

Zenite® 7244

Liquid Crystal Polymer
Celanese Corporation

Message:

Zenite 7244 is a 40% glass/mineral reinforced liquid crystal polymer resin with a high heat deflection temperature of 295C, high flow and good flatness.

General Information			
UL YellowCard	E344082-100831278		
Filler / Reinforcement	Glass \mineral, 40% filler by weight		
Features	Good liquidity		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.73	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.50	%	ISO 294-4
Flow direction	0.10	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	14000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	115	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.4	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	11300	MPa	ISO 178
Flexural Stress (23°C)	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	295	°C	ISO 75-2/A
Linear thermal expansion coefficient			ISO 11359-2
Flow	6.0E-6	cm/cm/°C	ISO 11359-2
Lateral	4.1E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	200	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.350 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	355 - 365	°C	

Middle Temperature	360 - 370	°C
Front Temperature	360 - 370	°C
Nozzle Temperature	360 - 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°C Zone 4 Temperature: 360 to 370°C

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