

# Luranyl® KR 2404

Polyphenylene Ether + PS

ROMIRA GmbH

## Message:

PPE+PS-I Blend with high heat resistance

| General Information |                       |  |  |
|---------------------|-----------------------|--|--|
| UL YellowCard       | E148878-223655        |  |  |
| Features            | Heat resistance, high |  |  |
| Forms               | Particle              |  |  |
| Processing Method   | Extrusion             |  |  |
|                     | Injection molding     |  |  |

| Physical                                    | Nominal Value | Unit                   | Test Method |
|---------------------------------------------|---------------|------------------------|-------------|
| Density                                     | 1.06          | g/cm <sup>3</sup>      | ISO 1183    |
| Melt Volume-Flow Rate (MVR) (250°C/21.6 kg) | 65.0          | cm <sup>3</sup> /10min | ISO 1133    |
| Molding Shrinkage (23°C, 3.20 mm)           | 0.50 - 0.70   | %                      | ISO 294-4   |
| Water Absorption (23°C, 24 hr)              | < 0.10        | %                      | ISO 62      |

| Mechanical                          | Nominal Value | Unit | Test Method  |
|-------------------------------------|---------------|------|--------------|
| Tensile Modulus (23°C)              | 2500          | MPa  | ISO 527-2/1  |
| Tensile Stress (Yield, 23°C)        | 55.0          | MPa  | ISO 527-2/50 |
| Tensile Strain (Yield, 23°C)        | 4.0           | %    | ISO 527-2/50 |
| Flexural Stress <sup>1</sup> (23°C) | 100           | MPa  | ISO 178      |

| Impact                           | Nominal Value | Unit              | Test Method |
|----------------------------------|---------------|-------------------|-------------|
| Charpy Notched Impact Strength   |               |                   | ISO 179/1eA |
| -30°C                            | 12            | kJ/m <sup>2</sup> | ISO 179/1eA |
| 23°C                             | 22            | kJ/m <sup>2</sup> | 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) | 111             | °C       | ISO 75-2/A  |
| Vicat Softening Temperature                       | 125             | °C       | ISO 306/B50 |
| CLTE - Flow (23 to 80°C)                          | 6.0E-6 - 7.0E-6 | 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) | 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 | 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 min Injection 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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#### Recommended distributors for this material

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