

VECTRA® E440i | LCP | Mineral / Glass Reinforced

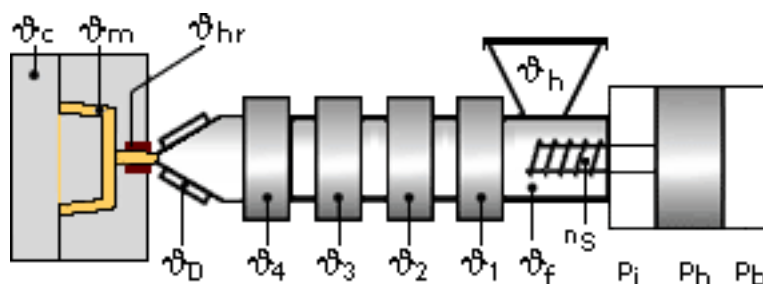
Description

Mineral and glass filled grade with low warp, easy flow and smooth surface appearance.

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

FDA compliant

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 ($\leq 24\text{ h}$).

Drying time: 6 h

Drying temperature: 302 - 338 °F

Temperature:

	ϑManifold	ϑMold	ϑMelt	ϑNozzle	ϑZone4	ϑZone3	ϑZone2	ϑZone1	ϑFeed	ϑHopper
min (°F)	635	176	644	635	626	626	608	599	140	68
max (°F)	653	248	662	653	644	644	626	617	176	86

Pressure:

	Inj press	Hold press	Back pressure
min (psi)	7250	7250	0
max (psi)	21800	21800	435

Speed:

Injection speed: very fast

Screw speed

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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

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