

# Edgetek™ PK-30GF/000 EM BK

Polyetheretherketone

PolyOne Corporation

## Message:

Edgetek®The engineering thermoplastic polymer product portfolio includes a series of standard and customizable high-performance materials. The combination includes high-temperature resistant materials for high-temperature working environments, and high-modulus/structural materials for load-bearing, high-strength applications and flame-retardant products. These polymers are made by mixing engineering thermoplastic resins with different reinforcing additives, such as carbon fiber, glass fiber and glass beads.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Heat resistance, high		
	General		
Uses	Industrial application		
	Application in Automobile Field		
	General		
	Consumer goods application field		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (400°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>1</sup>	12000	MPa	ASTM D638
Tensile Strength <sup>2</sup> (Yield)	180	MPa	ASTM D638
Tensile Elongation <sup>3</sup> (Break)	3.0 - 4.0	%	ASTM D638
Flexural Modulus	11000	MPa	ASTM D790
Flexural Strength	280	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm, Injection Molded)	110	J/m	ASTM D256A
Unnotched Izod Impact (23°C, 3.18 mm)	950	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	325	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	150 - 160	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	360 - 390	°C	
Mold Temperature	170 - 190	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	Type 1, 5.1 mm/min		
2.	Type 1, 5.1 mm/min		
3.	Type 1, 5.1 mm/min		

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