

Zenite® ZE88410NXL

Liquid Crystal Polymer
Celanese Corporation

Message:

40% glass reinforced, high weld-line strength, low warpage and with added lubricity.
Chemical abbreviation according to ISO 1043:1: LCP

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Low warpage		
Resin ID (ISO 1043)	LCP		
Physical	Nominal Value	Unit	Test Method
Density	1.67	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.60	%	ISO 294-4
Flow direction	0.30	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15900	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	130	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	15800	MPa	ISO 178
Flexural Stress (23°C)	200	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)	263	°C	ISO 75-2/A
Vicat Softening Temperature	239	°C	ISO 306/B50
Melting Temperature ¹	328	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.2E-5	cm/cm/°C	ISO 11359-2
Lateral	8.2E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	IEC 60093
Dielectric Strength	33	kV/mm	IEC 60243-1
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.250 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	4.0 - 24	hr	
Suggested Max Moisture	0.010	%	

Hopper Temperature	20.0 - 30.0	°C
Rear Temperature	315 - 325	°C
Middle Temperature	325 - 335	°C
Front Temperature	330 - 340	°C
Nozzle Temperature	335 - 345	°C
Processing (Melt) Temp	335 - 345	°C
Mold Temperature	100 - 130	°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: 335 to 345°C Feed Temperature: 60 to 80°C

NOTE

1. 10°C/min

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