

VECTRA® E488i

Liquid Crystal Polymer
Celanese Corporation

Message:

Ultra low warp

General Information			
UL YellowCard	E83005-100219632		
Features	Low warpage		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.77	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.43	%	ISO 294-4
Flow direction	0.14	%	ISO 294-4
Water Absorption (Saturation, 23°C)	5.0E-3	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	54		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	110	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.5	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	13000	MPa	ISO 178
Flexural Stress (23°C)	160	MPa	ISO 178
Compressive Modulus	11000	MPa	ISO 604
Flexural Strain at Break	1.8	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	18	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	29	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	28	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	260	°C	ISO 75-2/A
Vicat Softening Temperature	200	°C	ISO 306/B50
Melting Temperature ¹	335	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	8.0E-6	cm/cm/°C	ISO 11359-2
Lateral	4.2E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+17	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Dielectric Strength	55	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	4.24		IEC 60250
Dissipation Factor (1 MHz)	0.045		IEC 60250
Comparative Tracking Index	175	V	IEC 60112
Flammability	Nominal Value	Unit	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	%	
Rear Temperature	315 - 325	°C	
Middle Temperature	325 - 335	°C	
Front Temperature	335 - 345	°C	
Nozzle Temperature	335 - 345	°C	
Processing (Melt) Temp	340 - 355	°C	
Mold Temperature	80.0 - 120	°C	
Injection Pressure	50.0 - 150	MPa	
Injection Rate	Fast		
Injection instructions			
Zone 4 Temperature: 340 to 360°C			
NOTE			
1.	10°C/min		

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