LUVOCOM 3F PAHT® CF 9742 BK



High-temperature polyamide with carbon fibers, black

Physical properties		Test method	Specimen	Units	Typical value		
Specific gravity		ISO 1183-3		g/cm³	1,25		
Water absorption	23°C / 24h	ISO 62	ISO 3167 A	%	<0,3		
Linear mould shrinkage		DIN 16742	ISO 3167 A	%	0,00-0,1		
Mechanical properties at 23°C / 50% rh							
Tensile strength	dry, @50 mm/min	ISO 527	ISO 3167 A	MPa	170		
Elongation @Fmax.	dry, @50 mm/min	ISO 527	ISO 3167 A	%	1		
Tensile modulus	dry, @1 mm/min	ISO 527	ISO 3167 A	GPa	15		
Impact strength	dry	ISO 179 1eU	80x10x4mm	kJ/m²	47		
Thermal properties							
Heat distortion temp.	HDT A	ISO 75	80x10x4mm	°C	200		
Continuous service temp.	20.000 h	IEC 60216	ISO 3167 A	°C	150		
Service temperature	during lifetime max. 200h		ISO 3167 A	°C	180		
CLTE, longitudinal		ISO 11359	10x8x4 mm	10⁻⁵/K	0,4		
Therm. conductivity in plane	hot disk	ISO 22007	60x60x3 mm	W/mK	1		
Electrical properties							
Insulation resistance	strip electrode R25	DIN EN 62631-3-3	ISO 3167 A	Ω	≤10²		
Surface resistance	ROB	DIN EN 62631-3-2	Ronde 60x4mm	Ω	<10²		

Main features

Easy to print. No warping. High z-strength.

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Recommended processing parameters

General

3D Printing parameters may vary from machine to machine. The following settings may be used as an indication: nozzle temperature: 265 - 290 °C / nozzle material: abbrasion resistant / print bed temperature: > 50 °C / layer thickness: > 0,2mm / printing speed 40 - 60 mm/s.

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.

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	130	6 - 8
Vacuum Dryer	120	4 - 6

Recommended processing parameters

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!

Nozzle	Zone 3	Zone 2	Zone 1
250 - 290 °C	260 - 300 °C	260 - 300 °C	260 - 300 °C

Additional information

Filaments produced from this material may be wound into standard size spools.

09742 18 02 20 **Europe and Head Office** North America Asia Lehmann&Voss&Co. KG LEHVOSS North America, LLC LEHVOSS (Shanghai) Chemical Trading Co., Ltd. 185 South Broad Street Unit 4805, 8 Xingyi Road Alsterufer 19 LEHVOSS Changning District, Shanghai 200336 20354 Hamburg Pawcatuck, CT 06379 USA Germany China Tel +49 40 44 197-0 Tel +1-855-681-3226 Tel +86 21 62785181 Email: luvocom@lehvoss.de Email: info@lehvoss.us Email: info@lehvoss.cn

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