

VECTRA® J540 | LCP | Mineral Reinforced

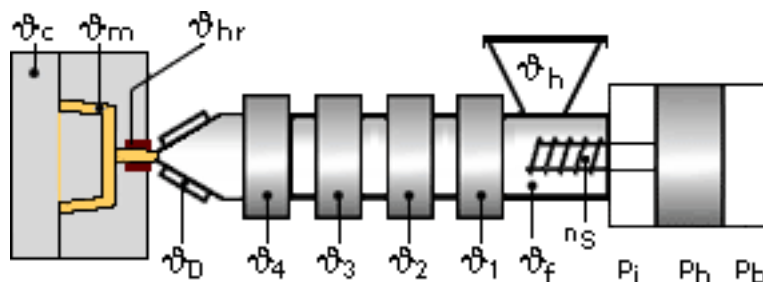
Description

40% Mineral filled, high heat resistance.

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

FDA compliant

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 - 338 °F

Temperature:

	ϑManifold	ϑMold	ϑMelt	ϑNozzle	ϑZone4	ϑZone3	ϑZone2	ϑZone1	ϑFeed	ϑHopper
min (°F)	689	176	653	662	662	653	644	635	176	68
max (°F)	707	284	680	680	680	671	662	653	248	140

Pressure:

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

Speed:

Injection speed: very fast

Screw speed

Screw diameter (mm)	16	25	40	55	75
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Screw speed (RPM)	80	120	200	-	-
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