

# VECTRA® MT®1345

30% mineral , hydrolytically stable

Vectra® MT1345 VF3001 (natural) is a 30% mineral filled, easy flow LCP grade for injection molding.

Vectra® MT1345 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/ISO 10993
- low residual monomers
- no animal products

Best overall surface appearance with properties similar to MT1310. Less abrasive than glass fiber reinforced grades.

Improved toughness over MT1310. Outstanding hydrolytic stability. Recommended where aesthetics are key.

Chemical abbreviation according to ISO 1043-1 : LCP

Inherently flame retardant.

## Rheological properties

Moulding shrinkage range, parallel	0.2 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 %	ISO 294-4, 2577

## Typical mechanical properties

Tensile Modulus	11000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	180 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.5 %	ISO 527-1/-2
Flexural Modulus	15000 MPa	ISO 178
Flexural Strength	250 MPa	ISO 178
Compressive modulus	9500 MPa	ISO 604
Compressive stress at 1% strain	60 MPa	ISO 604
Charpy notched impact strength, 23°C	45 kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	33 kJ/m <sup>2</sup>	ISO 180/1A
Izod impact strength, 23°C	40 kJ/m <sup>2</sup>	ISO 180/1U
Hardness, Rockwell, M-scale	67	ISO 2039-2

## Thermal properties

Melting temperature, 10°C/min	280 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	190 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	203 °C	ISO 75-1/-2
Temp. of deflection under load, 8 MPa	121 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	13 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	77 E-6/K	ISO 11359-1/-2



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## Flammability

Burning Behav. at thickness h	V-0 class	UL 94
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## Electrical properties

Relative permittivity, 100Hz	3.8	IEC 62631-2-1
Relative permittivity, 1MHz	3.2	IEC 62631-2-1
Dissipation factor, 100Hz	100 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	160 E-4	IEC 62631-2-1
Volume resistivity	1E12 Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15 Ohm	IEC 62631-3-2
Electric strength	44 kV/mm	IEC 60243-1
Comparative tracking index	PLC 3 PLC	UL 746A
Arc Resistance	180 s	Internal

## Other properties

Density	1650 kg/m³	ISO 1183
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## Injection

Drying Temperature	150 °C	
Drying Time, Dehumidified Dryer	4 - 6 h	
Processing Moisture Content	0.01 %	
Melt Temperature Optimum	290 °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
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## Additional information

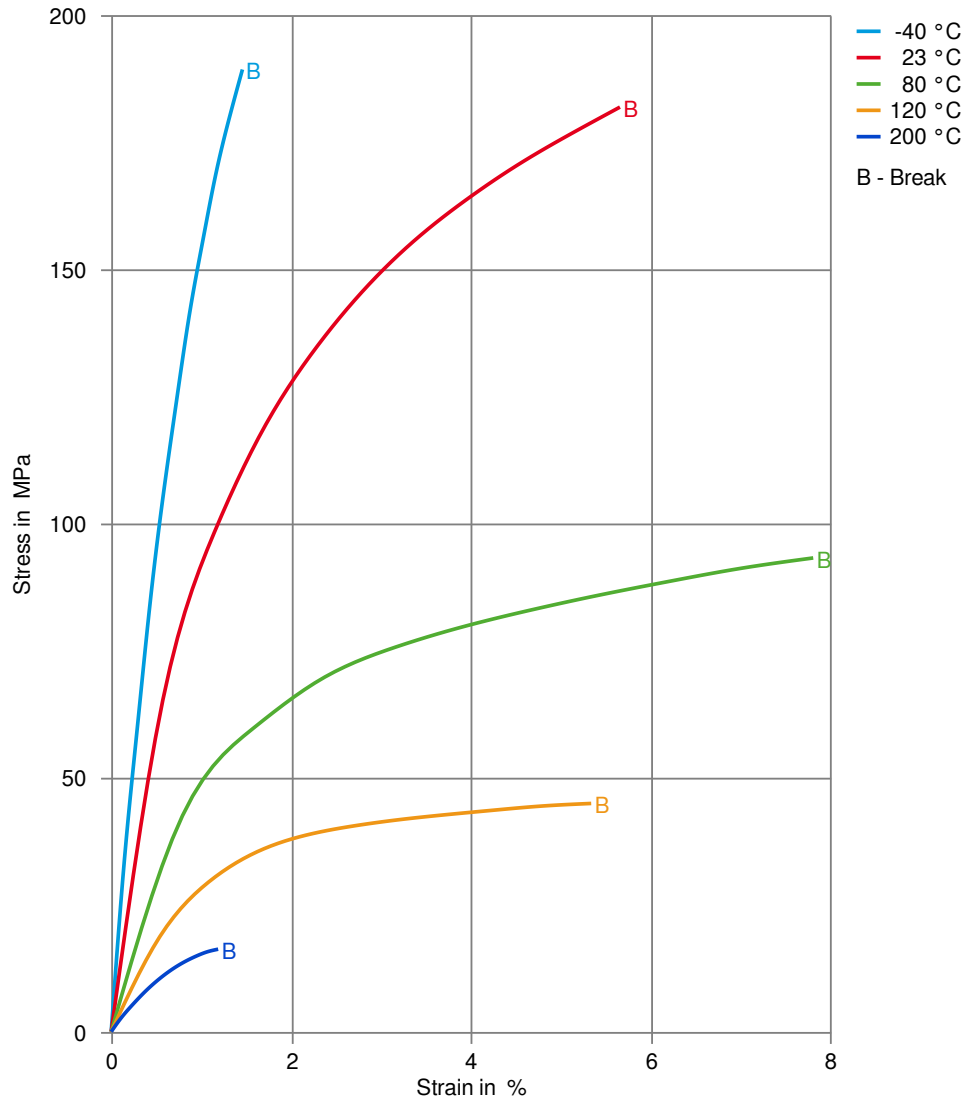
Injection molding	A three-zone screw evenly divided into feed, compression, and metering zones is preferred. A higher percentage of feed flights may be needed for smaller machines: 1/2 feed, 1/4 compression, 1/4 metering.
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Vectra LCPs are shear thinning, 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.



