

ZENITE® 6330L | LCP | Mineral Reinforced

Description

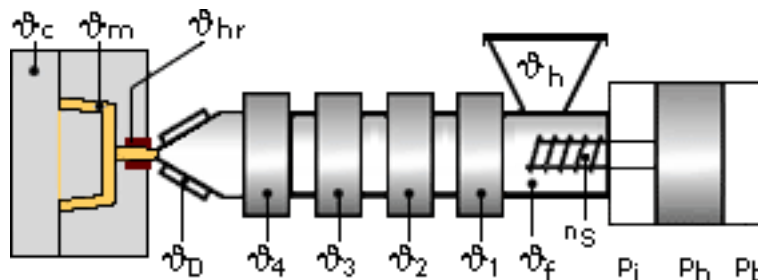
Zenite 6330L is a lubricated 30% mineral-reinforced LCP resin having excellent toughness. It is well suited for use in the automotive, electrical/electronic, telecommunications, and aerospace industries.

Physical properties	Value	Unit	Test Standard
Density	1630	kg/m ³	ISO 1183
Mold shrinkage - parallel	0	%	ISO 294-4
Mold shrinkage - normal	0.5	%	ISO 294-4

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	10500	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	125	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	4	%	ISO 527-2/1A
Flexural modulus (23°C)	9600	MPa	ISO 178
Flexural strength (23°C)	125	MPa	ISO 178

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	335	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	239	°C	ISO 75-1/-2

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.01%

Drying time: 3 h

Drying temperature: 150 - 150 °C

Temperature:

	ϕMold	ϕMelt	ϕNozzle	ϕZone4	ϕZone3	ϕZone2	ϕZone1	ϕFeed	ϕHopper
min (°C)	80	350	350	350	350	350	335	40	20
max (°C)	120	360	360	360	360	360	345	60	30

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Pressure:

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

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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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