Celanese
The chemistry inside innovation™

VECTRA® A230

Liquid Crystal Polymer

For Vectra® A230, two seperate versions are available. While Vectra® A230 is developed for exceptional stiffness, Vectra® A230D-3 is additionaly modified for electrical conductivity. 30% carbon fiber reinforced. Chemical abbreviation according to ISO 1043-1 : LCP Inherently flame retardant UL-Listing V-0 at 0.43mm thickness per UL 94 flame testing. Relative-Temperature-Index (RTI) according to UL 746B: electrical 130°C, mechanical 130°C. UL = Underwriters Laboratories (USA)

Product information

Resin Identification	LCP-CF30	ISO 1043
Part Marking Code	>LCP-CF30<	ISO 11469

Rheological properties

Molding shrinkage, parallel	0.1	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	3.41E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	21600	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.1	%	ISO 527-1/-2
Flexural modulus	3.77E6	psi	ISO 178
Flexural strength	33100	psi	ISO 178
Compressive modulus	3.41E6	psi	ISO 604
Compressive strength	19700	psi	ISO 604
Compressive stress at 1% strain	18000	psi	ISO 604
Tensile creep modulus, 1h	2.84E6	psi	ISO 899-1
Tensile creep modulus, 1000h	2.29E6	psi	ISO 899-1
Charpy impact strength, 23°C	6.18	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	3.33	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	3.33	ftlb/in²	ISO 180/1A
Izod impact strength, 23°C	8.56	ftlb/in²	ISO 180/1U
Hardness, Rockwell, M-scale	83		ISO 2039-2

Tribological properties

Coefficient of dynamic friction, against steel	0.13	ISO 8295
Coefficient of dynamic friction, against brass	0.13	
Coefficient of dynamic friction, against aluminium	0.13	

Thermal properties

Melting temperature, 10°C/min	536	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	451	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	482	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	379	°F	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	354	°F	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	0.01	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.0333	E-4/°F	ISO 11359-1/-2

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Flammability

Burning Behav. at thickness h	V-0	class	IEC 60695-11-10

Electrical properties

Volume resistivity	1	Ohm.m	IEC 62631-3-1
Surface resistivity	10	Ohm	IEC 62631-3-2

Physical/Other properties

Humidity absorption, 2mm	0.06	%	Sim. to ISO 62
Density	0.0538	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	302	°F
Drying Time, Dehumidified Dryer	4 - 6	h
Processing Moisture Content	≤0.01	%
Melt Temperature Optimum	554	°F
Min. melt temperature	545	°F
Max. melt temperature	563	°F
Max. screw tangential speed	0.2 - 0.3	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	176	°F
Max. mold temperature	248	°F
Back pressure	435	psi
Ejection temperature	423	°F

Characteristics

Processing	Injection Molding
Special characteristics	Increased electrical conductivity, Anti-static, Static dissipative, Flame retardant, Light stabilized or stable to light, High Flow

Additional information

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. Vectra A-grades should be dried at 150 C for a minimum of 4 hours in a desiccant dryer.

Processing

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. To prevent thermal decomposition, off-gassing, and pressure build-up in the barrel, melt temperatures should not exceed 330°C.

Processing Notes

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 =< - 40° C. The time between drying and processing should be as short as possible.

