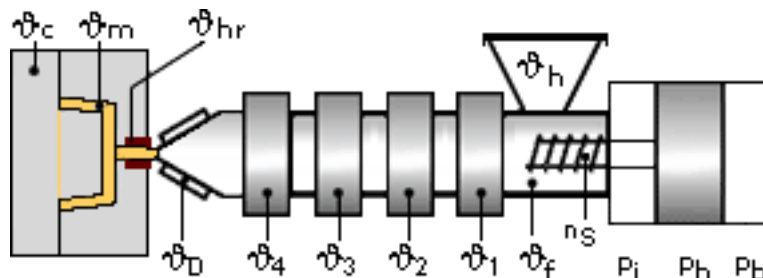


ZENITE® 5130L | LCP | Glass Reinforced

Description

Zenite 5130L is a 30% glass-reinforced LCP resin with improved toughness

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.01%

Drying time: 3 h

Drying temperature: 302 - 302 °F

Temperature:

	T_{Mold}	T_{Melt}	T_{Nozzle}	T_{Zone4}	T_{Zone3}	T_{Zone2}	T_{Zone1}	T_{Feed}	T_{Hopper}
min (°F)	176	617	635	635	635	635	608	104	68
max (°F)	248	653	653	653	653	653	626	140	86

Pressure:

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

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