

# Processing Guidelines

## Injection Moulding



## Luranyl® HT PPE/PA Blends

### General

Luranyl HT PPE/PA can be processed using all techniques convenient for thermoplastic resins. In particular it can be moulded without difficulty on usual injection moulding machines. A broad processing range, good thermal stability, low moulding shrinkage and low tendency to warp allow trouble free injection moulding.

Luranyl HT PPE/PA blend comprises one amorphous (PPE) and one semi crystalline (PA) polymer, so we recommend to follow preferably our guidelines in order to process the material without problems. The use of heatable nozzles avoids possible freezing.

### Storage

Luranyl HT PPE/PA should be stored dry in closed rooms. PPE/PA have to be protect against direct sun shine. If the material is stored outside the packs can be easy damaged and the granulate becomes faster yellow. Thus the mechanical and optical properties can be affected.

### Drying

Luranyl HT PPE/PA leaves the plant with moisture content < 0.1 % (Karl-Fischer-Titration).

Luranyl HT PPE/PA can absorb moisture. We therefore recommend to dry the material in a dry air dryer at 80 – 100 °C for about 2 – 4 hours (circulation air drying oven, vacuum dryer, fixed hopper). If the material will not be dried properly, streaks on the surface can occur.

Furthermore, we recommend to dry the material up to moisture content < 0.05 %. The pellet hopper used should be heatable.

The drying time should be limited to less than 2h if the material is coloured in light colour.

### Processing

Depending on the size of the injection moulding machine and the finished part, the processing conditions should be controlled regular and very careful. Following conditions are recommended for processing:

Luranyl® PPE/PA	unreinforced	reinforced
Drying temperature	80 - 100 °C	80 - 100 °C
Drying time	2- 4 h	2 - 4 h
Melt temperature	270 - 300 °C	285 - 310 °C
Mould temperature	80 - 120 °C	90 - 120 °C
Maximum residence time	4-10 min	4-10 min
Injection speed	moderate	moderate
Peripheral screw speed	0,2 m/s max. 0,3 m/s	0,2 m/s max. 0,3 m/s
Injection pressure	moderate to high	moderate to high

## Recycling

Defective parts and sprues from Luranyl PPE/PA without any contaminations can be reprocessed as a regrind. The amount of the regrind used should be chosen in dependence on the colour and degree of reinforcing. We recommend to start with 5% regrind and to control changes of the mechanical and optical properties. However, if there are specific properties requested, only prime material should be used.

The above processing guidelines should advise without commitment. The statements given are based on our experience and are correct to the best of the knowledge at the time of printing. No liability should be assumed as a result of this information.

