

# LUVOCOM® 1/XCF/25

Polyamide 66  
Lehmann & Voss & Co.

Message:

LUVOCOM® 1/XCF/25 is a polyamide 66 (nylon 66) material, which contains a 25% 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 1/XCF/25 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, 25% filler by weight		
Additive	heat stabilizer		
Features	Good dimensional stability		
	Conductivity		
	Low warpage		
	Rigidity, high		
	High strength		
	Electrostatic discharge protection		
	Thermal Stability		
Uses	Gear		
	Textile applications		
	Engineering accessories		
	Application in Automobile Field		
	Business equipment		
	Cam		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage	0.20 - 0.40	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 1.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	21000	MPa	ISO 527-2
Tensile Stress (Break)	295	MPa	ISO 527-2

Tensile Strain (Yield)	2.5	%	ISO 527-2
Flexural Modulus	18000	MPa	ISO 178
Flexural Stress	420	MPa	ISO 178
Flexural Strain at Flexural Strength	3.1	%	ISO 178
Maximum operating temperature-Short Term	160	°C	
Insulation Resistance		ohms	IEC 60167
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	90	kJ/m <sup>2</sup>	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	°C	ISO 75-2/A
Continuous Use Temperature	120	°C	UL 746B
CLTE - Flow	1.4E-5	cm/cm/°C	DIN 53752
Thermal Conductivity	0.50	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	75.0	°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 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

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