

VECTRA® J540

Liquid Crystal Polymer
Celanese Corporation

Message:

40% Mineral filled, high heat resistance.
Chemical abbreviation according to ISO 1043-1 : LCP
Inherently flame retardant
FDA compliant

General Information			
Filler / Reinforcement	Mineral filler, 40% filler by weight		
Features	Heat resistance, high		
	Flame retardancy		
Agency Ratings	FDA not rated		
RoHS Compliance	Contact manufacturer		
Resin ID (ISO 1043)	LCP		
Physical	Nominal Value	Unit	Test Method
Density	1.74	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.37	%	ISO 294-4
Flow direction	0.070	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	105	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.3	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10000	MPa	ISO 178
Flexural Stress (23°C)	120	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	5.0	kJ/m²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	240	°C	ISO 75-2/A
Melting Temperature ¹	350	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	150 - 170	°C	
Drying Time	6.0	hr	
Suggested Max Moisture	0.010	%	
Hopper Temperature	20.0 - 60.0	°C	
Rear Temperature	335 - 345	°C	
Middle Temperature	340 - 350	°C	

Front Temperature	345 - 355	°C
Nozzle Temperature	350 - 360	°C
Processing (Melt) Temp	345 - 360	°C
Mold Temperature	80.0 - 140	°C
Injection Pressure	50.0 - 150	MPa
Injection Rate	Fast	
Holding Pressure	50.0 - 150	MPa

Injection instructions

Manifold Temperature: 365 to 375°CZone 4 Temperature: 350 to 360°CFeed Temperature: 80 to 120°C

NOTE

1. 10°C/min

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