LUVOCOM® 70-9113/BK

LEHVOSS Group - *Polyketone*

General Information

Product Description

with PTFE lubricant modified, easy flowing, demolding aid; black

Main Features

- Improved friction and wear behaviour. Optimised for dry running operations.
- Sliding-couples with a low friction coefficient.
- Chemically- and hydrolytically- resistant parts.

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Mold Release	• PTFE Lubricant	
Features	• Chemical Resistant • Good Flow	• Hydrolytically Stable • Low Friction	• Lubricated • Wear Resistant
Appearance	• Black		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	30	cm³/10min	ISO 1133
Water Absorption (24 hr, 73°F)	0.15	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	218000	psi	ISO 527-1/1
Tensile Stress	8270	psi	ISO 527-2
Tensile Strain (Yield)	18	%	ISO 527-2/50
Flexural Modulus [2]	218000	psi	ISO 178
Flexural Stress [3]	9860	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	3.8	ft·lb/in²	ISO 179/1eA
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	212	°F	ISO 75-2/A
Continuous Use Temperature [4]	194	°F	IEC 60216
Vicat Softening Temperature	392	°F	ISO 306/A
Service Temperature - during lifetime max. 200 hr	248	°F	
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+12	ohms	IEC 62631-3-2
Insulation Resistance [5]	> 1.0E+12	ohms	IEC 62631-3-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
--	176	°F
Desiccant Dryer, A	248	°F
Drying Time		
--	2.0 to 6.0	hr
Desiccant Dryer, A	1.0 to 4.0	hr
Rear Temperature	428 to 455	°F
Middle Temperature	428 to 464	°F
Front Temperature	428 to 464	°F

Nozzle Temperature	446 to 473 °F
Processing (Melt) Temp	455 °F
Mold Temperature	140 to 212 °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] 20,000 hr

[5] strip electrode R25