

VECTRA® S625 | LCP | Specialty

Description

Low friction and wear resistance.

Chemical abbreviation according to ISO 1043-1 : LCP
Inherently flame retardant.

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.

Drying time: 6 h

Drying temperature: 302 - 302 °F

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 (°F)	689	176	689	689	689	689	671	653	140	68
max (°F)	707	284	707	707	707	707	689	671	176	104

Pressure:

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

Speed:

Injection speed: very fast

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