

**LUVOCOM® 1105-7685/L**

LEHOSS Group - Polyetheretherketone

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

unreinforced; natural color

**Main Features**

- Highly chemically-resistant parts, non flammable.
- Suitable for biocompatibility.
- Superheated-steam sterilisable.
- Inherent flame resistance.

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Biocompatible	• Flame Retardant	• Steam Sterilizable
	• Chemical Resistant	• Ignition Resistant	
Appearance	• Natural Color		

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

Physical	Nominal Value	Unit	Test Method
Density	1.29	g/cm <sup>3</sup>	ISO 1183
Melt Volume-Flow Rate (MVR) (380°C/10.0 kg)	20	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage			DIN 16742
Across Flow	1.4 to 1.7	%	
Flow	1.1 to 1.4	%	
Water Absorption (24 hr, 73°F)	0.50	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	522000	psi	ISO 527-1/1
Tensile Stress	14500	psi	ISO 527-2
Tensile Strain (Yield)	5.0	%	ISO 527-2/50
Flexural Modulus <sup>2</sup>	435000	psi	ISO 178
Flexural Stress <sup>3</sup>	21000	psi	ISO 178
Flexural Strain - (Yield) <sup>4</sup>	6.5	%	ISO 178
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature <sup>5</sup>	482	°F	IEC 60216
Vicat Softening Temperature	572	°F	ISO 306/A
Service Temperature - during lifetime max. 200 hr	500	°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	302	°F
Desiccant Dryer, B	248	°F
Drying Time		
Desiccant Dryer, A	3.0 to 6.0	hr
Desiccant Dryer, B	6.0 to 8.0	hr
Rear Temperature	680 to 698	°F
Middle Temperature	716 to 734	°F
Front Temperature	734 to 752	°F



Nozzle Temperature	680 to 716 °F
Processing (Melt) Temp	734 °F
Mold Temperature	338 to 392 °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

