

## VECTRA® MT1345 | LCP | Medical Technology

### Description

Best overall surface appearance with properties similar to MT1310. Less abrasive than glass fiber reinforced grades. Improved toughness over MT1310. Outstanding hydrolytic stability. Recommended where aesthetics are key. 30% mineral filled.

Chemical abbreviation according to ISO 1043-1 : LCP

Inherently flame retardant

Ticona has established at the FDA a drug master file (DMF no.8468) and a Device Master File (MAF no.315) for Vectra MT1345. These are to assist our customers with their end use FDA petitions. Vectra MT1345 has been tested and complies with USP Class VI.

Physical properties	Value	Unit	Test Standard
Density	<b>1650</b>	kg/m <sup>3</sup>	ISO 1183
Mold shrinkage - parallel	<b>0.2</b>	%	ISO 294-4
Mold shrinkage - normal	<b>0.7</b>	%	ISO 294-4

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	<b>11000</b>	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	<b>160</b>	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	<b>4.6</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>11900</b>	MPa	ISO 178
Flexural strength (23°C)	<b>180</b>	MPa	ISO 178
Compressive stress @ 1% strain	<b>60</b>	MPa	ISO 604
Charpy impact strength @ 23°C	<b>50</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength @ 23°C	<b>25</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	<b>40</b>	kJ/m <sup>2</sup>	ISO 180/1U
Notched impact strength (Izod) @ 23°C	<b>27</b>	kJ/m <sup>2</sup>	ISO 180/1A
Compressive modulus	<b>9500</b>	MPa	ISO 604
Rockwell hardness	<b>67</b>	M-Scale	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	<b>280</b>	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	<b>190</b>	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	<b>203</b>	°C	ISO 75-1/-2
DTUL @ 8.0 MPa	<b>121</b>	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	<b>151</b>	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	<b>0.1</b>	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	<b>0.3</b>	E-4/°C	ISO 11359-2
Flammability at thickness h	<b>V-0</b>	class	UL94

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	<b>3.8</b>	-	IEC 60250
Relative permittivity - 1 MHz	<b>3.2</b>	-	IEC 60250
Dissipation factor - 100 Hz	<b>100</b>	E-4	IEC 60250
Dissipation factor - 1 MHz	<b>160</b>	E-4	IEC 60250
Volume resistivity	<b>1E12</b>	Ohm*m	IEC 60093
Surface resistivity	<b>&gt;1E15</b>	Ohm	IEC 60093
Electric strength	<b>44</b>	kV/mm	IEC 60243-1
Comparative tracking index CTI	<b>200</b>	-	IEC 60112

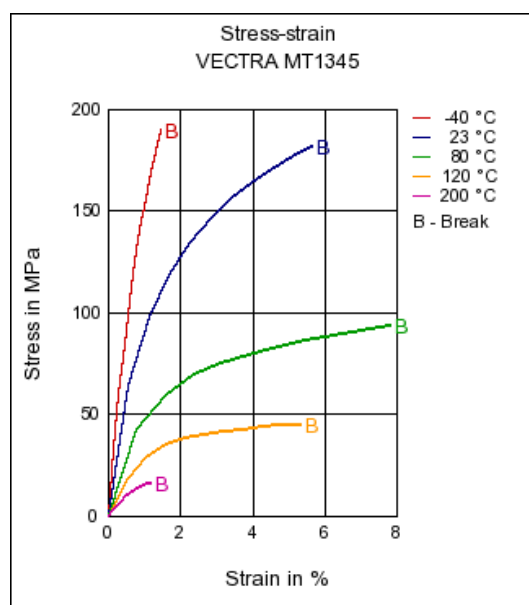
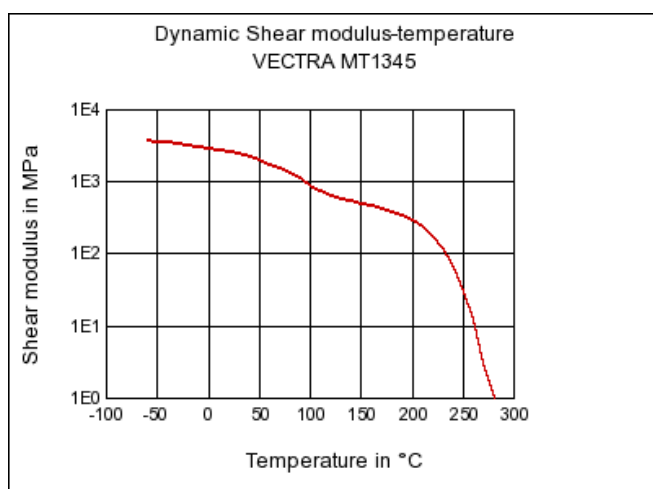
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Electrical properties	Value	Unit	Test Standard
Arc resistance	<b>180</b>	s	Internal

