

LUVOTECH® PAHT GF50 HS BK

LEHVOSS Group - Polyamide 66 + PA 6I/6T

General Information

Product Description

with glass fibers, heat stabilized; black; PA66 + PA6 I/X

Main Features

- Strong, stiff, impact-resistant parts.
- Dynamically-stressed parts.

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber
Additive	• Heat Stabilizer
Features	• Heat Stabilized • High Stiffness • High Impact Resistance • High Strength
Appearance	• Black

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.58	g/cm ³	ISO 1183
Water Absorption (24 hr, 73°F)	< 0.50	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.18E+6	psi	ISO 527-1/1
Tensile Stress	33400	psi	ISO 527-2
Tensile Strain (Yield)	2.6	%	ISO 527-2/50
Flexural Modulus ²	2.03E+6	psi	ISO 178
Flexural Stress ³	49300	psi	ISO 178
Flexural Strain - (Yield) ⁴	2.8	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
--	7.1	ft·lb/in ²	
-22°F	6.7	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
--	40	ft·lb/in ²	
-22°F	38	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	446	°F	ISO 75-2/A
Continuous Use Temperature ⁵	248	°F	IEC 60216
Vicat Softening Temperature	482	°F	ISO 306/A
Service Temperature - during lifetime max. 200 hr	392	°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

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
--	221	°F
Desiccant Dryer, A	176	°F



Drying Time	
--	3.0 to 10 hr
Desiccant Dryer, A	4.0 to 12 hr
Rear Temperature	536 to 572 °F
Middle Temperature	554 to 590 °F
Front Temperature	563 to 599 °F
Nozzle Temperature	554 to 590 °F
Mold Temperature	194 to 248 °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

