

VICTREX™ PEEK POLYMER 450CA30

General Information

Product Description

High performance thermoplastic material, 30% carbon fibre reinforced PolyEtherEtherKetone (PEEK), semi crystalline, granules for injection moulding and extrusion, standard flow, colour black.

Applications for higher strength and stiffness in a static or dynamic system. Excellent wear resistance, low coefficient of friction, low coefficient of thermal expansion. Chemically resistant to aggressive environments.

SKU numbers – 400001, 400165, 420000

Material Properties

Physical	Nominal Value	Unit	Test Method
Density (Crystalline)	1.40	g/cm ³	ISO 1183
Spiral Flow			Internal Method
-- 1	7.50	cm	
-- 2	33.0	cm	
Molding Shrinkage ³			ISO 294-4
Across Flow	0.50	%	
Flow	0.10	%	
Water Absorption (Saturation, 23°C)	0.30	%	ISO 62
Water Absorption Saturation (100°C)	0.45	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	28000	MPa	ISO 527-1
Tensile Stress			ISO 527-2
Break, 23°C	265	MPa	
Break, 125°C	160	MPa	
Break, 175°C	85.0	MPa	
Break, 275°C	50.0	MPa	
Tensile Strain (Break, 23°C)	1.7	%	ISO 527-2
Flexural Modulus (23°C)	24000	MPa	ISO 178
Flexural Stress			ISO 178
23°C	380	MPa	
125°C	275	MPa	
175°C	130	MPa	
275°C	65.0	MPa	
Compressive Stress			ISO 604
23°C	320	MPa	
120°C	200	MPa	
200°C	70.0	MPa	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45.0	kJ/m ²	ISO 179/1U
Notched Izod Impact Strength (23°C)	9.0	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength (23°C)	50.0	kJ/m ²	ISO 180

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Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 23°C)	87.5		ISO 868
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	336	°C	ISO 75-2/Af
Glass Transition Temperature Onset	143	°C	ISO 11357-2
Midpoint	150	°C	
Melting Temperature	343	°C	ISO 11357-3
CLTE - Flow < 143°C	5	ppm/K	ISO 11359-2
> 143°C	6	ppm/K	
CLTE - Average < 143°C	40	ppm/K	ISO 11359-2
> 143°C	100	ppm/K	
Thermal Conductivity 23°C ⁴	0.95	W/m/K	ISO 22007-4
23°C ⁵	2.0	W/m/K	
RTI Imp	200	°C	UL 746B
RTI Str	240	°C	UL 746B
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity ⁶ (23°C)	1.0E+5	ohms·cm	ASTM D4496
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (2.0 mm)	960	°C	IEC 60695-2-12
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (400°C)	675	Pa·s	ISO 11443

Typical Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120 to 150	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	< 100	°C
Rear Temperature	375	°C
Middle Temperature	380 to 385	°C
Front Temperature	390	°C
Nozzle Temperature	395	°C
Mould Temperature	180 to 210	°C

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Injection Notes

Drying Temperature / Time: 150°C / 3h or 120°C / 5h (residual moisture <0.02%)

Runner: Die / nozzle >3mm, manifold >3.5mm

Gate: >2mm or 0.5 x part thickness

Important notes:

1) Processing conditions quoted in our datasheets are typical of those used in our processing laboratories

- Data for mould shrinkage should be used for material comparison. Actual mould shrinkage values are highly dependent on part geometry, mould configuration, and processing conditions.
- Mould shrinkage differs for along flow and across flow directions. "Along flow" direction is taken as the direction the molten material is travelling when it exits the gate and enters the mould.
- Mould shrinkage is expressed as a percent change in dimension of a specimen in relation to mould dimensions.

2) Data are generated in accordance with prevailing national, international and internal standards, and should be used for material comparison.

Actual property values are highly dependent on part geometry, mould configuration and processing conditions. Properties may also differ for along flow and across flow directions.

Detailed data available on our website www.victrex.com or upon request.

Notes

¹ Mould Temperature: 200°C, Melt Temperature: 395°C, 1.00 mm

² Mould Temperature: 200°C, Melt Temperature: 395°C, 3.00 mm

³ 395°C nozzle, 200°C tool

⁴ Average

⁵ Along flow

⁶ 1V

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