LUVOCOM® 1114-8364

Polyaryletherketone

Lehmann & Voss & Co.

Message:

LUVOCOM®1114-8364 is a polyaryl ketone (PAEK) material, which contains a carbon fiber reinforced material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.
LUVOCOM®The main features of 1114-8364 are:
flame retardant/rated flame
Conductivity
Electrostatic protection
Lubrication
Typical application areas include:
textile/fiber
engineering/industrial accessories
Aerospace
Automotive Industry
medical/health care

General Information			
Filler / Reinforcement	Carbon fiber reinforced material		
Additive	PTFE lubricant		
Features	Conductivity Electrostatic discharge protection Lubrication		
Uses	Textile applications Engineering accessories Aerospace applications Application in Automobile Field Medical/nursing supplies		
Appearance	Dark gray		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.50	g/cm³	ISO 1183
Molding Shrinkage	0.10 - 0.30	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 0.10	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	18000	MPa	ISO 527-2
Tensile Stress (Break)	190	MPa	ISO 527-2
Tensile Strain (Yield)	1.7	%	ISO 527-2
Flexural Modulus	15000	MPa	ISO 178
Flexural Stress	260	MPa	ISO 178
Flexural Strain at Flexural Strength	2.2	%	ISO 178
Insulation Resistance		ohms	IEC 60167

Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1fU
-30°C	25	kJ/m²	ISO 179/1fU
23°C	30	kJ/m²	ISO 179/1fU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	305	°C	ISO 75-2/A
Continuous Use Temperature	255	°C	UL 746B
Vicat Softening Temperature	320	°C	ISO 306/A
CLTE - Flow	5.0E-6	cm/cm/°C	DIN 53752
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	< 1.0E+4	ohms	IEC 60093
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating [1]	V-0		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature			
Hot air dryer, A	150	°C	
Hot air dryer, B	120	°C	
Drying Time			
Hot air dryer, A	4.0 - 6.0	hr	
Hot air dryer, B	6.0 - 10	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	370 - 420	°C	
Middle Temperature	380 - 420	°C	
Front Temperature	390 - 420	°C	
Nozzle Temperature	390 - 420	°C	
Processing (Melt) Temp	390	°C	
Mold Temperature	160 - 200	°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 content should not exceed 0.05%. To avoid internal stresses, a medium to high injection rate should be used. An increase in tool temperature may be helpful. Post-crystallization may lead to warpage at elevated operating temperatures. This can be counteracted by suitable heat treatment.
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.
High-temperature polymers place increased demands on the tool steels employed.
Please contact us for further information.

NOTE	
1.	Not recognized by UL.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China