

Zenite® 17311 EFT

Liquid Crystal Polymer

Celanese Corporation

Message:

ZENITE® 17311 EFT is a 35% glass and mineral reinforced grade. This grade offers excellent flowability, low warpage, excellent surface appearance, and excellent dimensional stability. Application for this grade is fine pitch connector with thin wall.

General Information			
Filler / Reinforcement	Glass \mineral, 35% filler by weight		
Features	Good dimensional stability		
	Low warpage		
	Good liquidity		
	Good flexibility		
	Excellent appearance		
Uses	Thin wall parts		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	110	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	11000	MPa	ISO 178
Flexural Stress (23°C)	160	MPa	ISO 178
Flexural Strain at Break	2.4	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	298	°C	ISO 75-2/A
Melting Temperature ¹	346	°C	ISO 11357-3
Electrical	Nominal Value	Test Method	
Relative Permittivity (2.05 GHz)	4.18	IPC TM-650 2.5.5.13	
Dissipation Factor (2.05 GHz)	4.0E-4	IPC TM-650 2.5.5.13	
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	330 - 350	°C	
Middle Temperature	340 - 360	°C	

Front Temperature	345 - 365	°C
Nozzle Temperature	355 - 370	°C
Processing (Melt) Temp	360 - 370	°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

Feed Temperature: 40 to 60°CZone 4 Temperature: 355 to 370°C

NOTE

- 10°C/min

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