

LUVOTECH® MR 1025 BK

Polyamide 66

Lehmann & Voss & Co.

Message:

LUVOTECH®MR 1025 BK is a polyamide 66 (nylon 66) material that contains a mineral filler. This product is available in Europe. LUVOTECH®The main characteristics of MR 1025 BK are: anti-warping.

Typical application areas include:

textile/fiber

engineering/industrial accessories

Automotive Industry

business/office supplies

General Information			
Filler / Reinforcement	Mineral filler		
Features	Low warpage		
Uses	Textile applications		
	Engineering accessories		
	Application in Automobile Field		
	Business equipment		
Appearance	Black		
Physical	Nominal Value	Unit	Test Method
Density	1.51	g/cm ³	ISO 1183
Molding Shrinkage	0.60 - 1.2	%	DIN 16901
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11000	MPa	ISO 527-2
Tensile Stress (Break)	110	MPa	ISO 527-2
Tensile Strain (Yield)	2.5	%	ISO 527-2
Flexural Modulus	9000	MPa	ISO 178
Flexural Stress	165	MPa	ISO 178
Coefficient of Friction			
Dynamic	0.45		
Static	0.40		
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	25	kJ/m ²	ISO 179/1fU
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature	120	°C	UL 746B
Maximum operating temperature-Short Term	140	°C	
Vicat Softening Temperature	240	°C	ISO 306
Injection	Nominal Value	Unit	

Drying Temperature		
Hot air dryer, A	75.0	°C
Vacuum dryer, B	105	°C
Drying Time		
Hot air 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
Front Temperature	290 - 310	°C
Nozzle Temperature	280 - 300	°C
Processing (Melt) Temp	290	°C
Mold Temperature	90.0 - 120	°C
Injection instructions		

General

In general LUVOTECH® 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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