LUVOCOM® 1-8841

Polyamide 66

Lehmann & Voss & Co.

Message:

LUVOCOM ® 1-8841 is a polyamide 66 (nylon 66) material, which contains glass fiber reinforcement and aramid fiber. This product is available in Europe. LUVOCOM ® The main features of 1-8841 are: anti-warping Good stiffness Wear-resistant Lubrication Typical application areas include: textile/fiber engineering/industrial accessories Automotive Industry business/office supplies

| General Information | | | | |
|--------------------------------|---------------------------------|--------------------|-------------|--|
| Filler / Reinforcement | Glass fiber reinforced material | | | |
| | Aramid fiber | | | |
| | | | | |
| Additive | PTFE lubricant | PTFE lubricant | | |
| Features | Low friction coefficient | | | |
| | Low warpage | | | |
| | Rigid, good | | | |
| | Good strength | | | |
| | Good wear resistance | | | |
| | Lubrication | | | |
| | | | | |
| Uses | Textile applications | | | |
| | Engineering accessories | | | |
| | Application in Automobile Field | | | |
| | Business equipment | Business equipment | | |
| | | | | |
| Appearance | Black | | | |
| Physical | Nominal Value | Unit | Test Method | |
| Density | 1.44 | g/cm³ | ISO 1183 | |
| Molding Shrinkage | 0.30 - 0.70 | % | DIN 16901 | |
| Water Absorption (23°C, 24 hr) | < 1.0 | % | | |
| Mechanical | Nominal Value | Unit | Test Method | |
| Tensile Modulus | 8000 | MPa | ISO 527-2 | |
| Tensile Stress (Break) | 120 | MPa | ISO 527-2 | |
| Tensile Strain (Yield) | 2.8 | 2.8 % ISO 527-2 | | |
| Flexural Modulus | 7000 | MPa | ISO 178 | |

