

ZENITE® SEA20N | LCP | Mineral Reinforced

Description

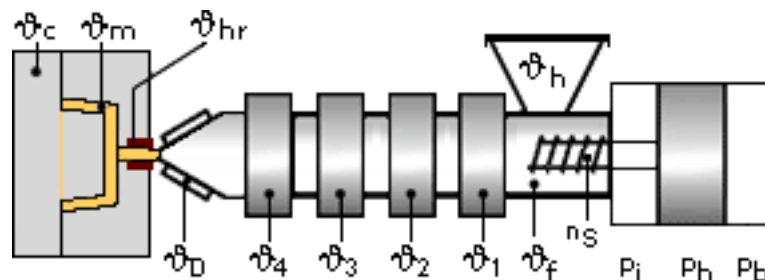
ZENITE® SEA20N is a 40% mineral filled grade. It offers excellent surface appearance, low warpage, and excellent dimensional stability. Application for this grade is compact camera module, and other thin, small electronic parts

Physical properties	Value	Unit	Test Standard
Density	1770	kg/m ³	ISO 1183
Mold shrinkage - parallel	0.25	%	ISO 294-4
Mold shrinkage - normal	0.76	%	ISO 294-4

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	10000	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	105	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	4.2	%	ISO 527-2/1A
Flexural modulus (23°C)	10000	MPa	ISO 178
Flexural strength (23°C)	126	MPa	ISO 178
Charpy notched impact strength @ 23°C	4.5	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	330	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	220	°C	ISO 75-1/-2

Typical injection moulding processing conditions



Pre Drying:

Drying time: 6 h

Drying temperature: 150 - - °C

Temperature:

	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1
min (°C)	80	335	330	330	330	320	310
max (°C)	140	345	340	350	350	330	320

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Pressure:

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

Speed:**Injection speed: medium-fast****Special Info:**

open or shut-off nozzle

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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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