Celanese
The chemistry inside innovation™

VECTRA® E488i

Ultra low warp
Ultra low warp

Rheological properties

Moulding shrinkage range, parallel	0.1	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.4	%	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	13000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	110	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.5	%	ISO 527-1/-2
Flexural Modulus	13000	MPa	ISO 178
Flexural Strength	160	MPa	ISO 178
Compressive modulus	11000	MPa	ISO 604
Charpy impact strength, 23°C	29	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	7	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	9	kJ/m²	ISO 180/1A
Izod impact strength, 23°C	28	kJ/m²	ISO 180/1U
Hardness, Rockwell, M-scale	54		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	335	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	260	°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	42	E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	0.15	mm	UL 94

Electrical properties

Relative permittivity, 1MHz	4.24		IEC 62631-2-1
Dissipation factor, 1MHz	450	E-4	IEC 62631-2-1
Volume resistivity	1E14	Ohm.m	IEC 62631-3-1
Surface resistivity	1E17	Ohm	IEC 62631-3-2
Electric strength	55	kV/mm	IEC 60243-1
Comparative tracking index	PLC 4	PLC	UL 746A

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Other properties

Water absorption, 2mm	0.005	%	Sim. to ISO 62
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	350	°C	Internal
Max. mould temperature	80 - 120	°C	
Injection speed	very fast		

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True stress-strain