

VECTRA® E135i | LCP | Glass Reinforced

Description

35% glass fiber filled /Higher weldline strength.

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

UL-Listing V-0 in all colors at .15mm thickness per UL 94 flame testing.

UL = Underwriters Laboratories (USA)

Physical properties	Value	Unit	Test Standard
Density	1670	kg/m ³	ISO 1183
Mold shrinkage - parallel	0.0	%	ISO 294-4
Mold shrinkage - normal	0.29	%	ISO 294-4
Water absorption (23°C-sat)	0.07	%	ISO 62

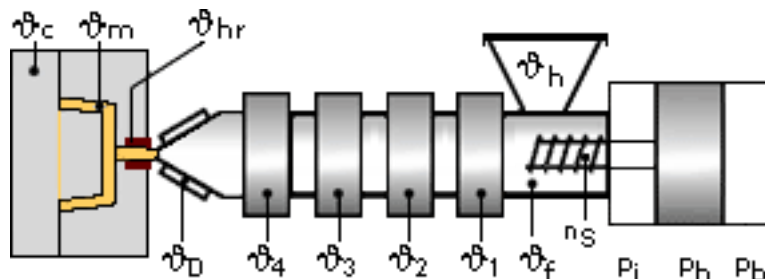
Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	16000	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	150	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	1.5	%	ISO 527-2/1A
Flexural modulus (23°C)	17000	MPa	ISO 178
Flexural strength (23°C)	225	MPa	ISO 178
Flexural strain @ break	2.1	%	ISO 178
Compressive stress @ 1% strain	100	MPa	ISO 604
Charpy impact strength @ 23°C	40.0	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	27.0	kJ/m ²	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	40	kJ/m ²	ISO 180/1U
Notched impact strength (Izod) @ 23°C	30.0	kJ/m ²	ISO 180/1A
Compressive modulus	13500	MPa	ISO 604
Rockwell hardness	62	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	275	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	200	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	0.05	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	0.59	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 1 MHz	4.1	-	IEC 60250
Dissipation factor - 1 MHz	30	E-4	IEC 60250
Volume resistivity	1E14	Ohm*m	IEC 60093
Surface resistivity	1E15	Ohm	IEC 60093
Electric strength	28	kV/mm	IEC 60243-1
Comparative tracking index CTI	175	-	IEC 60112

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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: 4 h

Drying temperature: 150 - 150 °C

Temperature:

	$\varnothing_{\text{Mold}}$	$\varnothing_{\text{Melt}}$	$\varnothing_{\text{Nozzle}}$	$\varnothing_{\text{Zone4}}$	$\varnothing_{\text{Zone3}}$	$\varnothing_{\text{Zone2}}$	$\varnothing_{\text{Zone1}}$
min (°C)	80	335	335	330	325	320	315
max (°C)	120	355	350	360	355	345	335

Pressure:

	Inj press	Hold press
min (bar)	500	500
max (bar)	1500	1500

Speed:

Injection speed: very fast

Screw speed

	16	25	40	55	75
Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	200	140	80	-	-

Contact Information

Americas

Ticona North American Headquarters
Product Information Service
8040 Dixie Highway
Florence, KY 41042
USA
Tel.: +1-800-833-4882

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

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Tel.: +1-859-372-3244
email: prodinfo@ticona.com
Ticona on the web: www.ticona.com

Internet: www.ticona.com

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

General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

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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