

# VECTRA® E830iPd

30% glass filled Platable grade.

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## Typical mechanical properties

Tensile Modulus	15000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	140 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.7 %	ISO 527-1/-2
Flexural Modulus	14000 MPa	ISO 178
Flexural Strength	200 MPa	ISO 178
Charpy notched impact strength, 23°C	30 kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	20 kJ/m <sup>2</sup>	ISO 180/1A

## Thermal properties

Melting temperature, 10°C/min	330 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	245 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	4 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	59 E-6/K	ISO 11359-1/-2

## Other properties

Density	1600 kg/m <sup>3</sup>	ISO 1183
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## Injection

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

## 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  $\leq -40^{\circ}\text{C}$ . The time between drying and processing should be as short as possible.

