

**LUVOCOM® 1850-8652**

 LEHVOSS Group - *Polybutylene Terephthalate*
**General Information**
**Product Description**

with glass fibers, thermally conductive modified; black

## Main Features

- Strong, stiff parts.
- Low warpage.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber		
Features	• High Stiffness	• Low Warpage	
	• High Strength	• Thermally Conductive	
Appearance	• Black		

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

Physical	Nominal Value	Unit	Test Method
Density	1.62	g/cm <sup>3</sup>	ISO 1183
Water Absorption (24 hr, 73°F)	< 0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.89E+6	psi	ISO 527-1/1
Tensile Stress	7540	psi	ISO 527-2
Tensile Strain (Yield)	0.40	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	2.9	ft·lb/in <sup>2</sup>	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature <sup>2</sup>	266	°F	IEC 60216
Thermal Conductivity <sup>3</sup>	100	Btu·in/hr/ft <sup>2</sup> /°F	ISO 22007
Service Temperature - during lifetime max. 200 hr	356	°F	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+5	ohms	IEC 62631-3-2
Insulation Resistance <sup>4</sup>	< 1.0E+5	ohms	IEC 62631-3-3

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer, A	248	°F
Vacuum Dryer, B	176	°F
Drying Time		
Desiccant Dryer, A	4.0 to 6.0	hr
Vacuum Dryer, B	6.0 to 8.0	hr
Rear Temperature	464 to 500	°F
Middle Temperature	500 to 536	°F
Front Temperature	482 to 518	°F
Nozzle Temperature	482 to 509	°F
Processing (Melt) Temp	482	°F
Mold Temperature	140 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> 20,000 hr

<sup>3</sup> in plane; hot disk

<sup>4</sup> strip electrode R25

