

# HiFill® PEEK 4500 BK

Polyetheretherketone  
Techmer Engineered Solutions

Message:

HiFill® PEEK 4500 BK is a Polyetheretherketone (PEEK) product. It can be processed by injection molding and is available in North America. Primary characteristic: high viscosity.

General Information			
Features	High Viscosity		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.6	%	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	96.5	MPa	ASTM D638
Tensile Elongation (Yield)	50	%	ASTM D638
Flexural Modulus	4100	MPa	ASTM D790
Flexural Strength	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	320	°C	ASTM D648
CLTE - Flow	4.7E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	12	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	249	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	360 to 388	°C	
Middle Temperature	360 to 388	°C	
Front Temperature	360 to 388	°C	
Processing (Melt) Temp	360 to 382	°C	
Mold Temperature	177 to 218	°C	
Back Pressure	0.345 to 0.689	MPa	

Screw Speed	50 to 100	rpm
NOTE		

1.	Method A (Short-Time)
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Recommended distributors for this material


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