

ZENITE® 88410NXL

40% glass reinforced, high weld-line strength, low warpage and with added lubricity.
 40% glass reinforced, high weld-line strength, low warpage and with added lubricity.
 Chemical abbreviation according to ISO 1043-1 : LCP

Rheological properties

Moulding shrinkage range, parallel	0.3 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	15900 MPa	ISO 527-1/-2
Stress at break, 5mm/min	130 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1 %	ISO 527-1/-2
Flexural Modulus	15800 MPa	ISO 178
Flexural Strength	200 MPa	ISO 178
Compressive stress at 1% strain	130 MPa	ISO 604
Izod notched impact strength, 23°C	8 kJ/m ²	ISO 180/1A

Thermal properties

Melting temperature, 10°C/min	328 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	263 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	12 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	82 E-6/K	ISO 11359-1/-2

Flammability

Burning Behav. at thickness h	V-0 class	UL 94
Thickness tested	0.25 mm	UL 94

Electrical properties

Surface resistivity	1E17 Ohm	IEC 62631-3-2
Electric strength	33 kV/mm	IEC 60243-1

Other properties

Density	1670 kg/m ³	ISO 1183
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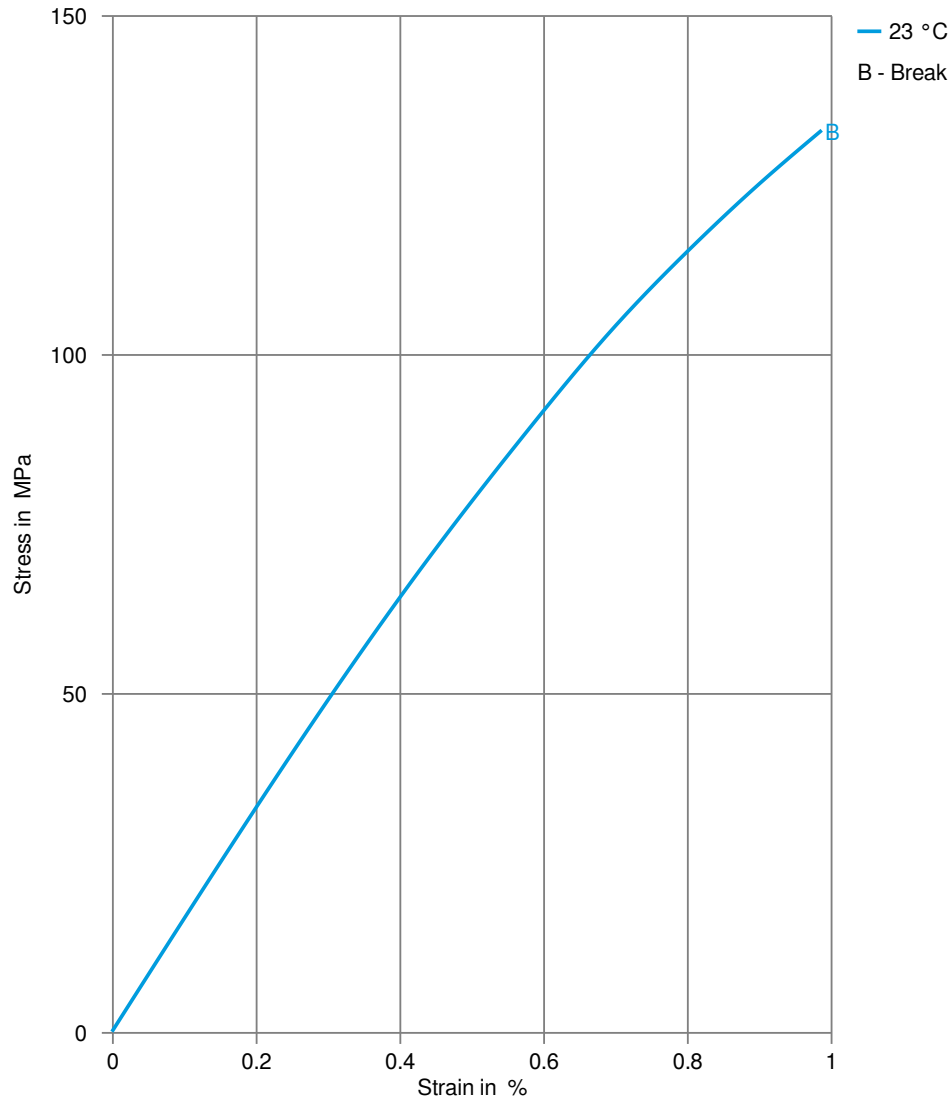
Injection

