

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/m ³	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/m ²	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