

LUVOCOM® 1-0865

LEHOSS Group - Polyamide 66

General Information
Product Description

with aramid reinforcement, heat stabilized; natural color (yellow)

Main Features

- Improved heat resistance.
- Low warpage.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Aramid Fiber		
Additive	• Heat Stabilizer		
Features	• Good Heat Resistance	• Heat Stabilized	• Low Warpage
Appearance	• Yellow		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Water Absorption (24 hr, 73°F)	< 1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	624000	psi	ISO 527-1/1
Tensile Stress	14500	psi	ISO 527-2
Tensile Strain (Yield)	5.0	%	ISO 527-2/50
Flexural Modulus ²	508000	psi	ISO 178
Flexural Stress ³	20300	psi	ISO 178
Flexural Strain - (Yield) ⁴	6.0	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.9	ft·lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	464	°F	ISO 75-2/A
Continuous Use Temperature ⁵	248	°F	IEC 60216
Service Temperature - during lifetime max. 200 hr	320	°F	
Electrical	Nominal Value	Unit	Test Method
Insulation Resistance ⁶	> 1.0E+12	ohms	IEC 62631-3-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer, A	167	°F
Vacuum Dryer, B	221	°F
Drying Time		
Desiccant Dryer, A	6.0 to 16	hr
Vacuum Dryer, B	4.0 to 6.0	hr
Rear Temperature	554 to 590	°F
Middle Temperature	554 to 590	°F
Front Temperature	554 to 590	°F
Nozzle Temperature	536 to 572	°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

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