Drying Temperature	150 °C
Drying Time, Dehumidified Dryer	4 - 24 h
Processing Moisture Content	0.01 %
Screw tangential speed	0.17 - 0.18 m/s
Max. mould temperature	100 - 130 °C
Back pressure	3 MPa
Injection speed	very fast



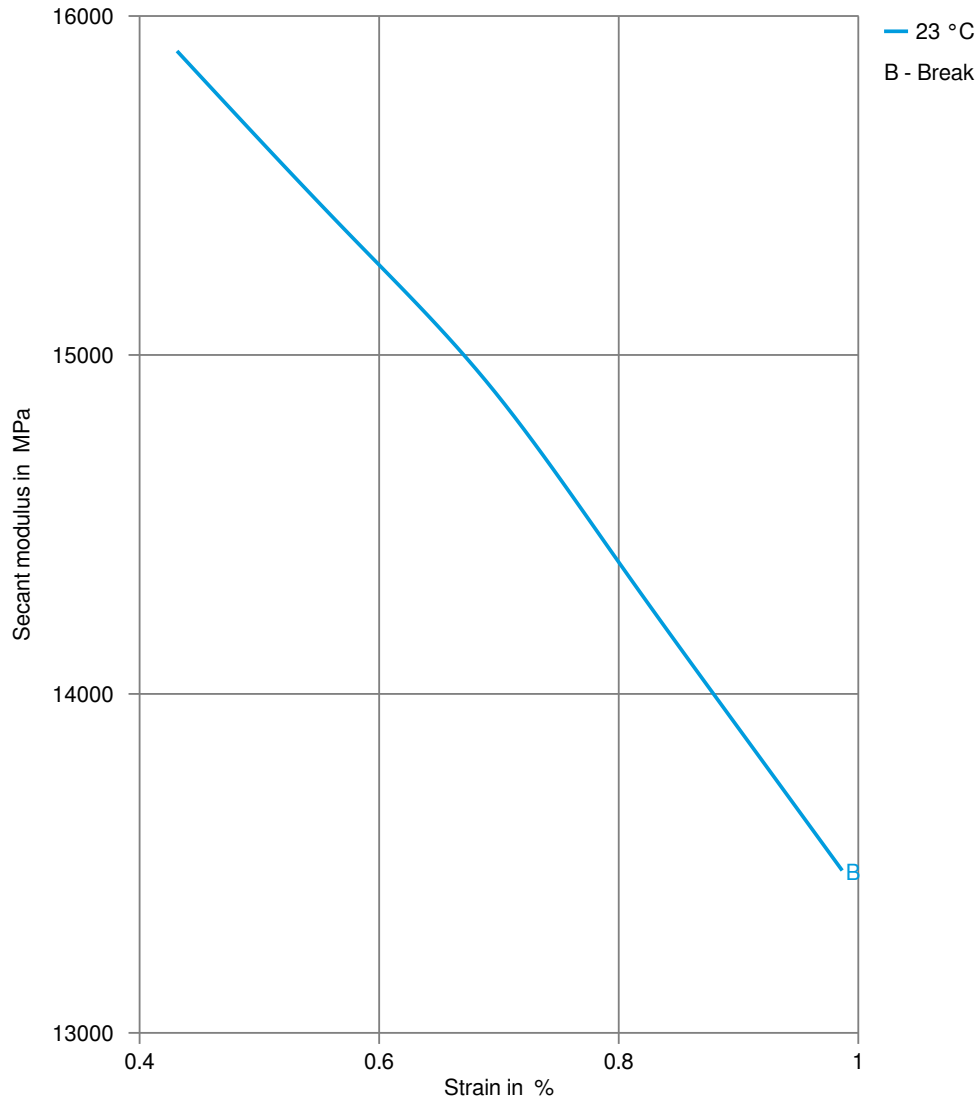
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Stress-strain



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Secant modulus-strain



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Processing Texts

Pre-drying

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

