

VECTRA® B230 | LCP | Specialty

Description

Exceptional strength and stiffness. Suitable for metal replacement applications. Electrically conductive. 30% carbon fiber reinforced.

Chemical abbreviation according to ISO 1043-1 : LCP
Inherently flame retardant

UL-Listing V-0 at 0.46mm thickness per UL 94 flame testing.
Relative-Temperature-Index (RTI) according to UL 746B: electrical 130°C, mechanical 130°C.

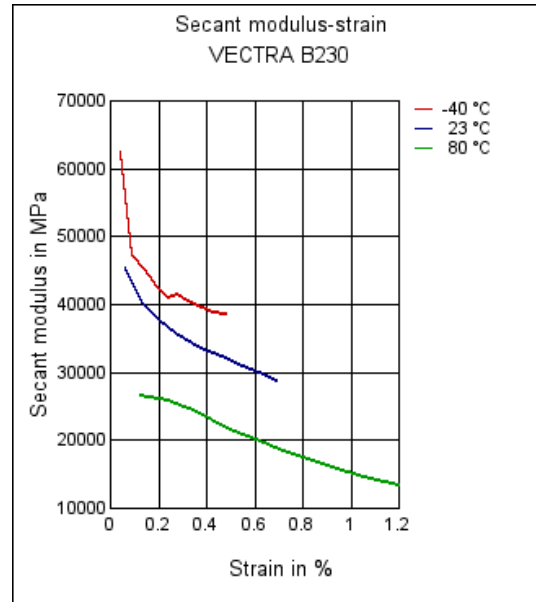
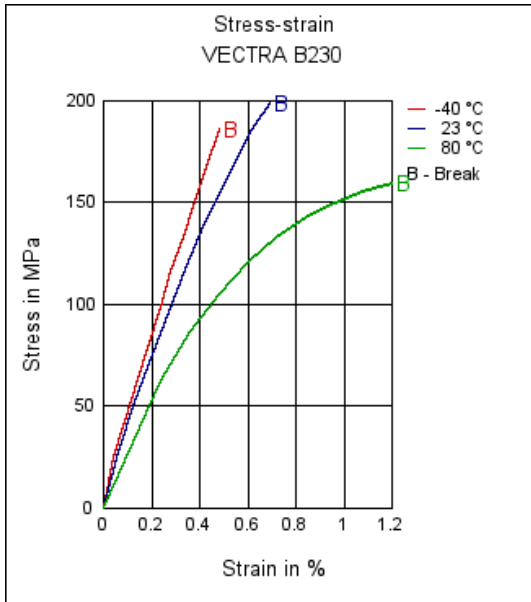
UL = Underwriters Laboratories (USA)

Physical properties	Value	Unit	Test Standard
Density	1500	kg/m ³	ISO 1183
Mold shrinkage - parallel	0.0	%	ISO 294-4
Mold shrinkage - normal	0.1	%	ISO 294-4
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	31800	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	200	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	0.7	%	ISO 527-2/1A
Flexural modulus (23°C)	25500	MPa	ISO 178
Flexural strength (23°C)	300	MPa	ISO 178
Compressive stress @ 1% strain	204	MPa	ISO 604
Charpy impact strength @ 23°C	15	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	6	kJ/m ²	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	12	kJ/m ²	ISO 180/1U
Notched impact strength (Izod) @ 23°C	6.0	kJ/m ²	ISO 180/1A
Compressive modulus	33000	MPa	ISO 604
Rockwell hardness	99	M-Scale	ISO 2039-2
Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	280	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	235	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	250	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	186	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	167	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	0.01	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	0.09	E-4/°C	ISO 11359-2
Flammability at thickness h	V-0	class	UL94
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 1 MHz	32	-	IEC 60250
Volume resistivity	1000	Ohm*m	IEC 60093
Surface resistivity	100	Ohm	IEC 60093
Test specimen production	Value	Unit	Test Standard
Injection molding melt temperature	304	°C	ISO 294

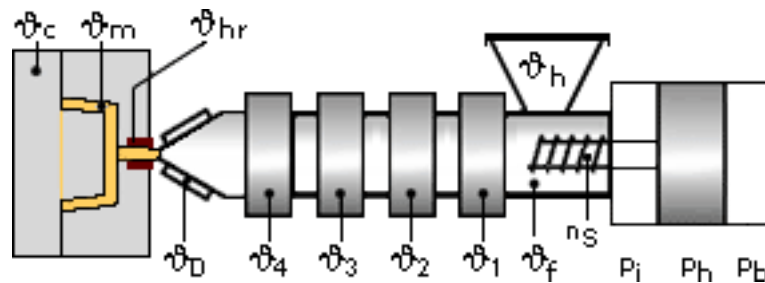
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Test specimen production	Value	Unit	Test Standard
Injection molding mold temperature	100	°C	ISO 294
Injection molding flow front velocity	150	mm/s	ISO 294
Injection molding hold pressure	69	MPa	ISO 294

Stress-strain	Secant modulus-strain
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Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.01%

VECTRA should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be $\leq -40^\circ\text{C}$. The time between drying and processing should be as short as possible.

For subsequent storage of the material in the dryer until processed the temperature does not need to be lowered for grades A, B, C, D and V ($\leq 24\text{ h}$).

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Drying time: 6 - 8 h

Drying temperature: 150 - 150 °C

Temperature:

	° Manifold	° Mold	° Melt	° Nozzle	° Zone4	° Zone3	° Zone2	° Zone1	° Feed	° Hopper
min (°C)	285	80	285	290	285	280	275	270	60	20
max (°C)	295	120	300	300	295	290	285	280	80	30

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	500	500	0
max (bar)	1500	1500	30

Speed:

Injection speed: very fast

Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	200	140	80	-	-

Special Info:

When using short metering strokes an accumulator is recommended to get short injection times

Injection Molding

A three-zone screw evenly divided into feed, compression, and metering zones is preferred. A higher percentage of feed flights may be needed for smaller machines: 1/2 feed, 1/4 compression, 1/4 metering.

Vectra LCPs are shear thinning, their melt viscosity decreases quickly as shear rate increases. For parts that are difficult to fill, the molder can increase the injection velocity to improve melt flow.

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Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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