

Zenite® ZE55311E

Liquid Crystal Polymer

Celanese Corporation

Message:

Zenite ZE55311E is mineral filled LCP resin with improved elongation, low abrasion and smooth surface.

General Information			
Filler / Reinforcement	Mineral filler		
Features	Good wear resistance		
	Excellent appearance		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.73	%	ISO 294-4
Flow direction	0.050	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	130	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	4.3	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	9000	MPa	ISO 178
Flexural Stress (23°C)	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	258	°C	ISO 75-2/A
Melting Temperature ¹	320	°C	ISO 11357-3
Electrical	Nominal Value		Test Method
Relative Permittivity (2.05 GHz)	4.27		IPC TM-650 2.5.5.13
Dissipation Factor (2.05 GHz)	1.4E-3		IPC TM-650 2.5.5.13
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94
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	320 - 330	°C	
Middle Temperature	335 - 345	°C	
Front Temperature	335 - 345	°C	

Nozzle Temperature	335 - 345	°C
Processing (Melt) Temp	325 - 345	°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

Zone 4 Temperature: 335 to 345°CFeed Temperature: 40 to 60°C

NOTE

1. 10°C/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