Test specimen production	Value	Unit	Test Standard
Injection molding melt temperature	<b>293</b>	°C	ISO 294
Injection molding mold temperature	<b>60</b>	°C	ISO 294
Injection molding flow front velocity	<b>150</b>	mm/s	ISO 294
Injection molding hold pressure	<b>48</b>	MPa	ISO 294

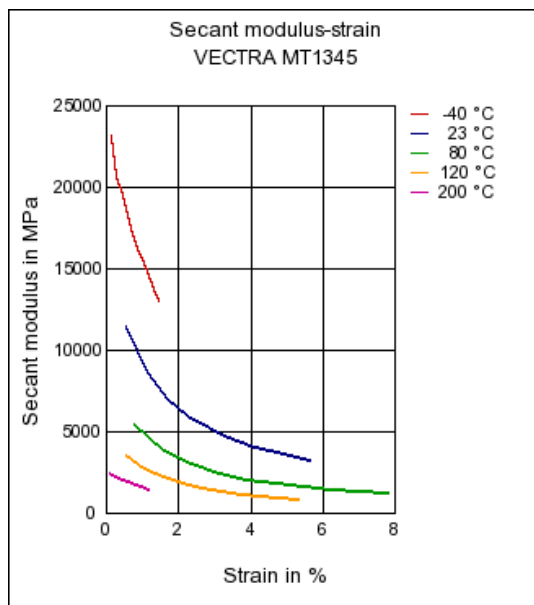
**Dynamic Shear modulus-temperature**

**Stress-strain**

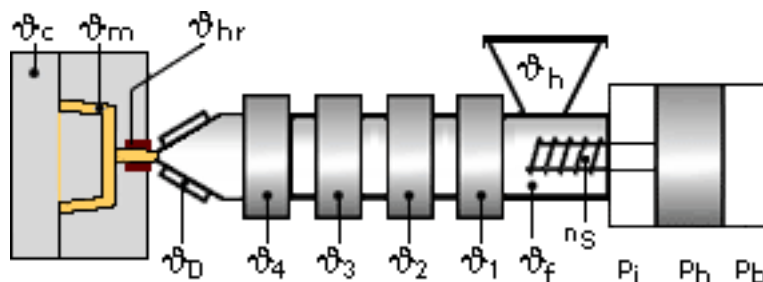


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### Secant modulus-strain



### 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  $\leq -40^\circ\text{C}$ . 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 ( $\leq 24$  h).

**Drying time: 4 - 6 h**

**Drying temperature: 150 - 150 °C**

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### Temperature:

	ϕ <sub>Manifold</sub>	ϕ <sub>Mold</sub>	ϕ <sub>Melt</sub>	ϕ <sub>Nozzle</sub>	ϕ <sub>Zone4</sub>	ϕ <sub>Zone3</sub>	ϕ <sub>Zone2</sub>	ϕ <sub>Zone1</sub>	ϕ <sub>Feed</sub>	ϕ <sub>Hopper</sub>
min (°C)	285	80	285	290	285	280	275	270	60	20
max (°C)	295	120	295	300	295	290	285	280	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](mailto:prodinfo@ticona.com)  
Ticona on the web: [www.ticona.com](http://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](mailto:infoservice@ticona.de)  
Internet: [www.ticona.com](http://www.ticona.com)

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### 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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We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

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