

Luranyl® KR 2451/3

Polyphenylene Ether + PS

ROMIRA GmbH

Message:

PPE+PS-I Blend with halogen free flame retardant; good heat resistance

General Information	
UL YellowCard	E148878-223659
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	1.08	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/21.6 kg)	138	cm ³ /10min	ISO 1133
Molding Shrinkage (23°C, 3.20 mm)	0.50 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	< 0.15	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2500	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	5.0	%	ISO 527-2/50
Flexural Stress ¹ (23°C)	110	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	14	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	92.0	°C	ISO 75-2/A
Vicat Softening Temperature	110	°C	ISO 306/B50
CLTE - Flow (23 to 80°C)	6.0E-5 - 7.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.18	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 - 290	°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 to 10 min		

NOTE		
1.	2.0 mm/min	

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