

VECTRA® E830iPd - LCP

Description

30% glass filled Platable grade. Chemical abbreviation according to ISO 1043-1 : LCP Inherently flame retardant.

Physical properties	Value	Unit	Test Standard
Density	1600	kg/m ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	15000	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	140	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1,8	%	ISO 527-2/1A
Flexural modulus, 23°C	14500	MPa	ISO 178
Flexural strength, 23°C	180	MPa	ISO 178
Charpy notched impact strength, 23°C	21	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	335	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	245	°C	ISO 75-1, -2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0,01	%	-
Drying time	6	h	-
Drying temperature	150	°C	-

Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 30	°C	-
Feeding zone temperature	60 - 80	°C	-
Zone1 temperature	315 - 325	°C	-
Zone2 temperature	320 - 330	°C	-
Zone3 temperature	325 - 335	°C	-
Zone4 temperature	335 - 345	°C	-
Nozzle temperature	340 - 350	°C	-
Melt temperature	340 - 350	°C	-
Mold temperature	80 - 120	°C	-
Hot runner temperature	340 - 350	°C	-

Pressure	Value	Unit	Test Standard
Injection pressure	500 - 1500	bar	-
Hold pressure	500 - 1500	bar	-

Speed	Value	Unit	Test Standard
Injection speed	medium	-	-

Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 16mm	200	RPM	-
Screw speed diameter, 25mm	140	RPM	-
Screw speed diameter, 40mm	80	RPM	-

Other text information

Pre-drying

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.

Characteristics

Product Categories

Specialty

Contact Information

VECTRA® E830iPd - LCP

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

Europe

Am Unisys-Park 1
65843 Sulzbach, Germany
Product Information Service
t: +49-800-86427-531
t: +49-(0)-69-45009-1011
e: info-engineeredmaterials-eu@celanese.com

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