

**LUVOTECH® MR 2007 BK**

Polyamide 6  
with mineral filler, black

Physical properties		Test method	Units	Typical value
Specific gravity		ISO 1183-3	g/cm <sup>3</sup>	1,44
Linear mould shrinkage		DIN 16742	%	0,6-1,2

Mechanical properties at 23°C / 50% rh				
Tensile strength	dry, @50 mm/min	ISO 527	MPa	96
Elongation @Fmax.	dry, @50 mm/min	ISO 527	%	3,2
Tensile modulus	dry, @1 mm/min	ISO 527	GPa	8,3
Flexural strength	dry, @10 mm/min	ISO 178	MPa	150
Flexural elongation @Fmax.	dry, @10 mm/min	ISO 178	%	4,2
Flexural modulus	dry, @2 mm/min	ISO 178	GPa	7,2
Impact strength	dry	ISO 179 1eU	kJ/m <sup>2</sup>	36

Thermal properties				
Vicat softening temp.	VST A	DIN ISO 306	°C	205
Continuous service temp.	20.000 h	IEC 60216	°C	120
Service temperature	during lifetime max. 200h		°C	160

**Main features**

Low warpage. Isotropic shrinkage characteristics.

Polyamide 6  
 with mineral filler, black

## Recommended processing parameters

### Delivery form & storage

Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.

### Predrying

It is advisable to predry the granules with a suitable dryer immediately before processing. The granule may absorb moisture from the environment.

Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	75	10 - 16
or	105	4 - 6

### Recommended processing parameters

In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!

Mold	Nozzle	Zone 3	Zone 2	Zone 1
70 - 110 °C	270 - 280 °C	280 - 300 °C	270 - 290 °C	250 - 270 °C

### Additional information

During processing the moisture level should not exceed 0.05%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. Excessively high predrying temperatures may cause discoloration. 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.