

VECTRA® E531i

Liquid Crystal Polymer
Celanese Corporation

Message:

Mineral filled grade with low warp, easy flow and smooth surface appearance.
Chemical abbreviation according to ISO 1043-1:LCP
Inherently flame retardant

General Information			
Filler / Reinforcement	Mineral filler		
Features	Low warpage		
	Good liquidity		
	Excellent appearance		
	Flame retardancy		
Resin ID (ISO 1043)	LCP		
Physical	Nominal Value	Unit	Test Method
Density	1.65	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	9000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	120	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10000	MPa	ISO 178
Flexural Stress (23°C)	130	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	225	°C	ISO 75-2/A
Melting Temperature ¹	335	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.010	%	
Hopper Temperature	20.0 - 30.0	°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	80.0 - 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

Manifold Temperature: 335 to 345°C Zone 4 Temperature: 330 to 340°C Feed Temperature: 60 to 80°C

NOTE

1. 10°C/min

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