

VECTRA® S475 | LCP | Mineral / Glass Reinforced

Description

Super High Flow, High heat Resistance and Low Warp for Thin Parts.

Chemical abbreviation according to ISO 1043-1 : LCP

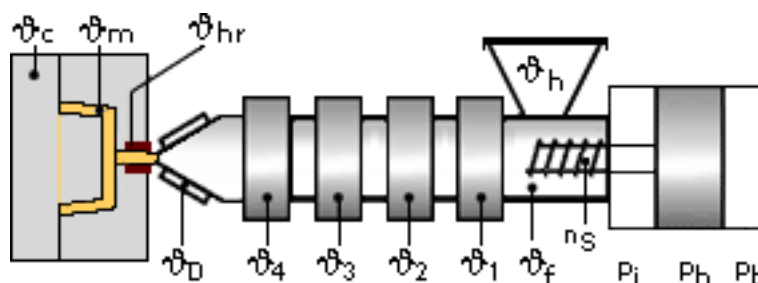
Inherently flame retardant

UL-Listing V-0 in natural and black at 0.15mm 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%

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

Drying time: 6 h

Drying temperature: 302 - 302 °F

Temperature:

	ϕManifold	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1	ϕFeed	ϕHopper
min (°F)	671	176	680	671	671	653	644	626	140	68
max (°F)	698	248	707	698	698	689	680	662	176	104

Pressure:

	Inj press	Hold press	Back pressure
min (psi)	7250	7250	0
max (psi)	21800	21800	435

Speed:

Injection speed: medium

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Screw speed

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

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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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