

Technical data

KEBAFLOW LCP HF130 (FE 190203*)

KEBAFLOW LCP HF130 is a 30% short glass fiber reinforced LCP with very high heat resistance. The material is characterized by the following properties: Good flowability at thin wall thicknesses, very good toughness and strength, inherent flame retardancy, high heat deflection temperature (HDT ~300°C), good chemical resistance.

Polymer: LCP

ISO designation: LCP-GF30

Productgroup: LCP

Brief description of the product family:

The trade name KEBAFLOW stands for a range of liquid crystalline polymers (LCP). KEBAFLOW's outstanding flowability enables the realization of extremely thin wall thicknesses. KEBAFLOW LCP is inherently flame retardant and exhibits very high heat resistance and good aging behavior.

Properties:

dimensionally stable, Thin wall thicknesses, good aging behavior, good fire behavior, high continuous used temperature, semi-crystalline

Typical areas of application:

Pressure cans, LED housing, Luminaire housing, Relay, Bobbin, Plug

Industries:

Automotive, Electrical and electronics industry, Household appliances, Aviation Industry, Mechanical Engineering

Physical properties

Water absorption in % in Anlehnung an ISO 62	0.04
Density in kg/m ³ ISO 1183-1	1620.00

Mechanical properties

E-modulus in MPa ISO 527-1	14000
Breaking stress in MPa ISO 527-1	136.0
Elongation at break in % ISO 527-1	1.5

Rheological properties

Shrinkage in flow direction in % ISO 294-4	0.16
Shrinkage transverse to the flow direction in % ISO 294-4	0.46

Thermal properties

Heat deflection temperature HDT (1.80 MPa) in °C ISO 75-1/-2	305.0
Fire behavior (0.8 mm wall thickness) IEC 60695-11-10	V0

Electrical properties	
Contact resistance in Ohm*m IEC 60093	1e+13
Surface resistivity in ohms IEC 60093	1e+15

Processing instructions:

Pre-drying:

Dryer type: dry air dryer

Temperature: 150 – 170 °C

drying time: 4 – 6 h

Recommended max. residual moisture: < 0.01 %.

Recommended basic settings:

melt temperature: 335 – 345 °C

Mold temperature: 80 – 120 °C

With higher cavity temperatures, smoother surfaces and better flow properties can usually be achieved. surfaces and better flow properties.

Injection speed: very high

Viscosity decreases with increasing shear. Thus, for parts that are difficult to fill, increasing the injection speed may be more effective than increasing the melt temperature.

Back pressure: 0 – 30 bar (spec.)

Screw: 3-zone screw with non-return valve

Nozzle: Open nozzle or shut-off nozzle (recommended)

Wear protection: Wear and corrosion protected according to machine manufacturer's recommendation for LCP glass fiber reinforced

The most important processing instructions in brief:

- Ensure good drying! Ensure moisture content < 0.01%.
- Inject as fast as possible, if necessary use machine with pressure accumulator.
- Injection speed has a strong influence on the achievable flow path length
- Avoid excessively thick walls
- Ensure good venting

Legal notices:

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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Am Weidenbach 8-10
51491 Overath

Telefon +49 (0)2206 90851-100
Telefax +49 (0)2206 90851-199

E-Mail: kontakt@barlog.de
Web: www.barlog.de