Celanese
The chemistry inside innovation™

VECTRA® E473I

Liquid Crystal Polymer

Vectra E473i is a low warp LCP with easy flow and high temperature capability. Chemical abbreviation according to ISO 1043-1 : LCP Inherently flame retardant UL-Listing V-0 in natural and black at 0.75mm thickness per UL 94 flame testing. Relative-Temperature-Index (RTI) according to UL 746B: electricals 130°C, mechanicals 130°C. UL = Underwriters Laboratories (USA)

Product information

Resin Identification	LCP-(GF+MD)33		ISO 1043
Part Marking Code	>LCP-(GF+MD)33<		ISO 11469

Rheological properties

Molding shrinkage, parallel	0.1	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	1.6E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	18100	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.2	%	ISO 527-1/-2
Flexural modulus	1.74E6	psi	ISO 178
Flexural strength	24700	psi	ISO 178
Compressive stress at 1% strain	8560	psi	ISO 604
Charpy impact strength, 23°C	15.7	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	6.18	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	6.18	ftlb/in²	ISO 180/1A
Izod impact strength, 23°C	14.3	ftlb/in²	ISO 180/1U
Hardness, Rockwell, M-scale	40		ISO 2039-2

Thermal properties

Melting temperature, 10°C/min	635	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	482	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	318	°F	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	374	°F	ISO 306
Coefficient of linear thermal expansion (CLTE), parallel	0.03	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.0611	E-4/°F	ISO 11359-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0	class	IEC 60695-11-10

Electrical properties

Relative permittivity, 1MHz	4		IEC 62631-2-1
Dissipation factor, 1MHz	340	E-4	IEC 62631-2-1
Volume resistivity	1E14	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	1240	kV/in	IEC 60243-1
Comparative tracking index	175		IEC 60112

Revised: 2025-03-20 Source: Celanese Materials Database

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Physical/Other properties

Density	0.0588	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	671	°F
Min. melt temperature	635	°F
Max. melt temperature	698	°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
Ejection temperature	597	°F

Automotive

OEM	ADDITIONAL INFORMATION
VW Group	No spec listed (Natural)

Characteristics

Processing	Injection Molding
Special characteristics	Flame retardant, Heat stabilized or stable to heat, High Flow, Low Warpage, Lead-free soldering resistant

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NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.
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