

VECTRA® MT4350

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

Celanese has established at the FDA a drug master file (DMF no.8468) and a Device Master File (MAF no.315) for Vectra MT4350. These are to assist our customers with their end use FDA petitions. Vectra MT4350 has been tested and complies with USP Class VI.

General Information			
Filler / Reinforcement	Mineral filler, 40% filler by weight		
Features	Low warpage		
	Good liquidity		
	Excellent appearance		
Agency Ratings	DMF 8468		
	MAF 315		
	USP Class VI		
RoHS Compliance	Contact manufacturer		
Resin ID (ISO 1043)	LCP		
Physical	Nominal Value	Unit	Test Method
Density	1.74	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	9800	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	105	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.2	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	10000	MPa	ISO 178
Flexural Stress (23°C)	125	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	5.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	230	°C	ISO 75-2/A
Melting Temperature ¹	335	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.1E-5	cm/cm/°C	ISO 11359-2

Lateral	1.1E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Dielectric Strength	46	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.60		IEC 60250
Dissipation Factor (1 MHz)	0.031		IEC 60250
Comparative Tracking Index	200	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	170	°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°CZone 4 Temperature: 330 to 340°CFeed Temperature: 60 to 80°C			
NOTE			
1.	10°C/min		

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