Celanese
The chemistry inside innovation™

Zenite® LKX1864 - LCP

Description

High flow LCP
Zenite LKX1863 is a high flow, low warpage LCP with a good balance of mechanical properties and processability

Physical properties	Value	Unit	Test Standard
Density	**1740**	kg/m³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**12606**	MPa	ISO 527-1, -2
Tensile stress at break, 5mm/min	**92**	MPa	ISO 527-1, -2
Tensile strain at break, 5mm/min	**2.22**	%	ISO 527-1, -2
Charpy notched impact strength, 23 °C	**14.9**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 20 °C/min	**319**	°C	ISO 11357-1/-3
Flammability at thickness h	**V-0**	class	UL 94

Typical injection moulding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	**0.01**	%
Drying time	**3**	h
Drying temperature	**150**	°C

Temperature	Value	Unit
Hopper temperature	**20 - 30**	°C
Feeding zone temperature	**40 - 60**	°C
Zone1 temperature	**320 - 330**	°C
Zone2 temperature	**335 - 345**	°C
Zone3 temperature	**335 - 345**	°C
Zone4 temperature	**335 - 345**	°C
Nozzle temperature	**335 - 345**	°C
Melt temperature	**325 - 345**	°C
Mold temperature	**80 - 120**	°C

Pressure	Value	Unit
Injection pressure	**500 - 1500**	bar
Hold pressure	**500 - 1500**	bar
Back pressure max.	**30**	bar

Characteristics

Special Characteristics	High flow, Low warpage
Product Categories	Mineral/Glass reinforced
Processing	Injection molding