

VECTRA® E135i

Higher weldline strength, 35% glass filled

35% glass fiber filled /Higher weldline strength.

Chemical abbreviation according to ISO 1043-1 : LCP Inherently flame retardant. FDA compliant.

UL-Listing V-0 in all colors at .15mm thickness per UL 94 flame testing.

UL = Underwriters Laboratories (USA)

Rheological properties

Moulding shrinkage range, parallel	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.3 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	17000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	140 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.5 %	ISO 527-1/-2
Flexural Modulus	16000 MPa	ISO 178
Flexural Strength	215 MPa	ISO 178
Compressive modulus	13500 MPa	ISO 604
Compressive stress at 1% strain	100 MPa	ISO 604
Charpy impact strength, 23°C	40 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	27 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	20 kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	40 kJ/m ²	ISO 180/1U
Hardness, Rockwell, M-scale	62	ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	331 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	275 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	5 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	59 E-6/K	ISO 11359-1/-2

Electrical properties

Relative permittivity, 1MHz	4.1	IEC 62631-2-1
Dissipation factor, 1MHz	320 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	28 kV/mm	IEC 60243-1
Comparative tracking index	PLC 3 PLC	UL 746A



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Other properties

Water absorption, 2mm
Density

0.07 %
1670 kg/m³

Sim. to ISO 62
ISO 1183

Injection

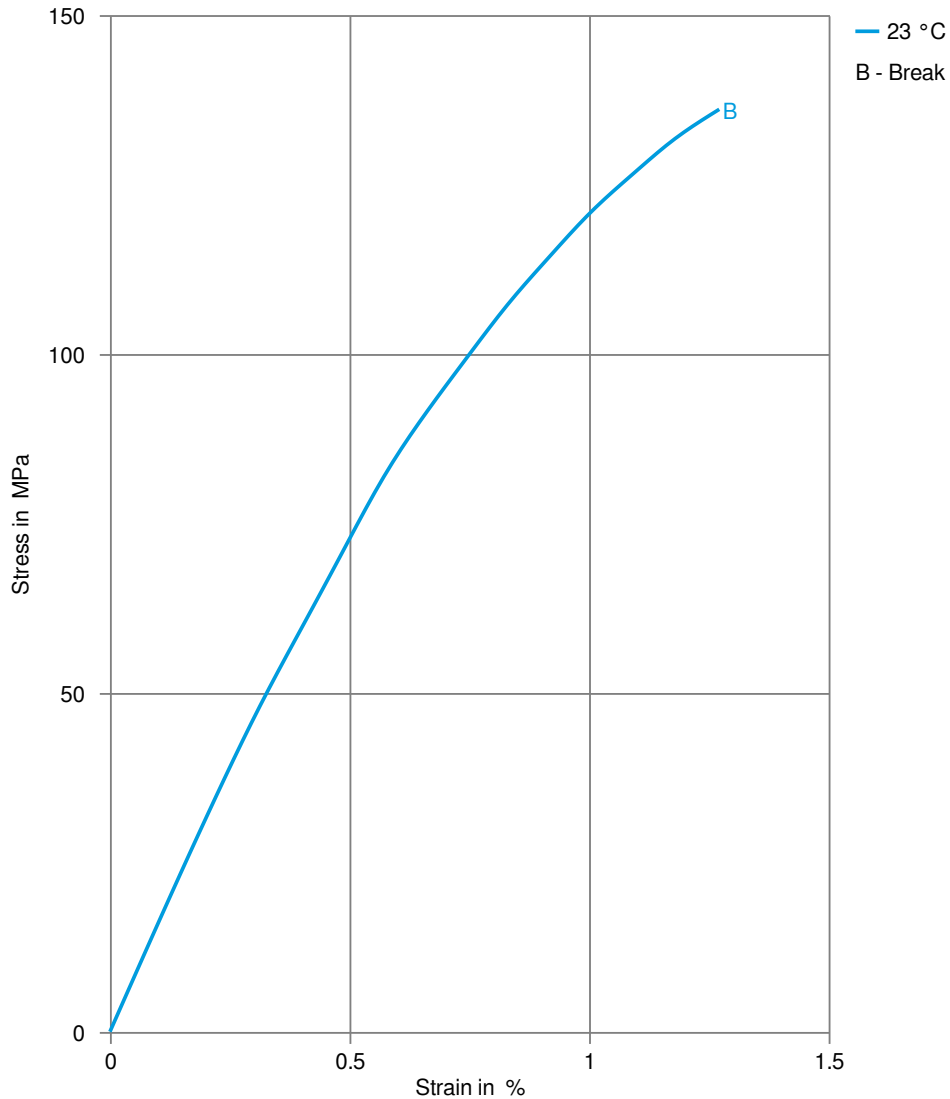
Drying Temperature
Drying Time, Dehumidified Dryer
Processing Moisture Content
Screw tangential speed
Max. mould temperature
Injection speed