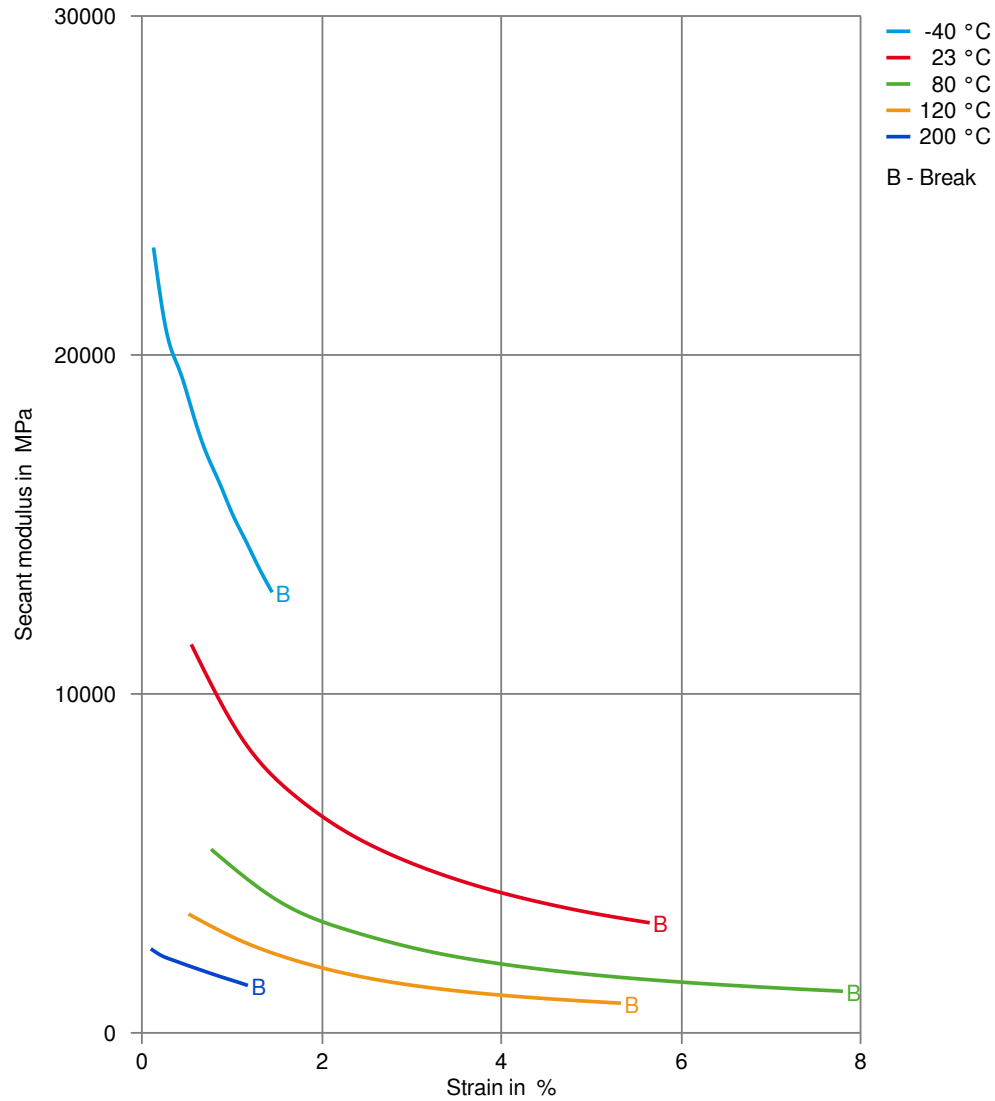
# VECTRA® MT® 1345

## Stress-strain



# VECTRA® MT® 1345

## Secant modulus-strain



# VECTRA® MT®1345

## 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.

### 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 ( $\leq 24\text{ h}$ ).

### 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. The Vectra MT-grades MT1300, MT1305, MT1310, MT1335, MT1340 and MT1345 should be dried at  $150^{\circ}\text{C}$  for a minimum of 4 hours in a desiccant dryer.

