LUVOCOM® 1/CF/15/HS

Polyamide 66

Lehmann & Voss & Co.

Message:

LUVOCOM®1/CF/15/HS is a polyamide 66 (nylon 66) material, which contains a 15% 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 1/CF/15/HS are:
flame retardant/rated flame
Conductivity
High stiffness
high strength
Electrostatic protection
Typical application areas include:
engineering/industrial accessories
Automotive Industry
textile/fiber
business/office supplies

General Information	
UL YellowCard	E108976-218771
Filler / Reinforcement	Carbon fiber reinforced material, 15% filler by weight
Additive	heat stabilizer
Features	Good dimensional stability Conductivity Low warpage Rigidity, high High strength Electrostatic discharge protection Thermal Stability
Uses	Gear Textile applications Engineering accessories Application in Automobile Field Business equipment Cam
Appearance	Natural color

Physical	Nominal Value	Unit	Test Method
Density	1.18	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (285°C/2.16 kg)	8.00	cm³/10min	ISO 1133
Molding Shrinkage	0.20 - 0.50	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 1.0	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	12000	MPa	ISO 527-2
Tensile Stress (Break)	200	MPa	ISO 527-2
Tensile Strain (Yield)	2.8	%	ISO 527-2
Flexural Modulus	10000	MPa	ISO 178
Flexural Stress	300	MPa	ISO 178
Coefficient of Friction			
Dynamic	0.22		
Static	0.18		
Flexural Strain at Flexural Strength	3.6	%	ISO 178
Maximum operating temperature-Short Term	160	°C	
Insulation Resistance		ohms	IEC 60167
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	7.0	kJ/m^2	ISO 179/1eA
23°C	9.0	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength			
-30°C	30	kJ/m^2	ISO 179/1fU
23°C	45	kJ/m^2	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	245	°C	ISO 75-2/A
Continuous Use Temperature	120	°C	UL 746B
Vicat Softening Temperature	250	°C	ISO 306/A
CLTE - Flow	2.7E-5	cm/cm/°C	DIN 53752
Thermal Conductivity	0.38	W/m/K	DIN 52612
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	< 1.0E+3	ohms	IEC 60093
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature			
Hot air dryer, A	75.0	°C	
Vacuum dryer, B	105	°C	
Drying Time			
Hot air dryer, A	6.0 - 16	hr	
Vacuum dryer, B	4.0 - 6.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	290 - 310	°C	
Middle Temperature	290 - 310	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	280 - 300	°C	

Processing (Melt) Temp	290	°C
Mold Temperature	90.0 - 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 0.1%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. Due to rapid absorption of water, originally sealed containers should only be opened immediately prior to processing. Excessively high predrying temperatures may cause discoloration.
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.

Recommended distributors for this material

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