150 °C
4 h
0.01 %
0.17 - 0.18 m/s
80 - 120 °C
very fast



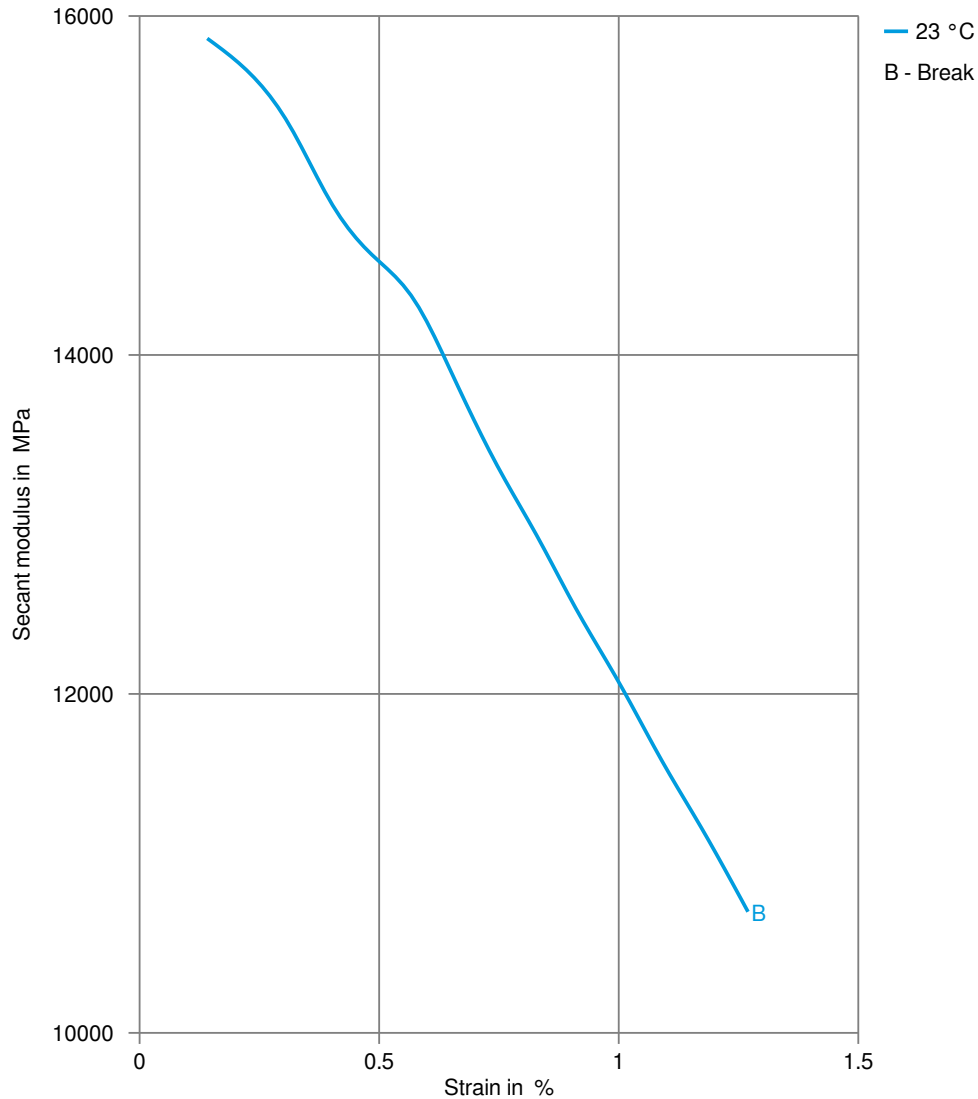
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Stress-strain



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Secant modulus-strain



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

