LUVOTECH® 1850-9218

Polybutylene Terephthalate

LEHVOSS Group

Message:

LUVOTECH®1850-9218 is a polybutene terephthalate (PBT) material, which contains mineral fillers. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.
LUVOTECH®The main features of 1850-9218 are:
anti-warping
Good stiffness
Typical application areas include:
engineering/industrial accessories
textile/fiber
Automotive Industry
business/office supplies

General Information			
Filler / Reinforcement	Mineral filler		
Features	Low warpage Rigid, good Good strength		
Uses	Gear Textile applications Engineering accessories Application in Automobile Field Business equipment		
Appearance	Black		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.84	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	21	g/10 min	ISO 1133
Molding Shrinkage	0.20 - 0.50	%	DIN 16901
Water Absorption (23°C, 24 hr)	< 0.10	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	10000	MPa	ISO 527-2
Tensile Stress (Break)	61.0	MPa	ISO 527-2
Tensile Strain (Yield)	1.3	%	ISO 527-2
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength (23°C)	14	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Continuous Use Temperature	130	°C	UL 746B
Maximum operating temperature-Short Term	180	°C	

Insulation Resistance	> 1.0E+10	ohms	IEC 60167
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+10	ohms	IEC 60093
Injection	**Nominal Value**	**Unit**	
Drying Temperature			
Hot air dryer, A	120	°C	
Vacuum dryer, B	80	°C	
Drying Time			
Hot air dryer, A	4.0 - 6.0	hr	
Vacuum dryer, B	6.0 - 8.0	hr	
Rear Temperature	240 - 260	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	250 - 270	°C	
Nozzle Temperature	250 - 265	°C	
Processing (Melt) Temp	250	°C	
Mold Temperature	60 - 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 0.02%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. As the material absorbs water very quickly, the predried material should be fed to the processing immediately. Processing temperatures above 270°C may very rapidly cause thermal damage and should therefore be avoided.
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.

Recommended distributors for this material

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