

DynaMix™ XP4025-CFL

Liquid Crystal Polymer

Polymer Dynamix

Message:

- 25% Carbon Fiber LCP
- Features:
 - Excellent Processing
 - Exceptional Dimensional Stability
 - Superior Weld Line Strength
- Applications:
 - Military
 - Aerospace
 - Industrial
 - Automotive

General Information			
Filler / Reinforcement	Carbon Fiber,25% Filler by Weight		
Features	Good Dimensional Stability		
	Good Processability		
Uses	Aerospace Applications		
	Automotive Applications		
	Industrial Applications		
	Military Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	124	MPa	ASTM D638
Tensile Elongation (Break)	4.0 to 7.0	%	ASTM D638
Flexural Modulus	11700	MPa	ASTM D790
Flexural Strength	207	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53 to 80	J/m	ASTM D256
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0 to 8.0	hr	
Suggested Max Moisture	< 0.080	%	
Rear Temperature	288 to 343	°C	
Middle Temperature	310 to 354	°C	
Front Temperature	316 to 360	°C	
Nozzle Temperature	321 to 360	°C	

Processing (Melt) Temp	321 to 360	°C
Mold Temperature	65.6 to 93.3	°C
Injection Rate	Fast	
Screw Speed	40 to 70	rpm
Clamp Tonnage	4.1 to 6.9	kN/cm ²

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