

**LUVOCOM® 1850/TF/30**

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

with PTFE; natural color (white)

**Main Features**

- Improved friction and wear behaviour. Optimised for dry running operations.
- Isotropic shrinkage characteristics.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• PTFE Lubricant		
Features	• Low Friction	• Lubricated	• Wear Resistant
Appearance	• White		

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

Physical	Nominal Value	Unit	Test Method
Density	1.46	g/cm <sup>3</sup>	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	14	cm <sup>3</sup> /10min	ISO 1133
Water Absorption (24 hr, 73°F)	< 0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	363000	psi	ISO 527-1/1
Tensile Stress	5800	psi	ISO 527-2
Tensile Strain (Yield)	3.5	%	ISO 527-2/50
Flexural Modulus <sup>2</sup>	290000	psi	ISO 178
Flexural Stress <sup>3</sup>	10200	psi	ISO 178
Flexural Strain - (Yield) <sup>4</sup>	5.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	2.4	ft-lb/in <sup>2</sup>	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature <sup>5</sup>	266	°F	IEC 60216
Vicat Softening Temperature	329	°F	ISO 306/A
Service Temperature - during lifetime max. 200 hr	302	°F	
Electrical	Nominal Value	Unit	Test Method
Insulation Resistance <sup>6</sup>	> 1.0E+12	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



**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

