

Luranyl® HT 220 G6

Polyphenylene Ether + Nylon 66

ROMIRA GmbH

Message:

PPE+PA Blend with 30% glass fibre; impact resistant; very high heat resistance

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Impact resistance, high		
	Heat resistance, high		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.32	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	45.0	cm ³ /10min	ISO 1133
Molding Shrinkage (23°C, 3.20 mm)	0.20 - 0.50	%	ISO 294-4
Water Absorption (23°C, 24 hr)	< 0.50	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	8400	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	140	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	8.0	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	60	kJ/m ²	ISO 179/1eU
23°C	70	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	210	°C	ISO 75-2/A
Vicat Softening Temperature	220	°C	ISO 306/B50
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	%	
Processing (Melt) Temp	285 - 310	°C	
Mold Temperature	90.0 - 120	°C	
Injection Rate	Moderate		
Screw Speed	12 - 18	rpm	

Injection instructions

Maximum Residence Time: 4 to 10 minInjection Pressure: moderate to high

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

