

Luranyl® KR 2454/3 G4

Polyphenylene Ether + PS

ROMIRA GmbH

Message:

PPE+PS-I Blend with 20% glass fibre; halogen free flame retardant; high heat resistance

General Information	
UL YellowCard	E148878-223649
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight
Additive	Flame retardancy
Features	Heat resistance, high
	Halogen-free
	Flame retardancy
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/21.6 kg)	15.0	cm ³ /10min	ISO 1133
Molding Shrinkage (23°C, 3.20 mm)	0.30 - 0.50	%	ISO 294-4
Water Absorption (23°C, 24 hr)	< 0.15	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6500	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	90.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Flexural Stress ¹ (23°C)	150	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	35	kJ/m ²	ISO 179/1eU
23°C	35	kJ/m ²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	135	°C	ISO 75-2/A
Vicat Softening Temperature	139	°C	ISO 306/B50
CLTE - Flow (23 to 80°C)	3.0E-6 - 4.0E-6	cm/cm/°C	ISO 11359-2

Thermal Conductivity	0.22	W/m/K	DIN 52612
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	V-1		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.050	%	
Processing (Melt) Temp	260 - 300	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate		
Screw Speed	12 - 18	rpm	
Injection instructions			
Maximum Residence Time: 4 to 10 minInjection Pressure: moderate to high			
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.050	%	
Cylinder Zone 1 Temp.	240 - 270	°C	
Cylinder Zone 2 Temp.	240 - 270	°C	
Cylinder Zone 3 Temp.	240 - 270	°C	
Cylinder Zone 4 Temp.	240 - 270	°C	
Cylinder Zone 5 Temp.	240 - 270	°C	
Melt Temperature	< 270	°C	
Extrusion instructions			
Maximum Residence Time: 4 to10 min			
NOTE			
1.	2.0 mm/min		

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