

Vectra® E631i

Liquid Crystal Polymer
Celanese Corporation

Message:

30% glass reinforced
Inherently flame retardant.
UL-Listing V-0 black at 0.15mm thickness per UL 94 flame testing.
UL = Underwriters Laboratories (USA)

General Information			
UL YellowCard	E83005-100732103		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Flame retardancy		
Resin ID (ISO 1043)	LCP		
Physical	Nominal Value	Unit	Test Method
Density	1.61	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	18000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	145	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.3	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	17000	MPa	ISO 178
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	°C	ISO 75-2/A
Melting Temperature ¹	335	°C	ISO 11357-3
Electrical	Nominal Value		Test Method
Relative Permittivity			
1 MHz	4.50		IEC 60250
2.05 GHz	7.41		IPC TM-650 2.5.5.13
Dissipation Factor (2.05 GHz)	0.012		IPC TM-650 2.5.5.13
Flammability	Nominal Value		Test Method
Flame Rating (0.150 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	6.0	hr	
Suggested Max Moisture	0.010	%	
Hopper Temperature	20 - 30	°C	
Rear Temperature	315 - 325	°C	
Middle Temperature	320 - 330	°C	
Front Temperature	325 - 335	°C	
Nozzle Temperature	335 - 345	°C	

Processing (Melt) Temp	335 - 345	°C
Mold Temperature	80 - 120	°C
Injection Pressure	50.0 - 150	MPa
Injection Rate	Fast	
Holding Pressure	50.0 - 150	MPa
Back Pressure	0.00 - 3.00	MPa

Injection instructions

Feed Temperature: 60 to 850°CZone 4 Temperature: 330 to 340°C

NOTE

1.
- 10°C/min

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