

SUMIKASUPER® E6404C

LCP

Sumitomo Chemical Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.0013	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.008	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	130	MPa	ASTM D 638
Flexural Modulus	13500	MPa	ASTM D 790
Flexural Strength	140	MPa	ASTM D 790
Izod Impact unnotched, 1/8 in	250	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.3	mm	-
DTUL @ 264 psi	285	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Volume Resistivity	1000000	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Density	1470	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	130	°C	-
Pre-drying - Time	4 - 24	h	-
Melt temperature	350	°C	-
Mold temperature	40 - 160	°C	-
Zone 1	280 - 320	°C	-
Zone 2	320 - 350	°C	-
Zone 3	340 - 370	°C	-
Nozzle temperature	340 - 370	°C	-
Screw speed	50 - 100	rpm	-
Injection pressure	80 - 160	MPa	-
Back pressure	1 - 5	MPa	-
Holding pressure	20 - 40	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Black