0	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 0.15	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2
Tensile Stress (Break)	45.0	MPa	ISO 527-2
Tensile Strain (Yield)	10	%	ISO 527-2
Flexural Modulus	2200	MPa	ISO 178
Flexural Stress	80.0	MPa	ISO 178
Coefficient of Friction			

Dynamic	0.16		
Static	0.13		
Flexural Strain at Flexural Strength	12	%	ISO 178
Maximum operating temperature-Short Term	150	°C	
Insulation Resistance	> 1.0E+12	ohms	IEC 60167
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	3.0	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	30	kJ/m^2	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	82.0	°C	ISO 75-2/A
Continuous Use Temperature	130	°C	UL 746B
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating [1]	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature			
Hot air dryer, A	120	°C	
Vacuum dryer, B	80.0	°C	
Drying Time			
Hot air dryer, A	4.0 - 6.0	hr	
Vacuum dryer, B	6.0 - 8.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	240 - 260	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	250 - 265	°C	
Processing (Melt) Temp	250	°C	
Mold Temperature	60.0 - 120	°C	

Injection instructions

General
In general LUVOCOM® can be processed on conventional injection moulding machines while observing the usual technical guidelines.
Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials.
Lengthy dwell times for the melts in the cylinder should be avoided.
Lower the temperatures during interruptions!
Predrying (optional)
It is advisable to predry the granulate with a suitable dryer immediately before processing.
The granulate may absorb moisture from the air.
Delivery Form & Storage
Unless indicated otherwise, the material is delivered as 3mm-long pellets in sealed bags on pallets.
Preferably storage should be effected in dry and normally temperatured rooms
Additional Information
During processing the moisture level should not exceed 0.02%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. As the material absorbs water very quickly, the predried material should be fed to the processing immediately. Processing temperatures above 270°C may very rapidly cause thermal damage and should therefore be avoided.
The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application.
Please contact us for further information.

NOTE	
1.	Not recognized by UL.

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