

VECTRA® E840i LDS | LCP | Mineral Reinforced

Description

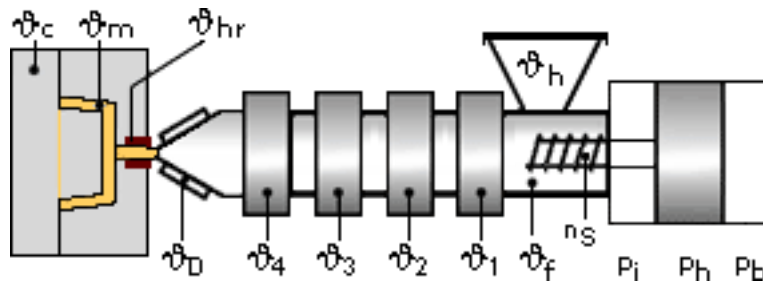
40% Mineral filled Laser Direct Structuring grade.

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

UL-Listing V-0 in black at 1.5mm 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: 6 h

Drying temperature: 302 - 302 °F

Temperature:

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

Pressure:

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

Speed:

Injection speed: medium

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Screw speed

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

Special Info:

For MID applications mold temperature between 120 - 140°C are recommended. For applications with extremely thin wall applications pre-humidity of max. 0,01% is recommended. When using short metering strokes an accumulator is recommended to get short injec

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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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