

Preliminary data sheet.

LUVOCOM 3F PA^{HT} 9825 NT

**Polyamide based material
natural color**

Physical Properties		Test Method	Specimen	Units	Typical Value
Specific Gravity		ISO 1183	MPTS ISO 3167 A	g/cm ³	1,20
Water Absorption	23 °C / 24 h		MPTS ISO 3167 A	%	<0,3
Melt Flow Rates	MFR	ISO 1133	pellet	g/10 Min	3,60
Melt Volume Rate	MVR	ISO 1133	pellet	cm ³ /10 Min	3,47
Linear Mould Shrinkage	VSR 3mm	DIN 16901	MPTS ISO 3167 A	%	0,3-0,5
Flamability Behaviour		UL 94	1/16"	-	
Mechanical Properties					
at 23°C/50% rh					
Tensile Strength	σ_{zM}	ISO 527	MPTS ISO 3167 A	MPa	85
Elongation	ϵ_{zM}	ISO 527	MPTS ISO 3167 A	%	3,6
Modulus of Elasticity	E_t	ISO 527	MPTS ISO 3167 A	GPa	3,4
Flexural Strength	σ_{bM}	ISO 178	MPTS ISO 3167 A	MPa	
Flexural Elongation	ϵ_{bM}	ISO 178	MPTS ISO 3167 A	%	
Flexural Modulus	E_{3B}	ISO 178	MPTS ISO 3167 A	GPa	
Charpy Impact Strength		ISO 179 1eU	MPTS ISO 3167 A	kJ/m ²	NB
Charpy Impact Strength	-30°C	ISO 179 1eU	MPTS ISO 3167 A	kJ/m ²	
Charpy Impact Strength notched		ISO 179 eA	MPTS ISO 3167 A	kJ/m ²	
Charpy Impact Strength notched	-30°C	ISO 179 eA	MPTS ISO 3167 A	kJ/m ²	
Thermal Properties					
Vicat Softening Temp.	VST A	DIN ISO 306	MPTS ISO 3167 A	°C	
Heat Distortion Temp.	HDT A	ISO 75	MPTS ISO 3167 A	°C	90
Continuous Service Temp.		UL 746B	MPTS ISO 3167 A	°C	120
Maximum (short term) Use Temp.				°C	160
Coefficient of Thermal Expansion		DIN 53752		10 ⁻⁵ /K	0,5
Thermal Conductivity		HOT-DISK	60x60x3 mm	W/mK	0,3
Electrical Properties					
Insulation Resistance	Strip electrode	R ₂₅	DIN/IEC 60167	MPTS ISO 3167 A	Ω >10 ¹²
Surface Resistance		R _{OB}	DIN IEC 60093	Ronde 60x4 mm	Ω >10 ¹²
Tribological Properties					
Coeff. of Friction μ	dynamic	15Hz 21N	DIN 51834	MPTS ISO 3167	N/N
Coeff. of Friction μ		40mm/s 21N	LuV	MPTS ISO 3167	N/N

Application Examples

9825

strong and tough parts.

Low influence from moisture and temperature to measures and electrical properties, compared with PA66

Automotive industry, textile- and office machinery, apparatus- and precision engineering.

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Recommended Processing Instructions

General

In general LUVOCOM® 3F can be processed on conventional extrusion machines while observing the usual technical guidelines.
Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder, screw and die 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!

Predrying

(optional)

It is advisable to predry the granulate with a suitable dryer immediately before processing.
The granulate may absorb moisture from the air.

Dryer type	Temperature°C	Drying time in h
Dehumidifying dryer	130	6 to 8
Vacuum Dryer	120	4 to 6

Processing Temperatures

Zone 1	°C	260 to 300
Zone 2	°C	260 to 300
Zone 3	°C	260 to 300
Nozzle	°C	250 to 290
Mass-Temperature	°C	optimum 280

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.

Additional Information

The filament can be wound into standard size spools.

3D Printing parameters may vary from machine to machine, the following settings can be used as an indication:

Nozzle temperature: 270 - 290 °C Print Bed Temperature: > 50 °C Layer Thickness: >0,1mm

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.

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