

VECTRA® E471i | LCP | Specialty

Description

Low warp with excellent properties

Chemical abbreviation according to ISO 1043-1 : LCP

Inherently flame retardant

UL-Listing V-0 in natural and black at 0.75mm thickness per UL 94 flame testing.

Relative-Temperature-Index (RTI) according to UL 746B: electricals 130°C, mechanicals 130°C.

UL = Underwriters Laboratories (Japan)

Physical properties	Value	Unit	Test Standard
Density	1670	kg/m ³	ISO 1183
Mold shrinkage - parallel	0.1	%	ISO 294-4
Mold shrinkage - normal	0.5	%	ISO 294-4
Water absorption (23°C-sat)	0.015	%	ISO 62
Humidity absorption (23°C/50%RH)	0.002	%	ISO 62

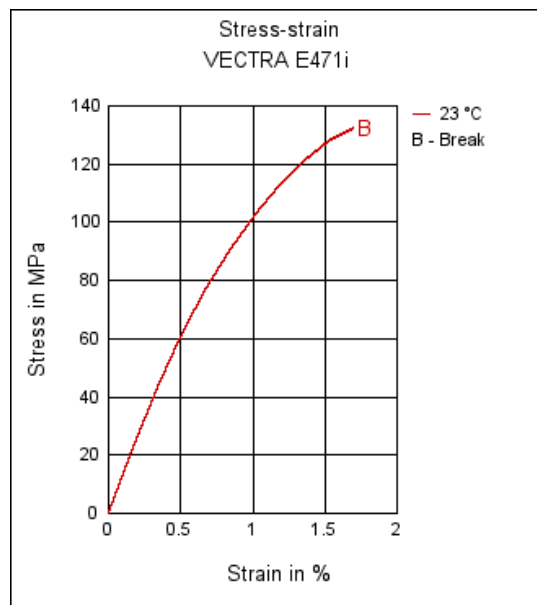
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	13800	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	130	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	2.5	%	ISO 527-2/1A
Flexural modulus (23°C)	13500	MPa	ISO 178
Flexural strength (23°C)	180	MPa	ISO 178
Flexural strain @ break	2.5	%	ISO 178
Compressive stress @ 1% strain	82	MPa	ISO 604
Charpy impact strength @ 23°C	55	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	30.0	kJ/m ²	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	60	kJ/m ²	ISO 180/1U
Notched impact strength (Izod) @ 23°C	14.0	kJ/m ²	ISO 180/1A
Compressive modulus	11000	MPa	ISO 604
Rockwell hardness	55	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	335	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	265	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	220	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	200	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	0.06	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	0.18	E-4/°C	ISO 11359-2
Flammability at thickness h	V-0	class	UL94

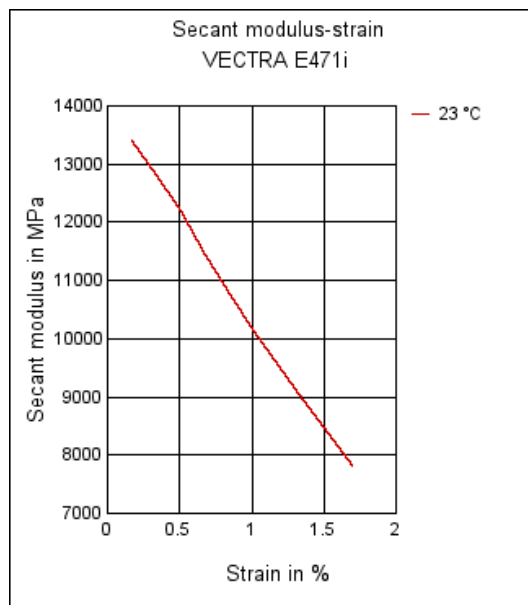
Electrical properties	Value	Unit	Test Standard
Relative permittivity - 1 MHz	3.8	-	IEC 60250
Dissipation factor - 1 MHz	310	E-4	IEC 60250
Volume resistivity	1E14	Ohm*m	IEC 60093
Surface resistivity	>1E15	Ohm	IEC 60093
Electric strength	53	kV/mm	IEC 60243-1

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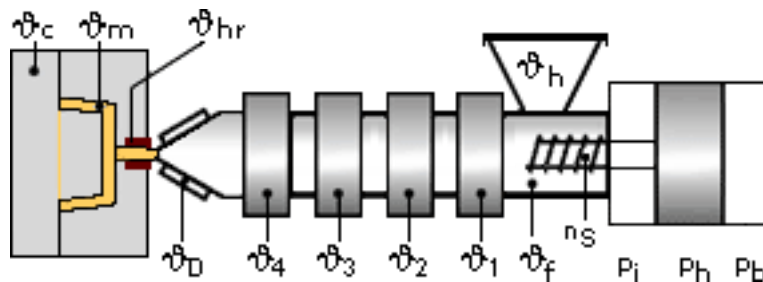
Stress-strain



Secant modulus-strain



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 not need to be lowered for grades A, B, C, D and V ($\leq 24\text{ h}$).

Drying time: 4 - 6 h

Drying temperature: 150 - 170 °C

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Temperature:

	° Manifold	° Mold	° Melt	° Nozzle	° Zone4	° Zone3	° Zone2	° Zone1	° Feed	° Hopper
min (°C)	335	80	335	335	330	325	320	315	60	20
max (°C)	345	120	345	345	340	335	330	325	80	30

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	500	500	0
max (bar)	1500	1500	30

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.

Contact Information

Americas

8040 Dixie Highway, Florence, KY 41042 USA

Product Information Service

t: +1-800-833-4882 t: +1-859-372-3244

Customer Service

t: +1-800-526-4960 t: +1-859-372-3214

e: info-engineeredmaterials-am@celanese.com

Asia

4560 Jinke Road, Zhang Jiang Hi Tech Park

Shanghai 201203 PRC

Customer Service

t: +86 21 3861 9266 f: +86 21 3861 9599

e: info-engineeredmaterials-asia@celanese.com

Europa

Am Unisys-Park 1, 65843 Sulzbach, Germany

Product Information Service

t: +(00)-800-86427-531 t: +49-(0)-69-45009-1011

e: info-engineeredmaterials-eu@celanese.co

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