

VICTREX® HT™ G45

➤ Product Description:

High performance thermoplastic material, unreinforced PolyEtherKetone (PEK), semi crystalline, depth filtered granules for injection moulding, low flow, FDA food contact compliant, colour natural/beige.

➤ Typical Application Areas:

Applications for high strength and stiffness as well as good ductility at higher temperatures. Chemically resistant to aggressive environments, suitable for sterilisation for medical and food contact applications.

➤ Material Properties

	CONDITIONS	TEST METHOD	UNITS	TYPICAL VALUE
Mechanical Data				
Tensile Strength	Yield, 23°C	ISO 527	MPa	110
Tensile Elongation	Break, 23°C	ISO 527	%	35
Tensile Modulus	23°C	ISO 527	GPa	4.2
Flexural Strength	At 3.5% strain, 23°C	ISO 178	MPa	130
	At yield, 23°C			180
	125°C			105 *
	175°C			32 *
	275°C			16 *
Flexural Modulus	23°C	ISO 178	GPa	4.2
Compressive Strength	23°C	ISO 604	MPa	140 *
	120°C			90 *
	200°C			30 *
Izod Impact Strength	Notched, 23°C	ISO 180/A	kJ m ⁻²	7.0
	Unnotched, 23°C	ISO 180/U		n/b
Thermal Data				
Melting Point		ISO 11357	°C	373
Glass Transition (Tg)	Onset	ISO 11357	°C	152
	Midpoint			160
Specific Heat Capacity	23°C	DSC	kJ kg ⁻¹ °C ⁻¹	2.2
Coefficient of Thermal Expansion	Along flow below Tg	ISO 11359	ppm K ⁻¹	45 *
	Average below Tg			55 *
	Along flow above Tg			75 *
	Average above Tg			130 *
Heat Deflection Temperature	1.8 MPa	ISO 75-f	°C	163 *
Thermal Conductivity	Along flow, 23°C	ISO 22007-4	W m ⁻¹ K ⁻¹	0.32
	Average, 23°C			0.29
Flow				
Melt Viscosity	400°C	ISO 11443	Pa.s	350
Miscellaneous				
Density	Crystalline	ISO 1183	g cm ⁻³	1.30
Shore D hardness	23°C	ISO 868		85.5
Water Absorption by immersion	Saturation, 23°C	ISO 62-1	%	0.6 *
	Saturation, 100°C			0.75 *

Electrical Properties				
Dielectric Strength	2mm thickness	IEC 60243-1	kV mm ⁻¹	23 *
Comparative Tracking Index		IEC 60112	V	150 *
Volume Resistivity	23°C	IEC 60093	Ω cm	10 ¹⁶ *
	125°C			10 ¹⁵ *
	275°C			10 ⁹ *
Fire Smoke Toxicity				
Glow Wire Test	2mm thickness	IEC 60695-2-12	°C	960 *
Limiting Oxygen Index	0.4mm thickness	ISO 4589	% O ₂	24 *
	3.2mm thickness			35 *
Toxicity Index	CO content	NES 713	n/a	0.074 *
	CO ₂ content			0.15 *
	Total gases			0.22 *

* Result based on similar products

Typical Processing Conditions	
Drying Temperature / Time	150°C / 3h or 120°C / 5h (residual moisture <0.02%)
Temperature settings	390 / 395 / 405 / 410 / 415°C (Nozzle)
Hopper Temperature	Not greater than 100°C
Mould Temperature	200°C - 220°C
Runner	Die / nozzle >3mm, manifold >3.5mm
Gate	>1mm or 0.5 x part thickness

Mould Shrinkage and Spiral Flow					
Spiral Flow	415°C nozzle, 220°C tool	1mm thick section	Victrex	mm	190
Mould Shrinkage	415°C nozzle, 220°C tool	Along flow	ISO 294-4	%	1.0
		Across flow			1.2

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 or upon request

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