Celanese
The chemistry inside innovation™

VECTRA® MT®4350

40% mineral, low warp & easy flow with smooth surface appearance
Vectra® MT4350 VF3001 (natural) is a mineral filled high flow LCP grade for injection molding

Vectra® MT4350 VF3001 (natural) is a special grade developed for medical industry applications and complies with:

- Food Contact Substance Notification (FCN) No. 742 of the Food and Drug Administration (FDA) and is listed in the Drug Master File (DMF 8464) and the Device Master File (MAF 315)
- the corresponding EU and national registry regulatory requirements
- biocompatibility in tests corresponding to USP 23 Class VI and/or ISO 10993
- low residual monomers
- no animal products

Mineral filled grade with low warp, easy flow and smooth surface appearance.
Chemical abbreviation according to ISO 1043-1 : LCP
Inherently flame retardant

Rheological properties

Moulding shrinkage range, parallel		%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.5	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	10000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	100	MPa	ISO 527-1/-2
Strain at break, 5mm/min	3	%	ISO 527-1/-2
Flexural Modulus	11000	MPa	ISO 178
Flexural Strength	125	MPa	ISO 178
Charpy notched impact strength, 23°C	5	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	4	kJ/m²	ISO 180/1A
Izod impact strength, 23°C	35	kJ/m²	ISO 180/1U

Thermal properties

Melting temperature, 10°C/min	335	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	230	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	10	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	36	E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	1.50	mm	UL 94

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Electrical properties

Relative permittivity, 1MHz	3.6		IEC 62631-2-1
Dissipation factor, 1MHz	310	E-4	IEC 62631-2-1
Volume resistivity	1E14	Ohm.m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2
Electric strength	46	kV/mm	IEC 60243-1
Comparative tracking index	PLC 3	PLC	UL 746A

Other properties

Density	1740	kg/m^3	ISO 1183

Injection

Drying Temperature	170	°C	
Drying Time, Dehumidified Dryer	4 - 6	h	
Processing Moisture Content	0.01	%	
Melt Temperature Optimum	350	°C	Internal
Screw tangential speed	0.17 - 0.18	m/s	
Max. mould temperature	80 - 120	°C	
Back pressure	3	MPa	
Injection speed	very fast		

Characteristics

Additives	Mineral Filler

Additional information

Injection molding	A three-zone screw evenly divided into feed, compression, and metering zones is preferred. A higher percentage of feed flights may be needed for smaller machines: 1/2 feed, 1/4 compression, 1/4 metering. Vectra LCPs are shear thinning, their melt viscosity decreases quickly as shear rate increases. For parts that are difficult to fill, the molder can increase the injection velocity to improve melt flow.

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.
Longer pre-drying times/storage	For subsequent storage of the material in the dryer until processed the temperature does not need to be lowered for grades A, B, C, D and V (<= 24 h).
Injection molding	A three-zone screw evenly divided into feed, compression, and metering zones is

	preferred. A higher percentage of feed flights may be needed for smaller machines: 1/2 feed, 1/4 compression, 1/4 metering.
	Vectra LCPs are shear thinning, their melt viscosity decreases quickly as shear rate increases. For parts that are difficult to fill, the molder can increase the injection velocity to improve melt flow.
Injection molding Preprocessing	Vectra resins are well known for their excellent thermal and hydrolytic stability. In order to ensure these properties are optimum, the resin should be dried correctly prior to processing. Vectra LCP MT4310 and MT4350 should be dried at 150°C for a minimum of 6 hours or at 170°C for a minimum of 4 hours in a desiccant dryer.