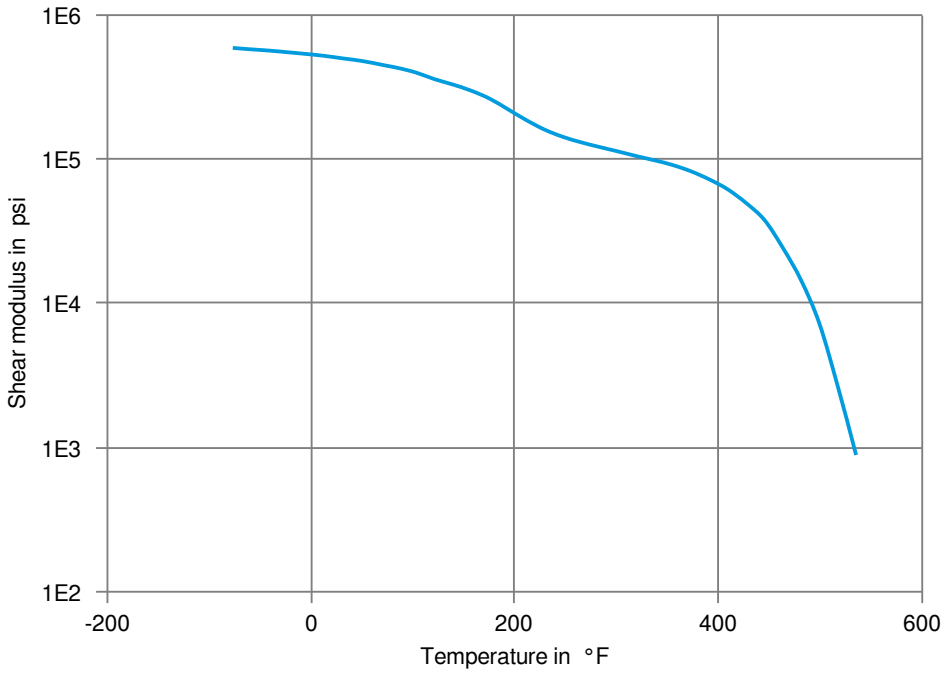
Storage

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 (<= 24 h).

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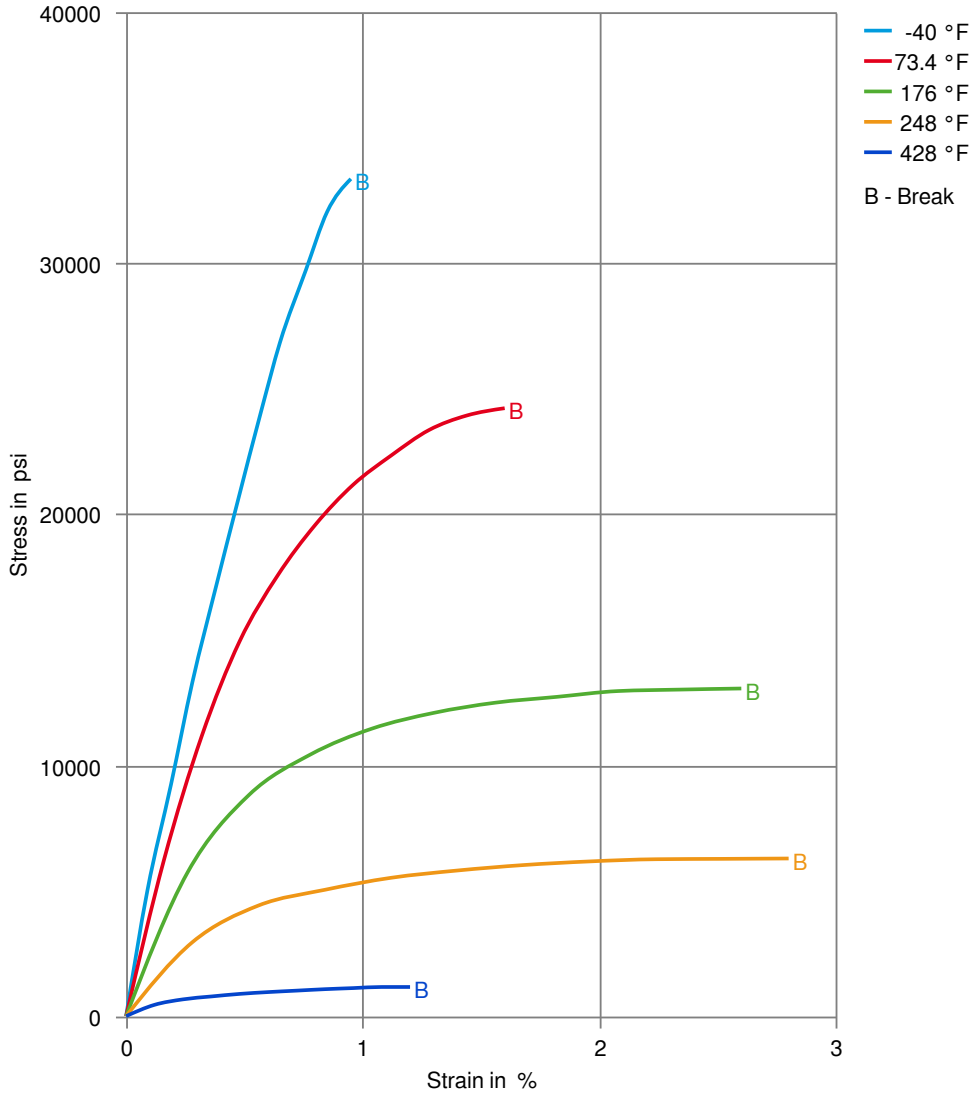
Dynamic Shear modulus-temperature



