

LUVOCOM® 6-8660

Polyamide 12

Lehmann & Voss & Co.

Message:

LUVOCOM® 6-8660 is a polyamide 12 (nylon 12) material. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is: profile extrusion molding.

LUVOCOM® The main features of 6-8660 are:

Antistatic

moisture resistance

Typical application areas include:

engineering/industrial accessories

textile/fiber

Automotive Industry

business/office supplies

Handle

General Information			
Additive	Antistatic property		
Features	Antistatic property		
	Low or no water absorption		
Uses	Handle		
	Textile applications		
	Engineering accessories		
	Roller		
	Application in Automobile Field		
	Business equipment		
	Profile		
Appearance	Natural color		
Processing Method	Profile extrusion molding		
Physical	Nominal Value	Unit	Test Method
Density	1.03	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (235°C/5.0 kg)	13.0	cm ³ /10min	ISO 1133
Molding Shrinkage	0.70 - 1.0	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 0.10	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1300	MPa	ISO 527-2
Tensile Stress (Break)	42.0	MPa	ISO 527-2
Tensile Strain (Yield)	6.5	%	ISO 527-2
Flexural Modulus	1100	MPa	ISO 178
Flexural Stress	50.0	MPa	ISO 178
Flexural Strain at Flexural Strength	7.2	%	ISO 178

Maximum operating temperature-Short Term	140	°C	
Insulation Resistance	1.0E+9	ohms	IEC 60167
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	16	kJ/m ²	ISO 179/1eA
23°C	38	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1fU
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature	90.0	°C	UL 746B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+13	ohms	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature			
A	75.0	°C	
B	105	°C	
Drying time-A	6.0 - 10	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	230 - 250	°C	
Middle Temperature	240 - 260	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	250 - 260	°C	
Processing (Melt) Temp	250	°C	
Mold Temperature	70.0 - 110	°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. As the material absorbs water 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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