

LUVOCOM® 3F PP 9929 NT

Polypropylene-copolymer
unreinforced, natural

Physical properties		Test method	Specimen	Units	Typical value
Specific gravity		ISO 1183-3		g/cm ³	0,9
Water absorption	23°C / 24h	ISO 62	ISO 3167 A	%	<0,3
Melt volume rate (MVR)		230°C / 2,16kg	pellet	cm ³ /10 min	9

Mechanical properties at 23°C / 50% rh					
Tensile strength	dry, @50 mm/min	ISO 527	ISO 3167 A	MPa	15
Elongation @Fmax.	dry, @50 mm/min	ISO 527	ISO 3167 A	%	6
Elongation at break	dry, @50 mm/min	ISO 527	ISO 3167 A	%	500
Flexural modulus	dry, @2 mm/min	ISO 178	ISO 3167 A	GPa	0,75
Impact strength, notched	dry	ISO 179 1eA	80x10x4mm	kJ/m ²	65
Charpy Impact Strength notched	-30°C	ISO 179 1eA	80x10x4mm	kJ/m ²	10

Thermal properties					
Vicat softening temp.	VST A	DIN ISO 306	ISO 3167 A	°C	135
Heat distortion temp.	HDT B	ISO 75	80x10x4mm	°C	80

Electrical properties					
Insulation resistance	strip electrode R25	DIN EN 62631-3-3	ISO 3167 A	Ω	>10 ¹²
Surface resistance	ROB	DIN EN 62631-3-2	Ronde 60x4mm	Ω	>10 ¹²

Main features

Reduced moment of inertia compared with metal parts.

Recommended processing parameters

General

3D Printing parameters may vary from machine to machine. The following settings may be used as an indication: nozzle temperature: 220 - 250 °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

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Any recommendations made for use of Seller's materials are made to the best of Seller's knowledge and are based upon prior tests and experience of the Seller believed to be reliable; however, Seller does not guarantee the results to be obtained and all such recommendations are non-binding – also with regard to the protection of third party's rights –, do not constitute any representation and do not affect in any way Buyer's obligation to examine and/or test the Seller's goods with regard to their suitability for Buyer's purposes. No information given by the Seller is to be construed in any way as a guarantee regarding characteristics or duration of use, unless such information has been explicitly given as a guarantee.

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from the environment.

Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	70 - 95	2 - 4

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!

Mold	Melt temperature	Nozzle	Zone 3	Zone 2	Zone 1
40 - 80 °C	60 °C	220 - 250 °C	230 - 260 °C	220 - 250 °C	220 - 250 °C

Additional information

During processing, the moisture content should not exceed 0.2%. Moisture may lead to smearing and in extreme cases to foaming. Usually the material can be processed over a broad temperature range and can thus be adapted to a wide variety of processing conditions. 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.

09929 04 02 19

Europe and Head Office

Lehmann&Voss&Co. KG
Alsterufer 19
20354 Hamburg
Germany
Tel +49 40 44 197-0
Email: luvocom@ehvoss.de

North America

LEHVOSS North America, LLC
185 South Broad Street
Pawcatuck, CT 06379
USA
Tel +1-855-681-3226
Email: info@ehvoss.us

Asia

LEHVOSS (Shanghai) Chemical Trading Co., Ltd.
Unit 4805, 8 Xingyi Road
Changning District, Shanghai 200336
China
Tel +86 21 62785181
Email: info@ehvoss.cn

