

LUVOCOM® 1/CF/15/TF/20/BK

Polyamide 66

LEHVOSS Group

Message:

LUVOCOM® 1/CF/15/TF/20/BK 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 characteristics of 1/CF/15/TF/20/BK are:

Conductivity

Wear-resistant

Lubrication

Typical application areas include:

engineering/industrial accessories

Automotive Industry

textile/fiber

business/office supplies

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 15% filler by weight		
Additive	PTFE lubricant (20%)		
Features	Conductivity		
	Low friction coefficient		
	Static conduction		
	Good wear resistance		
	Lubrication		
Uses	Gear		
	Textile applications		
	Engineering accessories		
	Application in Automobile Field		
	Business equipment		
	Cam		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Molding Shrinkage	0.20 - 0.50	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 1.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10500	MPa	ISO 527-2
Tensile Stress (Break)	145	MPa	ISO 527-2
Tensile Strain (Yield)	2.0	%	ISO 527-2
Flexural Modulus	9000	MPa	ISO 178
Flexural Stress	215	MPa	ISO 178

Flexural Strain at Flexural Strength	2.5	%	ISO 178
Maximum operating temperature-Short Term	140	°C	
Insulation Resistance		ohms	IEC 60167
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.0	kJ/m ²	ISO 179/1eA
23°C	7.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1fU
-30°C	30	kJ/m ²	ISO 179/1fU
23°C	35	kJ/m ²	ISO 179/1fU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	240	°C	ISO 75-2/A
Continuous Use Temperature	100	°C	UL 746B
Vicat Softening Temperature	250	°C	ISO 306/A
CLTE - Flow	3.0E-5	cm/cm/°C	DIN 53752
Thermal Conductivity	0.33	W/m/K	DIN 52612
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+4	ohms	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature			
Hot air dryer, A	75	°C	
Vacuum dryer, B	105	°C	
Drying Time			
Hot air dryer, A	6.0 - 16	hr	
Vacuum dryer, B	4.0 - 6.0	hr	
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 - 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.

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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

