

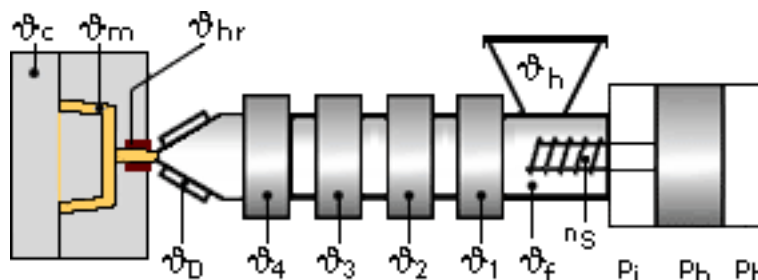
ZENITE® ZE88410NXL | LCP | Glass Reinforced

Description

40% glass reinforced, high weld-line strength, low warpage and with added lubricity.

Chemical abbreviation according to ISO 1043-1 : LCP

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.01%

LCP 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: 4 - 24 h

Drying temperature: 302 - 302 °F

Temperature:

	ϑManifold	ϑMold	ϑMelt	ϑNozzle	ϑZone4	ϑZone3	ϑZone2	ϑZone1	ϑFeed	ϑHopper
min (°F)	635	212	635	635	635	626	617	599	140	68
max (°F)	653	266	653	653	653	644	635	617	176	86

Pressure:

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

Speed:

Injection speed: very fast

Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	200	140	80	-	-

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Special Info:

When using short metering strokes an accumulator is recommended to get short injection times

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