

# LUVOCOM® 19-7342

Polyamide 46  
Lehmann & Voss & Co.

Message:

LUVOCOM® 19-7342 is a polyamide 46 (nylon 46) material containing 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 19-7342 are:

Conductivity  
High stiffness  
high strength  
Electrostatic protection  
anti-warping

Typical application areas include:  
engineering/industrial accessories  
textile/fiber  
Automotive Industry  
business/office supplies

General Information			
Filler / Reinforcement	Carbon fiber reinforced material		
Features	Conductivity		
	Low warpage		
	Rigidity, high		
	High strength		
	Electrostatic discharge protection		
Uses	Gear		
	Textile applications		
	Engineering accessories		
	Application in Automobile Field		
	Business equipment		
	Cam		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm <sup>3</sup>	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	20000	MPa	ISO 527-2
Tensile Stress (Break)	225	MPa	ISO 527-2
Tensile Strain (Yield)	1.8	%	ISO 527-2
Flexural Modulus	18000	MPa	ISO 178
Flexural Stress	320	MPa	ISO 178

Flexural Strain at Flexural Strength	2.2	%	ISO 178
Maximum operating temperature-Short Term	160	°C	
Insulation Resistance		ohms	IEC 60167
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Charpy Notched Impact Strength (23°C)	7.0	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	kJ/m <sup>2</sup>	ISO 179/1eU
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Continuous Use Temperature	150	°C	UL 746B
CLTE - Flow	2.0E-5	cm/cm/°C	DIN 53752
Thermal Conductivity	0.33	W/m/K	DIN 52612
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	< 1.0E+3	ohms	IEC 60093
<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>	
Drying Temperature			
A	80.0	°C	
Vacuum dryer, B	80.0	°C	
Drying Time			
A	2.0 - 8.0	hr	
Vacuum dryer, B	2.0 - 12	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	285 - 315	°C	
Middle Temperature	305 - 315	°C	
Front Temperature	305 - 315	°C	
Nozzle Temperature	280 - 330	°C	
Processing (Melt) Temp	310	°C	
Mold Temperature	120 - 140	°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 level should not exceed 0.1%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. As the material absorbs water very rapidly, originally sealed containers should only be opened immediately before 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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