

LUVOCOM® 1301-8724

 LEHOSS Group - *Linear Polyphenylene Sulfide*
General Information
Product Description

with glass fibers and mineral filler; natural color (black)

Main Features

- Electrically conductive, suitable for continuous discharging of statically-generated electricity.
- Strong, stiff parts.
- Low warpage.

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	2.44	g/cm ³	ISO 1183
Water Absorption (24 hr, 73°F)	< 0.050	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.89E+6	psi	ISO 527-1/1
Tensile Stress	12300	psi	ISO 527-2
Tensile Strain (Yield)	0.90	%	ISO 527-2/50
Flexural Modulus ²	1.60E+6	psi	ISO 178
Flexural Stress ³	17400	psi	ISO 178
Flexural Strain - (Yield) ⁴	1.3	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength	4.3	ft-lb/in ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Continuous Use Temperature ⁵	428	°F	IEC 60216
Vicat Softening Temperature	419	°F	ISO 306/A
Service Temperature - during lifetime max. 200 hr	464	°F	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+9	ohms	IEC 62631-3-2
Insulation Resistance ⁶	1.0E+4 to 1.0E+8	ohms	IEC 62631-3-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
--	122 to 194	°F
Desiccant Dryer, A	212 to 284	°F
Drying Time		
--	> 4.0	hr
Desiccant Dryer, A	2.0 to 4.0	hr
Rear Temperature	572 to 608	°F
Middle Temperature	590 to 626	°F
Front Temperature	608 to 644	°F



Nozzle Temperature	608 to 644 °F
Processing (Melt) Temp	626 °F
Mold Temperature	302 to 356 °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

