VICTREX® PEEK 650CA30

Product Description:

High performance thermoplastic material, 30% carbon fibre reinforced **P**oly**E**ther**E**ther**K**etone (PEEK), semi crystalline, granules for injection moulding and extrusion, low flow, FDA food contact compliant, colour black.

Typical Application Areas:

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.

Material Properties

	CONDITIONS	TEST METHOD	UNITS	TYPICAL VALUE
Mechanical Data				
Tensile Strength	Break, 23°C	ISO 527	MPa	250
	Break, 125°C			150
	Break, 175°C			85
	Break, 275°C			50
Tensile Elongation	Break, 23°C	ISO 527	%	1.9
Tensile Modulus	23°C	ISO 527	GPa	25
Flexural Strength	23°C	ISO 178	MPa	370
	125°C			250
	175°C			120
	275°C			60
Flexural Modulus	23°C	ISO 178	GPa	21.5
Compressive Strength	23°C	ISO 604	MPa	280
	120°C			180
	200°C			60
Charpy Impact Strength	Notched , 23°C	ISO 179/1eA	kJ m^{-2}	10.5
	Unnotched, 23°C	ISO 179/1U		60
Izod Impact Strength	Notched, 23°C	ISO 180/A	kJ m^{-2}	12
	Unnotched, 23°C	ISO 180/U		60
Thermal Data				
Melting Point		ISO 11357	°C	343
Glass Transition (Tg)	Onset	ISO 11357	°C	143
	Midpoint			150
Coefficient of Thermal Expansion	Along flow below Tg	ISO 11359	ppm K^{-1}	6
	Average below Tg			50
	Along flow above Tg			6
	Average above Tg			135
Heat Deflection Temperature	1.8 MPa	ISO 75-f	°C	333
Thermal Conductivity	Along flow, 23°C	ISO 22007-4	W m^{-1} K^{-1}	2.0
	Average, 23°C			0.95
Flow				
Melt Viscosity	420°C	ISO 11443	Pa.s	800

Miscellaneous				
Density	Crystalline	ISO 1183	g cm^{-3}	1.40
Water Absorption by immersion	Saturation, 23°C	ISO 62-1	%	0.3 *
	Saturation, 100°C			0.45 *

Electrical Properties				
Volume Resistivity	23°C, 1V	ASTM D4496	Ω cm	10^5 *

* Result based on similar products

Typical Processing Conditions	
Drying Temperature / Time	150°C / 3h or 120°C / 5h
Temperature settings	390 / 400 / 405 / 410 / 415°C (Nozzle)
Hopper Temperature	Not greater than 100°C
Mould Temperature	180°C - 210°C (max 250°C)
Runner	Die / nozzle >3mm, manifold >3.5mm
Gate	>2mm or 0.5 x part thickness

Mould Shrinkage and Spiral Flow					
Spiral Flow	415°C nozzle, 200°C tool	1mm thick section	Victrex	mm	80
		3mm thick section			375
Mould Shrinkage	415°C nozzle, 200°C tool	Along flow	ISO 294-4	%	0.1
		Across flow			0.5

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

World Headquarters
Victrex plc, Hillhouse International, Thornton Cleveleys, Lancashire FY5 4QD United Kingdom
Tel: + (44) 1253 897700 Fax: + (44) 1253 897701 Email: victrexplc@victrex.com

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