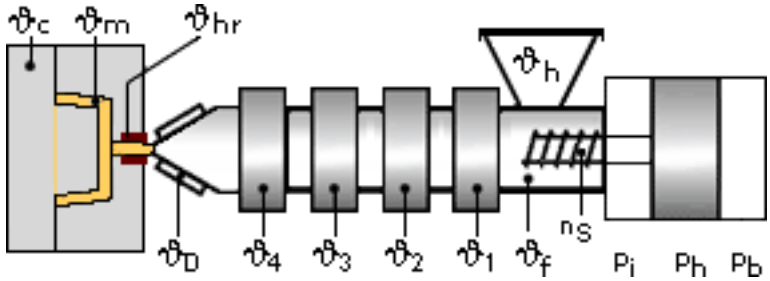
VECTRA® A530 | LCP | Mineral Reinforced

Description

Best overall surface appearance with properties similar to A130. Less abrasive than glass fiber reinforced grades. Improved toughness over A130. Outstanding hydrolytic stability. Recommended where aesthetics are key. 30% mineral filled.

Chemical abbreviation according to ISO 1043-1 : LCP
Inherently flame retardant
FDA compliant
UL-Listing V-0 in natural and black at 0.38mm thickness per UL 94 flame testing, and UL-5VA in natural at 3.0mm.
Relative-Temperature-Index (RTI) according to UL 746B: electrical 130°C, mechanical 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 =< - 40° 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 (<= 24 h).

Drying time: 4 - 6 h

Drying temperature: 302 - 302 °F

Temperature:

	ϑManifold	ϑMold	ϑMelt	ϑNozzle	ϑZone4	ϑZone3	ϑZone2	ϑZone1	ϑFeed	ϑHopper
min (°F)	545	176	545	554	545	536	527	518	140	68
max (°F)	563	248	563	572	563	554	545	536	176	86

Pressure:

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

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Speed:

Injection speed: very fast

Screw speed

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

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

Injection Molding

A three-zone screw evenly divided into feed, compression, and metering zones is preferred. A higher percentage of feed flights may be needed for smaller machines: 1/2 feed, 1/4 compression, 1/4 metering.

Vectra LCPs are shear thinning, their melt viscosity decreases quickly as shear rate increases. For parts that are difficult to fill, the molder can increase the injection velocity to improve melt flow.

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General Disclaimer

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