LUVOCOM® 1106-8769/GY

LEHVOSS Group - *Polyetherimide*

General Information

Product Description

with mineral filler, easy flowing; grey

Main Features

- Very stiff parts with low creep.
- High dimensionally stable precision parts, even at elevated temperatures and narrow tolerance range.
- Low warpage.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Mineral		
Features	• Creep Resistant • Good Flow	• High Dimensional Stability • High Heat Resistance	• Low Warpage • Ultra High Stiffness
Appearance	• Grey		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.78	g/cm³	ISO 1183
Water Absorption (24 hr, 73°F)	< 0.30	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2.03E+6	psi	ISO 527-1/1
Tensile Stress	16000	psi	ISO 527-2
Tensile Strain (Yield)	1.1	%	ISO 527-2/50
Flexural Modulus [2]	1.81E+6	psi	ISO 178
Flexural Stress [3]	24400	psi	ISO 178
Flexural Strain - (Yield) [4]	1.3	%	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
--	1.7	ft·lb/in²	
-22°F	1.4	ft·lb/in²	
Charpy Unnotched Impact Strength			ISO 179/1eU
--	7.1	ft·lb/in²	
-22°F	6.7	ft·lb/in²	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	374	°F	ISO 75-2/A
Continuous Use Temperature [5]	338	°F	IEC 60216
CLTE - Flow	1.1E-5	in/in/°F	ISO 11359-2
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+12	ohms	IEC 62631-3-2
Insulation Resistance [6]	> 1.0E+12	ohms	IEC 62631-3-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer, A	248	°F
Desiccant Dryer, B	302	°F
Drying Time		

Desiccant Dryer, A	> 8.0 hr
Desiccant Dryer, B	> 4.0 hr
Rear Temperature	680 to 716 °F
Middle Temperature	680 to 716 °F
Front Temperature	698 to 734 °F
Nozzle Temperature	716 to 752 °F
Processing (Melt) Temp	716 °F
Mold Temperature	320 to 374 °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

[6] strip electrode R25