

Pyramid™ KK2219

Polyaryletherketone

Polymics, Ltd.

Message:

Polyaryletherketone, Wear Grade, with Tg of 320 °F (160 °C)

General Information			
Filler / Reinforcement	Carbon\Graphite\PTFE,30% Filler by Weight		
Appearance	Black		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Molding Shrinkage - Flow	2.0	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	101		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10000	MPa	ASTM D638
Tensile Strength	145	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	9500	MPa	ASTM D790
Flexural Strength	234	MPa	ASTM D790
Poisson's Ratio	0.45		
Coefficient of Friction			ASTM D1894
Dynamic	0.11		
Static	0.11		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.318 mm)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	300	°C	ASTM D648
Glass Transition Temperature	182	°C	ASTM E1356
Melting Temperature	350	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+7	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	180	°C	
Drying Time	4.0	hr	
Rear Temperature	380	°C	
Middle Temperature	380	°C	

Front Temperature	380	°C
Nozzle Temperature	380	°C
Mold Temperature	200 to 210	°C
Injection Rate	Fast	
Screw Compression Ratio	2.5:1.0 to 3.5:1.0	

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