

# DynaMix™ 3204-HF

Polyetheretherketone

Polymer Dynamix

Message:

- Modified PEEK
- Features:
  - Excellent Chemical Resistance
  - Low Temperature Impact Resistance
  - Good Dimensional Stability
- Applications:
  - Automotive
  - Industrial
  - Military
  - Aerospace

General Information			
Features	Good Chemical Resistance		
	Good Dimensional Stability		
	Low Temperature Impact Resistance		
Uses	Aerospace Applications		
	Automotive Applications		
	Industrial Applications		
	Military Applications		
Processing Method	Injection Molding		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	79.3	MPa	
Break	80.0	MPa	
Tensile Elongation			ASTM D638
Yield	5.0 to 6.0	%	
Break	20 to 30	%	
Flexural Modulus	3450	MPa	ASTM D790
Flexural Strength	138	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	91	J/m	ASTM D256
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	332 to 360	°C	
Middle Temperature	338 to 366	°C	
Front Temperature	343 to 377	°C	

Nozzle Temperature	343 to 377	°C
Processing (Melt) Temp	343 to 377	°C
Mold Temperature	177 to 204	°C
Injection Rate	Moderate	
Screw Speed	40 to 70	rpm
Clamp Tonnage	4.1 to 6.9	kN/cm <sup>2</sup>

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