

VECTRA® E473i | LCP | Mineral / Glass Reinforced

Description

Vectra E473i is a low warp LCP with easy flow and high temperature capability.

Chemical abbreviation according to ISO 1043-1 : LCP

Inherently flame retardant

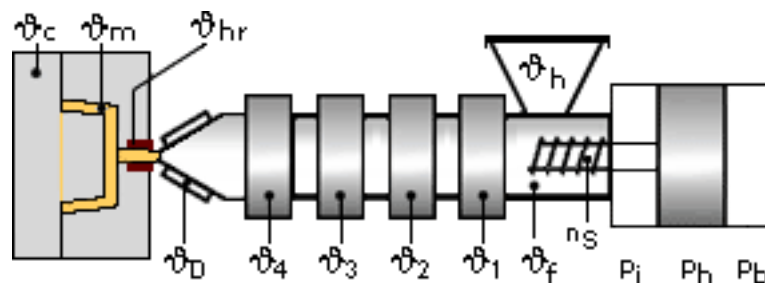
FDA compliant

UL-Listing V-0 in natural and black at 0.75mm 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%

Drying time: 6 h

Drying temperature: 302 - 302 °F

Temperature:

	θ Mold	θ Melt	θ Nozzle	θ Zone4	θ Zone3	θ Zone2	θ Zone1	θ Feed	θ Hopper
min (°F)	176	635	635	626	617	608	599	140	140
max (°F)	248	653	653	644	635	626	617	176	176

Pressure:

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

Speed:

Injection speed: high

Screw speed

Screw diameter (mm)	16	25	40	55	75
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Screw speed (RPM)	-	100	120	150	200
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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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