

VECTRA® S625

Liquid Crystal Polymer
Celanese Corporation

Message:

Low friction and wear resistance.
Chemical abbreviation according to ISO 1043-1 : LCP
Inherently flame retardant.

General Information			
Features	Low friction coefficient		
	Good wear resistance		
	Flame retardancy		
RoHS Compliance		Contact manufacturer	
Resin ID (ISO 1043)		LCP	
Physical	Nominal Value	Unit	Test Method
Density	1.53	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.80	%	ISO 294-4
Flow direction	0.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8300	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	121	MPa	ISO 527-2/1A/50
Tensile Strain (Break)	3.0	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	9500	MPa	ISO 178
Flexural Stress (23°C)	152	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	271	°C	ISO 75-2/A
8.0 MPa, not annealed	129	°C	ISO 75-2/C
Vicat Softening Temperature	227	°C	ISO 306/B50
Melting Temperature ¹	350	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	6.0	hr	
Suggested Max Moisture	0.010	%	
Hopper Temperature	20.0 - 40.0	°C	
Rear Temperature	345 - 355	°C	

Middle Temperature	355 - 365	°C
Front Temperature	365 - 375	°C
Nozzle Temperature	365 - 375	°C
Processing (Melt) Temp	365 - 375	°C
Mold Temperature	80.0 - 140	°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: 365 to 375°C Zone 4 Temperature: 365 to 375°C Feed Temperature: 60 to 80°C

NOTE

- 10°C/min

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