Ticona
Performance Driven Solutions™

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/m³	ISO 1183
Mold shrinkage - parallel	**0.1**	%	ISO 294-4
Mold shrinkage - normal	**0.5**	%	ISO 294-4

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/m²	ISO 179/1eU
Charpy notched impact strength @ 23°C	**30.0**	kJ/m²	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	**60**	kJ/m²	ISO 180/1U
Notched impact strength (Izod) @ 23°C	**14.0**	kJ/m²	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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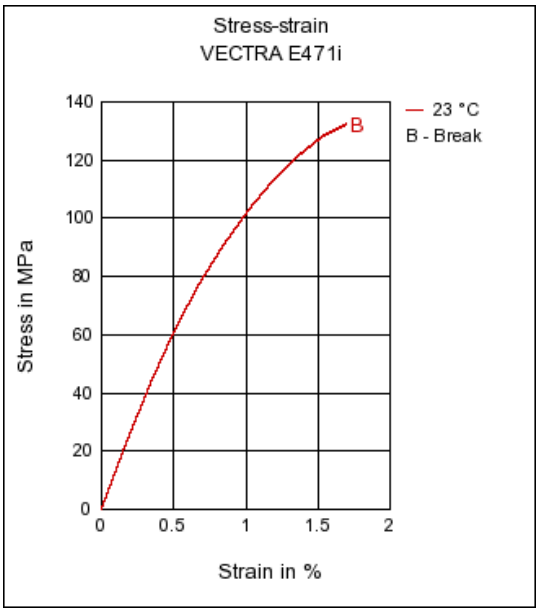
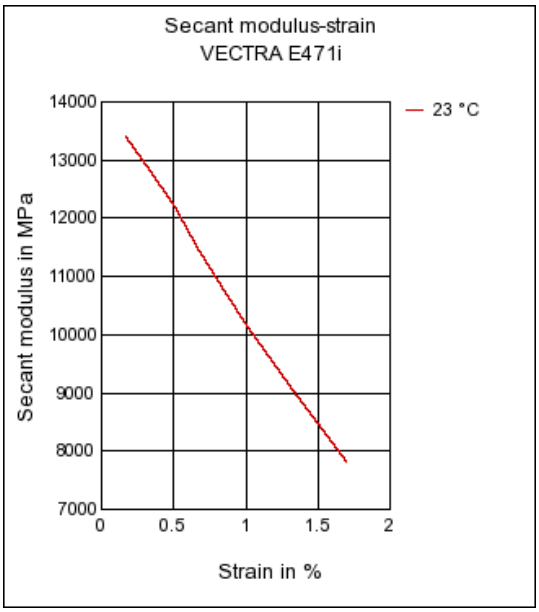
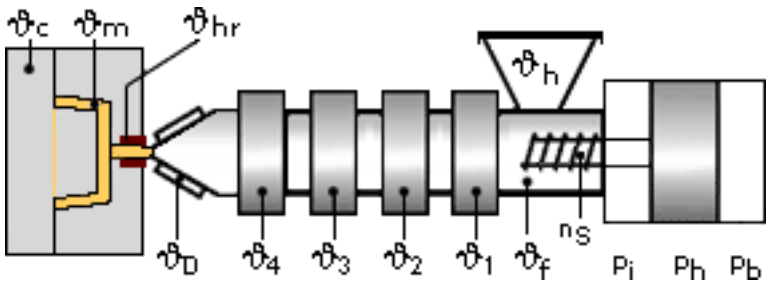
Stress-strain



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 =< - 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: 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

Ticona North American Headquarters
Product Information Service
8040 Dixie Highway
Florence, KY 41042
USA
Tel.: +1-800-833-4882
Tel.: +1-859-372-3244
email: prodinfo@ticona.com
Ticona on the web: www.ticona.com

Customer Service
Tel.: +1-800-526-4960
Tel.: +1-859-372-3214
Fax: +1-859-372-3125

Europe

Ticona GmbH
Information Service
Tel.: +49 (0) 180-5842662 (Germany)
+49 (0) 69-30516299 (Europe)
Fax: +49 (0) 180-2021202 (Germany & Europe)
email: infoservice@ticona.de
Internet: www.ticona.com

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General Disclaimer

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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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