

VECTRA® FIT30 | LCP | Mineral / Glass Reinforced

Description

43% glass and mineral reinforced grade. Glass and mineral filled grade, high flow and low warpage.

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

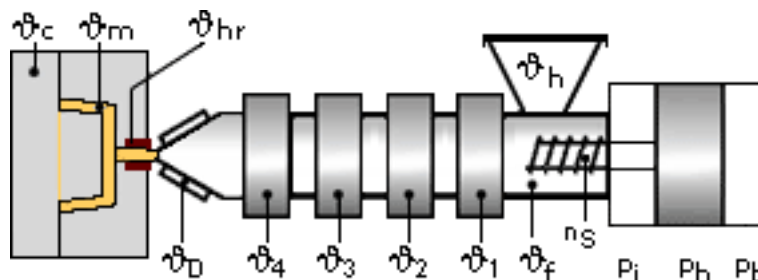
Physical properties	Value	Unit	Test Standard
Density	1770	kg/m ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	13000	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	130	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	1.7	%	ISO 527-2/1A
Flexural modulus (23°C)	12700	MPa	ISO 178
Flexural strength (23°C)	170	MPa	ISO 178
Flexural strain @ break	1.9	%	ISO 178
Charpy impact strength @ 23°C	25.5	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	5.8	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	328	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	262	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	286	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	0.09	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	0.38	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Volume resistivity	1E14	Ohm*m	IEC 60093
Surface resistivity	1E16	Ohm	IEC 60093

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.01%

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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 (≤ 24 h).

Drying time: 6 h

Drying temperature: 150 - 170 °C

Temperature:

	ϑ _{Mold}	ϑ _{Melt}	ϑ _{Nozzle}	ϑ _{Zone4}	ϑ _{Zone3}	ϑ _{Zone2}	ϑ _{Zone1}
min (°C)	80	335	330	330	330	325	315
max (°C)	130	345	340	350	350	335	325

Pressure:

	Inj press
min (bar)	500
max (bar)	1500

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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