

VICTREX® HT™ 22CA30

Polyether Ketone

Victrex plc

Message:

High performance thermoplastic material, 30% carbon fibre reinforced PolyEtherKetone (PEK), semi crystalline, granules for injection moulding, standard flow, colour black.

Higher temperature 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.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Features	Semicrystallization		
	Low friction coefficient		
	Rigidity, high		
	High strength		
	Good liquidity		
	Good chemical resistance		
	Good wear resistance		
	Compliance of Food Exposure		
Uses	High temperature application		
Appearance	Black		
Forms	Particles		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm³	ISO 1183
Spiral Flow	8.00	cm	Internal method
Molding Shrinkage ¹			ISO 294-4
Vertical flow direction: 200°C	0.70	%	ISO 294-4
Flow direction: 200°C	0.10	%	ISO 294-4
Water Absorption			ISO 62
23°C, 24 hr, 3.20 mm	0.050	%	ISO 62
Balance, 23°C, 3.20mm, 50% RH	0.50	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 23°C)	88		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	26000	MPa	ISO 527-2
Tensile Stress			ISO 527-2
Fracture, 23°C	260	MPa	ISO 527-2
Fracture, 125°C	170	MPa	ISO 527-2
Fracture, 175°C	110	MPa	ISO 527-2

Fracture, 225°C	80.0	MPa	ISO 527-2
Fracture, 275°C	70.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	1.6	%	ISO 527-2
Flexural Modulus (23°C)	23000	MPa	ISO 178
Flexural Stress			ISO 178
23°C	370	MPa	ISO 178
125°C	240	MPa	ISO 178
175°C	170	MPa	ISO 178
275°C	90.0	MPa	ISO 178
Compressive Stress			ISO 604
23°C	300	MPa	ISO 604
120°C	210	MPa	ISO 604
200°C	95.0	MPa	ISO 604
250°C	65.0	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	kJ/m ²	ISO 179/1U
Notched Izod Impact (23°C)	8.5	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength (23°C)	45	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	368	°C	ISO 75-2/A
Glass Transition Temperature	152	°C	ISO 11357-2
Melting Temperature	373	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow: > 152°C	5.0E-5	cm/cm/°C	ISO 11359-2
Flow: < 152°C	5.0E-5	cm/cm/°C	ISO 11359-2
Lateral: < 152°C	3.5E-4	cm/cm/°C	ISO 11359-2
Lateral: > 152°C	9.0E-4	cm/cm/°C	ISO 11359-2
Thermal Conductivity (23°C)	0.95	W/m/K	ISO 22007-4
Specific Heat Capacity (23°C)	1800	J/kg/°C	DSC
Toxicity			NES 713
CO content	0.0500		NES 713
CO2 content	0.120		NES 713
Total gases	0.170		NES 713
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity ² (23°C)	1.0E+5	ohms · cm	ASTM D4496
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (2.00 mm)	960	°C	IEC 60695-2-12
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (400°C)	550	Pa · s	ISO 11443
Injection	Nominal Value	Unit	

Drying Temperature	120 - 150	°C
Drying Time	3.0 - 5.0	hr
Hopper Temperature	< 100	°C
Rear Temperature	380	°C
Middle Temperature	390 - 395	°C
Front Temperature	400	°C
Nozzle Temperature	405	°C
Mold Temperature	190 - 215	°C

Injection instructions

Runner: Die / nozzle >3mm, manifold >3.5mmGate: >2mm or 0.5 x part thickness

NOTE

1. 405°C nozzle
2. 1V

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