| Hexural Stress175MPaISO 178Coefficient of Friction0.23Static0.17Flexural Strain at Flexural Strength3.4%ISO 178Maximum operating temperature-Short Term160°CISO 178Nusilation Resistance> 1.0E+12ohmsIEC 6016ThermalNominal ValueUnitTest MerContinuous Use Temperature250°CUL 7468Vicat Softening Temperature250°CISO 3066InjectionNominal ValueUnitISO 3066Nying Temperature250°CISO 3066Vicat Softening Temperature105°CISO 3066Nying Temperature105°CISO 3066Vacuum dryer, 80.016°CISO 3066Vacuum dryer, 80.016°CISO 3066Vacuum dryer, 80.010°CISO 3066Middle Temperature290 310°CISO 3066Nord Source90 310°CISO 3066Nord Source290 310°CISO 3066Middle Temperature290 310°CISO 3066Nord Source290 310°CISO 3066Nord Source90 310°CISO 3066Nord Source290 310°CISO 3066Nord Source90 310°CISO 3066Nord Source90 310°CISO 3066Nord Source90 310°CISO 3066Nord Source90 310°CISO 3066 | | | | | |
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| Dynamic 0.23 Static 0.17 Flexural Strain at Flexural Strength 3.4 % ISO 178 Maximum operating temperature-Short "c Insulation Resistance > 1.0E + 12 ohms IEC 6016 Thermal Nominal Value Unit Test Me Continuous Use Temperature 120 °C U.1746B Vicat Softening Temperature 250 °C ISO 3066 Injection Nominal Value Unit State Dyring Temperature 105 °C State Vacuum dryer, A 75.0 °C State Vacuum dryer, B 0.0 - 16 hr State Suggested Max Moisture 0.10 % State Suggested Max Moisture 290 - 310 °C State Midel Temperature 290 - 310 °C State Front Temperature 290 - 310 °C State Nozzle Temperature 280 - 300 °C State | 178 | Pa ISO 178 | М | 175 | Flexural Stress |
| Static 0.17 Flexural Strain at Flexural Strength 3.4 % ISO 178 Maximum operating temperature-Short Term 160 °C Insulation Resistance > 1.0E + 12 ohms IEC 6016 Thermal Nominal Value Unit Test Me Continuous Use Temperature 120 °C U17468 Vicat Softening Temperature 250 °C ISO 306/ Injection Nominal Value Unit Test Me Orying Temperature 250 °C ISO 306/ Injection Nominal Value Unit Test Me Orying Temperature 150 °C ISO 306/ Vacuum dryer, A 75.0 °C ISO 400 Vacuum dryer, B 105 °C ISO 400 Vacuum dryer, A 6.0 - 16 hr ISO 400 Vacuum dryer, B 4.0 - 6.0 hr ISO 400 Vacuum dryer, B 4.0 - 6.0 hr ISO 400 Suggested Max Moisture 200 - 310 °C ISO 400 < | | | | | Coefficient of Friction |
| Flexural Strain at Flexural Strength3.4%ISO 178Maximum operating temperature-Short Term160*CInsulation Resistance> 1.0E+12ohmsIEC 6016ThermalNominal ValueUnitTest MeContinuous Use Temperature120*CU.7468Vicat Softening Temperature250*CISO 306/InjectionNominal ValueUnitISO 306/Drying Temperature105*CISO 306/Vacuum dryer, B105*C*CMair dryer, A6.0 - 16hr*CVacuum dryer, B6.0 - 16hr*CSuggested Max Moisture0.10%*CRear Temperature290 - 310*C*CMiddle Temperature290 - 310*C*CNozzel Temperature | | | | 0.23 | Dynamic |
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| Term 160 °C Insulation Resistance > 1.0E+12 ohms IEC 6016 Thermal Nominal Value Unit Test Me Continuous Use Temperature 120 °C UL 746B Vicat Softening Temperature 250 °C ISO 306/ Injection Nominal Value Unit ISO 306/ Injector Nominal Value Unit ISO 306/ Injector Nominal Value Unit ISO 306/ Injector Nominal Value Unit ISO 306/ Prying Temperature ISO 300 °C ISO 306/ Vacuum dryer, A 75.0 °C ISO 300/ Vacuum dryer, B 105 °C ISO 300 Vacuum dryer, A 6.0 - 16 hr ISO 300 ISO 300 Suggested Max Moisture 0.10 % ISO 300 °C ISO 300 Middle Temperature 290 - 310 °C ISO 300 °C ISO 300 'C Nozzle Temperature 280 - 300 | 178 | ISO 178 | % | 3.4 | Flexural Strain at Flexural Strength |
| ThermalNominal ValueUnitTest MeContinuous Use Temperature120°CUL 7468Vicat Softening Temperature250°CISO 306/InjectionNominal ValueUnitDrying Temperature105°CCVacuum dryer, B105°CCDrying Time6.0 - 16hrCVacuum dryer, B4.0 - 6.0hrCSuggested Max Moisture0.10%CMiddle Temperature290 - 310°CCFront Temperature290 - 310°CCNozzle Temperature290 - 300°CCNozzle Temperature290 - 310°CCNozzle Temperature290 - 310°CCNozzle Temperature290 - 310°CCProcessing (Melt) Temp290°CC | | | °C | | |
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| InjectionNominal ValueUnitDrying TemperatureHot air dryer, A75.0Vacuum dryer, B105Drying TimeHot air dryer, A6.0 - 16Vacuum dryer, B4.0 - 6.0Vacuum dryer, B0.10Suggested Max Moisture0.10Rear Temperature290 - 310Middle Temperature290 - 310Suzge Temperature290 - 310Processing (Melt) Temp290290300CCNozzle Temperature290Suge Sted Max Moisture280 - 300CCNozzle Temperature290 - 310CCNozzle Temperature280 - 300CCNozzle Temperature290 - 310CCNozzle Temperature290 - 310CCNozzle Temperature290 | '46B | UL 746 | °C | 120 | Continuous Use Temperature |
| Drying Temperature Hot air dryer, A 75.0 °C Vacuum dryer, B 105 °C Drying Time 6.0 - 16 hr Vacuum 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 Nozzle Temperature 280 - 300 °C Nozzle Temperature 280 - 300 °C | 306/A | ISO 300 | °C | 250 | Vicat Softening Temperature |
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| Hot air dryer, A6.0 - 16hrVacuum dryer, B4.0 - 6.0hrSuggested Max Moisture0.10%Rear Temperature290 - 310°CMiddle Temperature290 - 310°CFront Temperature290 - 310°CNozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | °C | 105 | Vacuum dryer, B |
| Vacuum dryer, B4.0 - 6.0hrSuggested Max Moisture0.10%Rear Temperature290 - 310°CMiddle Temperature290 - 310°CFront Temperature290 - 310°CNozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | | | Drying Time |
| Suggested Max Moisture0.10%Rear Temperature290 - 310°CMiddle Temperature290 - 310°CFront Temperature290 - 310°CNozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | hr | 6.0 - 16 | Hot air dryer, A |
| Rear Temperature290 - 310°CMiddle Temperature290 - 310°CFront Temperature290 - 310°CNozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | hr | 4.0 - 6.0 | Vacuum dryer, B |
| Middle Temperature290 - 310°CFront Temperature290 - 310°CNozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | % | 0.10 | Suggested Max Moisture |
| Front Temperature290 - 310°CNozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | °C | 290 - 310 | Rear Temperature |
| Nozzle Temperature280 - 300°CProcessing (Melt) Temp290°C | | | °C | 290 - 310 | Middle Temperature |
| Processing (Melt) Temp 290 °C | | | °C | 290 - 310 | Front Temperature |
| - · · · | | | °C | 280 - 300 | Nozzle Temperature |
| Mold Temperature 90.0 - 120 °C | | | °C | 290 | Processing (Melt) Temp |
| | | | °C | 90.0 - 120 | Mold Temperature |
| Injection instructions | | | | | 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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