

# LUVOCOM® 1105-7786/L-NAT

Polyetheretherketone  
Lehmann & Voss & Co.

Message:

LUVOCOM® 1105-7786/L-NAT is a polyetheretherketone (PEEK) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.

LUVOCOM® The main features of 1105-7786/L-NAT are:

Flame Retardant  
anti-warping  
chemical resistance  
Wear-resistant  
Lubrication

Typical application areas include:

engineering/industrial accessories  
textile/fiber  
Aerospace  
Automotive Industry  
Handle

General Information			
Additive	PTFE lubricant		
Features	Low warpage		
	Good chemical resistance		
	Good wear resistance		
	Hydrolysis resistance		
	Lubrication		
	Flame retardancy		
Uses	Handle		
	Textile applications		
	Engineering accessories		
	Aerospace applications		
	Machine/mechanical parts		
	Application in Automobile Field		
	Medical/nursing supplies		
	Bearing		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (380°C/10.0 kg)	23.0	cm³/10min	ISO 1133
Molding Shrinkage	1.0 - 1.8	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 0.050	%	
Mechanical	Nominal Value	Unit	Test Method

Tensile Modulus	3800	MPa	ISO 527-2
Tensile Stress (Break)	90.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.0	%	ISO 527-2
Flexural Modulus	3000	MPa	ISO 178
Flexural Stress	130	MPa	ISO 178
Flexural Strain at Flexural Strength	6.5	%	ISO 178
Maximum operating temperature-Short Term	260	°C	
Insulation Resistance	> 1.0E+12	ohms	IEC 60167
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Charpy Notched Impact Strength (23°C)	5.0	kJ/m <sup>2</sup>	ISO 179/1eA
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Continuous Use Temperature	250	°C	UL 746B
<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>	
Drying Temperature			
Hot air dryer, A	150	°C	
Hot air dryer, B	120	°C	
Drying Time			
Hot air dryer, A	3.0 - 6.0	hr	
Hot air dryer, B	6.0 - 8.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	360 - 370	°C	
Middle Temperature	380 - 390	°C	
Front Temperature	390 - 400	°C	
Nozzle Temperature	360 - 380	°C	
Processing (Melt) Temp	390	°C	
Mold Temperature	170 - 190	°C	
<b>Injection instructions</b>			

#### 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.

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