

LUVOCOM® 1105-8356

LEHOSS Group - Polyetheretherketone

General Information
Product Description

unreinforced; natural color (beige)

Main Features

- Highly chemically-resistant parts, non flammable.
- Low warpage, isotropic shrinkage characteristics.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Chemical Resistant	• Ignition Resistant	• Low Warpage
Appearance	• Beige		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (380°C/10.0 kg)	22	cm ³ /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)	< 0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	580000	psi	ISO 527-1/1
Tensile Stress	13800	psi	ISO 527-2
Tensile Strain (Yield)	5.0	%	ISO 527-2/50
Flexural Modulus ²	508000	psi	ISO 178
Flexural Stress ³	23200	psi	ISO 178
Flexural Strain - (Yield) ⁴	6.0	%	ISO 178
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	302	°F	ISO 75-2/A
Continuous Use Temperature ⁵	482	°F	IEC 60216
Service Temperature - during lifetime max. 200 hr	500	°F	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+12	ohms	IEC 62631-3-2
Insulation Resistance ⁶	> 1.0E+12	ohms	IEC 62631-3-3
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		Internal Method

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	698 to 752 °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

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