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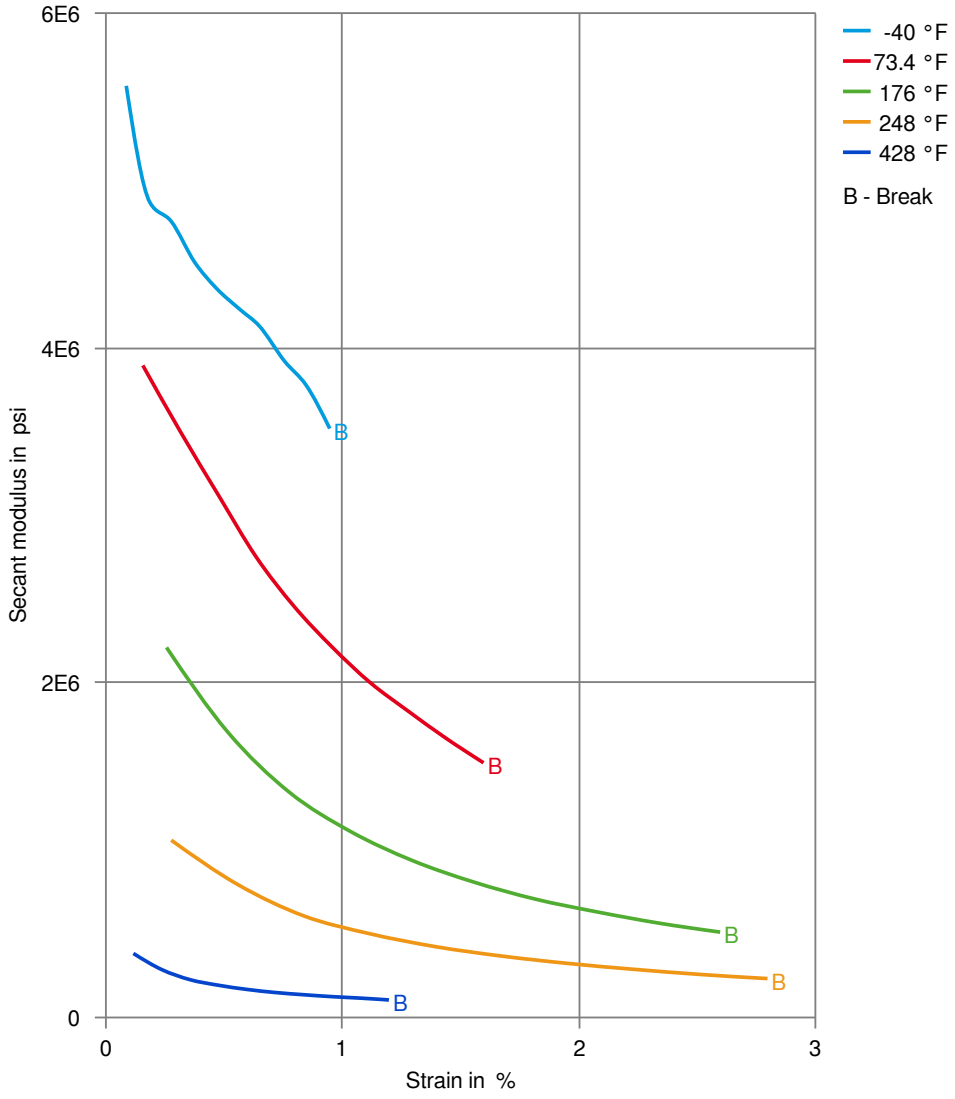
Stress-strain



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Secant modulus-strain



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