

VECTRA® E463i | LCP | Mineral / Glass Reinforced

Description

40% glass/mineral filled excellent flow, low warpage, high heat resistance.

Chemical abbreviation according to ISO 1043-1 : LCP

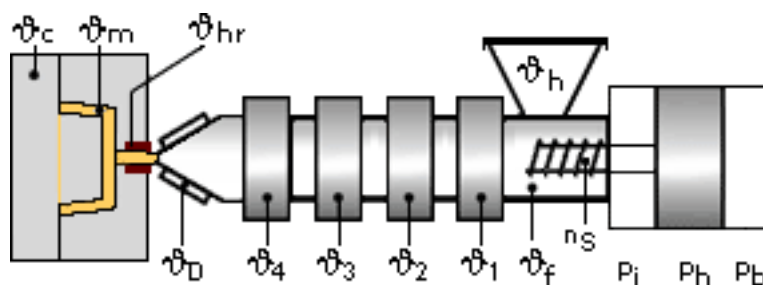
Inherently flame retardant

UL-Listing V-0 all colors at 1.5mm thickness per UL 94 flame testing.

Relative-Temperature-Index (RTI) according to UL 746B: electricals 130°C, mechanicals 130°C.

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.

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:

	ϑ_{Mold}	ϑ_{Melt}	$\vartheta_{\text{Nozzle}}$	ϑ_{Zone4}	ϑ_{Zone3}	ϑ_{Zone2}	ϑ_{Zone1}
min (°F)	176	635	635	635	626	617	599
max (°F)	266	653	653	671	662	635	617

Pressure:

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

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Speed:**Injection speed: medium-fast****Screw speed**

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	200	140	100	-	-

Special Info:

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

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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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