

VECTRA® S540 | LCP | Mineral Reinforced

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.

Drying time: 6 h

Drying temperature: 150 - 150 °C

Temperature:

	$\vartheta_{\text{Manifold}}$	ϑ_{Mold}	ϑ_{Melt}	$\vartheta_{\text{Nozzle}}$	ϑ_{Zone4}	ϑ_{Zone3}	ϑ_{Zone2}	ϑ_{Zone1}	ϑ_{Feed}	$\vartheta_{\text{Hopper}}$
min (°C)	365	80	365	365	365	365	355	345	60	20
max (°C)	375	140	375	375	375	375	365	355	80	40

Pressure:

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

Speed:

Injection speed: very fast

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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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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