LUVOCOM® 3F PAHT 9825 NT

LEHVOSS Group - *Polyamide 66 + PA 6I/6T*

General Information

Product Description

unreinforced; natural color

Main Features

- Low influence from moisture and temperature on dimensional stability and electrical properties, compared with PA6.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Dimensional Stability • Good Electrical Properties	• Good Heat Resistance • Low Moisture Absorption	
Appearance	• Natural Color		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	3.6	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	3.5	cm³/10min	ISO 1133
Water Absorption (24 hr, 73°F)	< 0.30	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	493000	psi	ISO 527-1/1
Tensile Stress	12300	psi	ISO 527-2
Tensile Strain (Yield)	3.6	%	ISO 527-2/50
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength	No Break		ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	194	°F	ISO 75-2/A
Continuous Use Temperature [2]	248	°F	IEC 60216
CLTE - Flow	2.8E-6	in/in/°F	ISO 11359-2
Thermal Conductivity [3]	2.1	Btu·in/hr/ft²/°F	ISO 22007
Service Temperature - during lifetime max. 200 hr	320	°F	
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+12	ohms	IEC 62631-3-2
Insulation Resistance [4]	> 1.0E+12	ohms	IEC 62631-3-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
--	248	°F
Desiccant Dryer, A	266	°F
Drying Time		
--	4.0 to 6.0	hr
Desiccant Dryer, A	6.0 to 8.0	hr
Rear Temperature	500 to 572	°F
Middle Temperature	500 to 572	°F
Front Temperature	500 to 572	°F
Nozzle Temperature	482 to 554	°F

Injection Notes

塑料专家 www.ponci.com.cn/wxb/ +13538586433 +18816996168

3D Printing parameters may vary from machine to machine. The following settings may be used as an indication: nozzle temperature: 265 - 290 °C / nozzle material: abbrasion resistant / print bed temperature: > 50 °C / layer thickness: > 0,2mm / printing speed 40 - 60 mm/s.
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.

In general LUVOCOM® 3F can be processed on conventional extrusion machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder, screw and die 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!

Notes

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

[2] 20,000 hr

[3] in plane; hot disk

[4] strip electrode R25

塑料专家 www.ponci.com.cn/wxb/ +13538586433 +18816996168