

LUVOCOM® 1105-7714

 LEHOSS Group - *Polyetheretherketone*
General Information
Product Description

with PTFE lubricant modified, easy flowing; graphite grey

Main Features

- Improved friction and wear behaviour. Optimised for dry running operations.
- Chemically- and hydrolytically- resistant parts, non flammable.
- Dynamically-stressed parts moving at high velocity.
- High dimensionally stable precision parts.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• PTFE Lubricant		
Features	• Chemical Resistant • Good Flow • High Dimensional Stability	• Hydrolytically Stable • Ignition Resistant • Low Friction	• Lubricated • Wear Resistant
Appearance	• Grey		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm ³	ISO 1183
Molding Shrinkage			DIN 16742
Across Flow	1.1 to 1.5	%	
Flow	0.80 to 1.2	%	
Water Absorption (24 hr, 73°F)	< 0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	580000	psi	ISO 527-1/1
Tensile Stress	11600	psi	ISO 527-2
Tensile Strain (Yield)	3.3	%	ISO 527-2/50
Flexural Modulus ²	493000	psi	ISO 178
Flexural Stress ³	15200	psi	ISO 178
Flexural Strain - (Yield) ⁴	4.4	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	15	ft·lb/in ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature ⁵	482	°F	IEC 60216
CLTE - Flow	2.8E-5	in/in/°F	ISO 11359-2
Service Temperature - during lifetime max. 200 hr	500	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		Internal Method

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer, A	302	°F
Desiccant Dryer, B	248	°F
Drying Time		
Desiccant Dryer, A	3.0 to 6.0	hr
Desiccant Dryer, B	6.0 to 8.0	hr



Rear Temperature	680 to 698 °F
Middle Temperature	716 to 734 °F
Front Temperature	734 to 752 °F
Nozzle Temperature	680 to 716 °F
Processing (Melt) Temp	734 °F
Mold Temperature	338 to 392 °F

Injection Notes

During processing, the moisture level should not exceed 0.01%, otherwise molecular degradation may occur. As the material absorbs water very quickly, the predried material should be fed to the processing immediately. 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.

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.079 in/min

³ 0.39 in/min

⁴ 10 mm/min

⁵ 20,000 hr

