

VICTREX HT™ POLYMER 22GL30

General Information

Product Description

High performance thermoplastic material, 30% glass fibre reinforced PolyEtherKetone (PEK), semi crystalline, granules for injection moulding, standard flow, colour natural/beige.

Higher temperature applications where higher strength in a static system is required. 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)	1.53	g/cm ³	ISO 1183
Spiral Flow ¹	10.5	cm	Internal Method
Molding Shrinkage ²			ISO 294-4
Across Flow	0.90	%	
Flow	0.30	%	
Water Absorption (Saturation, 23°C)	0.50	%	ISO 62
Water Absorption Saturation (100°C)	0.60	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	12000	MPa	ISO 527-1
Tensile Stress			ISO 527-2
Break, 23°C	195	MPa	
Break, 125°C	125	MPa	
Break, 175°C	75.0	MPa	
Break, 225°C	65.0	MPa	
Break, 275°C	55.0	MPa	
Tensile Strain (Break, 23°C)	2.6	%	ISO 527-2
Flexural Modulus (23°C)	11000	MPa	ISO 178
Flexural Stress			ISO 178
23°C	290	MPa	
125°C	210	MPa	
175°C	120	MPa	
275°C	85.0	MPa	
Compressive Stress			ISO 604
23°C	290	MPa	
120°C	180	MPa	
200°C	75.0	MPa	
250°C	50.0	MPa	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	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)	8.8	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength (23°C)	70.0	kJ/m ²	ISO 180
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 23°C)	87.5		ISO 868

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	360	°C	ISO 75-2/Af
Glass Transition Temperature			ISO 11357-2
Onset	152	°C	
Midpoint	160	°C	
Melting Temperature	373	°C	ISO 11357-3
CLTE - Flow			ISO 11359-2
< 152°C	20	ppm/K	
> 152°C	25	ppm/K	
CLTE - Average			ISO 11359-2
< 152°C	45	ppm/K	
> 152°C	110	ppm/K	
Thermal Conductivity			ISO 22007-4
23°C ³	0.30	W/m/K	
23°C ⁴	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)	23.0	kV/mm	IEC 60243-1
Dielectric Constant (23°C, 1 kHz)	3.20		IEC 60250
Dissipation Factor (23°C, 1 MHz)	5.0E-3		IEC 60250
Comparative Tracking Index	150	V	IEC 60112
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)	450	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	190 to 215	°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

² 395°C nozzle, 200°C tool

³ Average

⁴ Along flow

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