

Luranyl® KR 2403 G6

Polyphenylene Ether + PS

ROMIRA GmbH

Message:

PPE+PS-I Blend with 30% glass fibre, high rigidity and heat resistance

General Information			
UL YellowCard	E148878-223654		
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Rigidity, high		
	Heat resistance, high		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/21.6 kg)	9.00	cm³/10min	ISO 1133
Molding Shrinkage (23°C, 3.20 mm)	0.20 - 0.40	%	ISO 294-4
Water Absorption (23°C, 24 hr)	< 0.10	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	11000	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	130	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.5	%	ISO 527-2/5
Flexural Stress ¹ (23°C)	160	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	13	kJ/m²	ISO 179/1eA
23°C	14	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	25	kJ/m²	ISO 179/1eU
23°C	25	kJ/m²	ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	141	°C	ISO 75-2/A
Vicat Softening Temperature	145	°C	ISO 306/B50
CLTE - Flow (23 to 80°C)	3.0E-5 - 4.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.23	W/m/K	DIN 52612

Flammability	Nominal Value	Test Method
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Flame Rating (1.60 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.050	%
Suggested Max Regrind	5	%
Processing (Melt) Temp	270 - 310	°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 - 100	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	< 0.050	%
Cylinder Zone 1 Temp.	240 - 280	°C
Cylinder Zone 2 Temp.	240 - 280	°C
Cylinder Zone 3 Temp.	240 - 280	°C
Cylinder Zone 4 Temp.	240 - 280	°C
Cylinder Zone 5 Temp.	240 - 280	°C
Melt Temperature	< 280	°C
Extrusion instructions		
Maximum Residence Time: 4 to 10 min		
NOTE		
1.	2.0 mm/min	

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