

Zenite® 6330L

Liquid Crystal Polymer
Celanese Corporation

Message:

Zenite 6330L is a lubricated 30% mineral-reinforced LCP resin having excellent toughness. It is well suited for use in the automotive, electrical/electronic, telecommunications, and aerospace industries.

General Information			
UL YellowCard	E344082-100831269		
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Additive	Lubricant		
Features	Good toughness		
	Lubrication		
Uses	Electrical/Electronic Applications		
	Aerospace applications		
	Application in Automobile Field		
	Communication Equipment		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.50	%	ISO 294-4
Flow direction	0.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	125	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	9600	MPa	ISO 178
Flexural Stress (23°C)	125	MPa	ISO 178
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	239	°C	ISO 75-2/A
Melting Temperature ¹	335	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	3.0	hr	
Suggested Max Moisture	0.010	%	
Hopper Temperature	20.0 - 30.0	°C	
Rear Temperature	335 - 345	°C	

Middle Temperature	350 - 360	°C
Front Temperature	350 - 360	°C
Nozzle Temperature	350 - 360	°C
Processing (Melt) Temp	350 - 360	°C
Mold Temperature	80.0 - 120	°C
Injection Pressure	50.0 - 150	MPa
Holding Pressure	50.0 - 150	MPa
Back Pressure	0.00 - 3.00	MPa

Injection instructions

Feed Temperature: 40 to 60°CZone 4 Temperature: 350 to 360°C

NOTE

1. 10°C/min

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