

# VICTREX™ PEEK POLYMER 650PF

## General Information

### Product Description

High performance thermoplastic material, unreinforced PolyEtherEtherKetone (PEEK), semi crystalline, fine powder for compression moulding, low flow, colour natural.

## Material Properties

Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm <sup>3</sup>	ISO 1183
Apparent (Bulk) Density	0.30	g/cm <sup>3</sup>	ISO 1183
Average Particle Size - D50	75	µm	ISO 13320-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3900	MPa	ISO 527-1
Tensile Stress (Yield, 23°C)	90.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	30	%	ISO 527-2
Flexural Modulus (23°C)	3600	MPa	ISO 178
Flexural Stress (23°C)	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	7.5	kJ/m <sup>2</sup>	ISO 180/A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180
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
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (400°C)	500	Pa·s	ISO 11443
Additional Information	Nominal Value	Unit	
Compression Molding Temperature	380 to 400	°C	
Drying Temperature - Compression molding	120 to 150	°C	
Drying Time - Compression molding	3.0 to 5.0	hr	

## Typical Processing Information

### Injection Notes

Important notes:

- 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.
- 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](http://www.victrex.com) or upon request.

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