

VICTREX™ PEEK POLYMER 650GL30

General Information

Product Description

High performance thermoplastic material, 30% glass fibre reinforced PolyEtherEtherKetone (PEEK), semi crystalline, granules for injection moulding and extrusion, low flow, colour natural/beige.

Applications for higher strength in a static system. Low coefficient of thermal expansion. Chemically resistant to aggressive environments, suitable for sterilisation for medical and food contact applications.

Material Properties

Physical	Nominal Value	Unit	Test Method
Density (Crystalline)	1.51	g/cm ³	ISO 1183
Spiral Flow			Internal Method
-- 1	9.00	cm	
-- 2	45.0	cm	
Molding Shrinkage ³			ISO 294-4
Across Flow	0.80	%	
Flow	0.30	%	
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)	11500	MPa	ISO 527-1
Tensile Stress			ISO 527-2
Break, 23°C	170	MPa	
Break, 125°C	95.0	MPa	
Break, 175°C	50.0	MPa	
Break, 275°C	30.0	MPa	
Tensile Strain (Break, 23°C)	2.9	%	ISO 527-2
Flexural Modulus (23°C)	10000	MPa	ISO 178
Flexural Stress			ISO 178
23°C	260	MPa	
125°C	170	MPa	
175°C	75.0	MPa	
275°C	45.0	MPa	
Compressive Stress			ISO 604
23°C	190	MPa	
120°C	120	MPa	
200°C	35.0	MPa	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	70.0	kJ/m ²	ISO 179/1U
Notched Izod Impact Strength (23°C)	12.0	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength (23°C)	65.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/Af
1.8 MPa, Unannealed	320	°C	

VICTREX™ PEEK POLYMER 650GL30

Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature			ISO 11357-2
Onset	143	°C	
Midpoint	150	°C	
Melting Temperature	343	°C	ISO 11357-3
CLTE - Flow			ISO 11359-2
< 143°C	18	ppm/K	
> 143°C	22	ppm/K	
CLTE - Average			ISO 11359-2
< 143°C	45	ppm/K	
> 143°C	120	ppm/K	
Thermal Conductivity			ISO 22007-4
23°C ⁴	0.30	W/m/K	
23°C ⁵	0.35	W/m/K	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+16	ohms-cm	IEC 60093
Dielectric Strength (2.00 mm)	20.0	kV/mm	IEC 60243-1
Dielectric Constant (23°C, 1 kHz)	3.50		IEC 60250
Dissipation Factor (23°C, 1 MHz)	4.0E-3		IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (420°C)	700	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
Hopper Temperature	< 100	°C
Rear Temperature	385	°C
Middle Temperature	390 to 395	°C
Front Temperature	400	°C
Nozzle Temperature	405	°C
Mold Temperature	180 to 200	°C

Injection Notes

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.

VICTREX™ PEEK POLYMER 650GL30

Notes

¹ Mold Temperature: 190°C, Melt Temperature: 405°C, 1.00 mm

² Mold Temperature: 190°C, Melt Temperature: 405°C, 3.00 mm

³ 405°C nozzle, 190°C tool

⁴ Average

⁵ Along flow

Revision Date: December 2023

This information is provided "as is". It is not intended to amount to advice. Use of the product is at the customer's/user's risk. It is the customer's/user's responsibility to thoroughly test the product in each specific application to determine its performance, efficacy and safety for each end-use product, device or other application and compliance with applicable laws, regulations and standards. Mention of a product is no guarantee of availability. Victrex reserves the right to modify products, data sheets, specifications and packaging. **Victrex makes no warranties, express or implied (including, without limitation, any warranty of fitness for a particular purpose or of intellectual property non-infringement) and will not be liable for any loss or damage of any nature (however arising) in connection with customer's/user's use or reliance on this information, except for any liability which cannot be excluded or limited by law.** This document may be modified or retracted at any time without notice to the customer/user.

Victrex Manufacturing Limited (or another member of the Victrex group) is the owner or the licensee of all intellectual property rights in and to this document including the following trademarks, VICTREX, INVIBIO, JUVORA, APTIV, 450G, PEEK-OPTIMA, SHAPING FUTURE PERFORMANCE, LMPAEK, TRIANGLE (Device). All rights are protected by intellectual property rights including copyright under relevant national and international intellectual property laws and treaties. All rights reserved. Copyright © Victrex Manufacturing Limited 2023.