

VECTRA® E135i | LCP | Glass Reinforced

Description

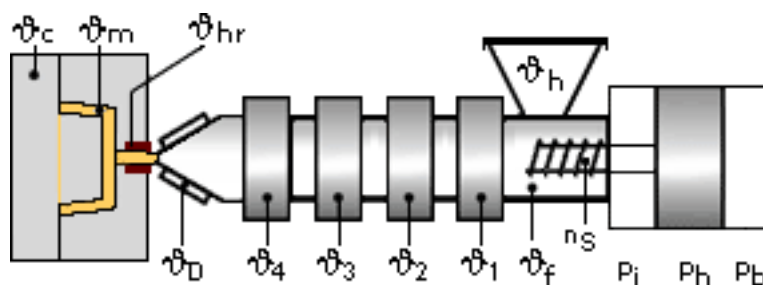
35% glass fiber filled /Higher weldline strength.

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

UL-Listing V-0 in all colors at .15mm thickness per UL 94 flame testing.

UL = Underwriters Laboratories (USA)

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.

Drying time: 4 h

Drying temperature: 302 - 302 °F

Temperature:

	ϑ_{Mold}	ϑ_{Melt}	$\vartheta_{\text{Nozzle}}$	ϑ_{Zone4}	ϑ_{Zone3}	ϑ_{Zone2}	ϑ_{Zone1}
min (°F)	176	635	635	626	617	608	599
max (°F)	248	671	662	680	671	653	635

Pressure:

	Inj press	Hold press
min (psi)	7250	7250
max (psi)	21800	21800

Speed:

Injection speed: very fast

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Screw speed

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

Contact Information

Americas

8040 Dixie Highway, Florence, KY 41042 USA

Product Information Service

t: +1-800-833-4882 t: +1-859-372-3244

Customer Service

t: +1-800-526-4960 t: +1-859-372-3214

e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road, Zhang Jiang Hi Tech Park

Shanghai 201203 PRC

Customer Service

t: +86 21 3861 9266 f: +86 21 3861 9599

e: info-engineeredmaterials-asia@celanese.com

Europa

Am Unisys-Park 1, 65843 Sulzbach, Germany

Product Information Service

t: +(00)-800-86427-531 t: +49-(0)-69-45009-1011

e: info-engineeredmaterials-eu@celanese.com

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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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