

## Technical data

# KEBALLOY ECO FE 220104 PPS

KEBALLOY ECO FE 220104 PPS is an unfilled PPS recyclate.

**Polymer:** PPS

**ISO designation:** PPS(REC)

**Productgroup:** Recycling Compounds

### **Brief description of the product family:**

The name KEBALLOY ECO stands for a product range of engineering plastics and high-performance compounds based on post-consumer or post-industrial recyclate. KEBALLOY ECO compounds enable significant CO2 savings compared to virgin materials and meet the highest requirements in terms of product properties and their uniformity from batch to batch. KEBALLOY ECO compounds also enable customer- or application-specific microcycles of engineering plastic parts and are thus a valuable contribution on the way to a circular plastics economy.

### **Properties:**

dimensionally stable, good aging behavior, good fire behavior, high continuous used temperature, High strength, semi-crystalline

### **Typical areas of application:**

Covers, Cover, Electronic components, Housing, Lamp socket, Cables and connectors for media-carrying systems, Pump housing, Sensors, Bobbin, Plug, Valves, Valve caps, Distributor

### **Industries:**

Automotive, Electrical and electronics industry, Household appliances, Industry

## Physical properties

Density in kg/m <sup>3</sup>   ISO 1183-1	1340
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## Mechanical properties

E-modulus in MPa   ISO 527-1	3400
Breaking stress in MPa   ISO 527-1	79
Elongation at break in %   ISO 527-1	11.0
Impact strength (Charpy) at 23°C in kJ/m <sup>2</sup>   ISO 179-1eU	27.0
Notched impact strength (Charpy) at 23°C in kJ/m <sup>2</sup>   ISO 179-1eA	3.5

## Thermal properties

Melting temperature (DSC, 10°C/min) in °C   ISO 11357-1/-3	280
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**Processing instructions:**

Pre-drying:

Dryer type: dry air dryer (!).

Temperature: 120 – 140 °C

drying time: 4 – 8 h

recommended max. residual moisture: < 0.02 %.

Temperatures:

Melt temperature: 320 – 340°C

Mold temperature: 140 – 180°C (As a rule of thumb, the higher the requirements, the higher the mold temperature).

Back pressure: < 10 bar (spec.)

The injection speed should be set as a slow – fast – slow profile. As a principle: as fast as possible, as slow as necessary.

Machine selection:

In the processing of KEBATRON PPS, wear and corrosion protected injection units have proven their worth. The injection unit should be selected so that the shot volume is 50 – 80% of the maximum metering volume. The dwell time should be kept as short as possible.

**Legal notices:**

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

\* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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Created at: 19.04.2024

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