

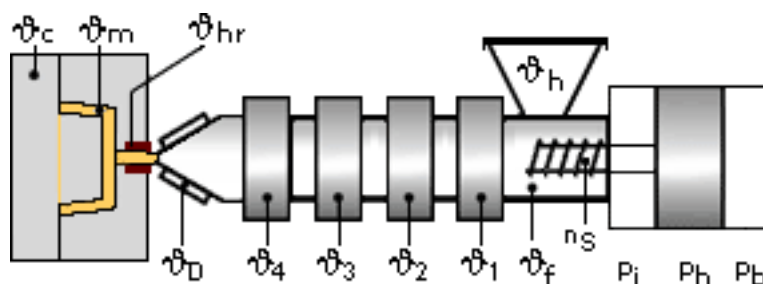
VECTRA® FIT70 | LCP | Mineral / Glass Reinforced

Description

35% glass and mineral reinforced grade. It offers excellent flowability, low warpage, excellent surface appearance, excellent dimensional stability, and good weldline strength.

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

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	626	626	626	617	599
max (°F)	284	653	644	662	662	635	617

Pressure:

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

Speed:

Injection speed: medium-fast

Screw speed

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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

Contact Information

Americas

8040 Dixie Highway, Florence, KY 41042 USA

Product Information Service

t: +1-800-833-4882 t: +1-859-372-3244

Customer Service

t: +1-800-526-4960 t: +1-859-372-3214

e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road, Zhang Jiang Hi Tech Park

Shanghai 201203 PRC

Customer Service

t: +86 21 3861 9266 f: +86 21 3861 9599

e: info-engineeredmaterials-asia@celanese.com

Europa

Am Unisys-Park 1, 65843 Sulzbach, Germany

Product Information Service

t: +(00)-800-86427-531 t: +49-(0)-69-45009-1011

e: info-engineeredmaterials-eu@celanese.co

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