

**LUVOTECH® eco PAHT GF50 HS BK**

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

**General Information**
**Product Description**

with glass fibers, heat stabilized; black; PA66 + PA6 I/X

**Main Features**

- Strong, stiff, impact-resistant parts.
- Dynamically-stressed parts.

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Filler / Reinforcement	• Glass Fiber
Additive	• Heat Stabilizer
Features	• Heat Stabilized • High Impact Resistance • High Stiffness • High Strength
Appearance	• Black

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density	1.57	g/cm <sup>3</sup>	ISO 1183
Water Absorption (24 hr, 73°F)	< 0.50	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.39E+6	psi	ISO 527-1/1
Tensile Stress	29000	psi	ISO 527-2
Tensile Strain (Yield)	2.3	%	ISO 527-2/50
Flexural Modulus <sup>2</sup>	2.03E+6	psi	ISO 178
Flexural Stress <sup>3</sup>	42100	psi	ISO 178
Flexural Strain - (Yield) <sup>4</sup>	2.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.7	ft-lb/in <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength	38	ft-lb/in <sup>2</sup>	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	466	°F	ISO 75-2/A
Continuous Use Temperature <sup>5</sup>	248	°F	IEC 60216
CLTE - Flow	8.3E-6	in/in/°F	ISO 11359-2
Service Temperature - during lifetime max. 200 hr	392	°F	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+12	ohms	IEC 62631-3-2
Insulation Resistance <sup>6</sup>	> 1.0E+12	ohms	IEC 62631-3-3

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	--	221 °F
Desiccant Dryer, A		176 °F
Drying Time	--	3.0 to 10 hr
Desiccant Dryer, A		4.0 to 12 hr
Rear Temperature		536 to 572 °F



Middle Temperature	554 to 590 °F
Front Temperature	563 to 599 °F
Nozzle Temperature	554 to 590 °F
Mold Temperature	194 to 248 °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

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 0.079 in/min

<sup>3</sup> 0.39 in/min

<sup>4</sup> 10 mm/min

<sup>5</sup> 20,000 hr

<sup>6</sup> strip electrode R25

