Celanese
The chemistry inside innovation™

VECTRA® E845i LDS

LDS capable LCP with higher DTUL and impact
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Chemical abbreviation according to ISO 1043-1 : LCP Inherently flame retardant
UL-Listing V-0 in black a 0.25mm thickness per UL 94 flame testing.
UL = Underwriters Laboratories (USA)

Rheological properties

Moulding shrinkage range, parallel		%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.2	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	15000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	130	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.7	%	ISO 527-1/-2
Flexural Modulus	15000	MPa	ISO 178
Flexural Strength	190	MPa	ISO 178
Charpy notched impact strength, 23°C	12	kJ/m²	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	335	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	255	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	8	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	58	E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 1MHz	3.87		IEC 62631-2-1
Dissipation factor, 1MHz	370	E-4	IEC 62631-2-1

Other properties

Density	1770	kg/m³	ISO 1183

Injection

Drying Temperature	150	°C	
Drying Time, Dehumidified Dryer	6	h	
Processing Moisture Content	0.01	%	
Melt Temperature Optimum	340	°C	Internal
Screw tangential speed	0.17 - 0.18	m/s	
Max. mould temperature	80 - 120	°C	
Injection speed	medium		

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Processing Texts

Pre-drying	VECTRA should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< - 40° C. The time between drying and processing should be as short as possible.