

VICTREX® PEEK 650CA30

Polyetheretherketone

Victrex plc

Message:

High performance thermoplastic material, 30% carbon fibre reinforced PolyEtherEtherKetone (PEEK), semi crystalline, granules for injection moulding and extrusion, low flow, FDA food contact compliant, colour black.

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			
UL YellowCard	E161131-101136381		
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Features	Semicrystallization		
	Low friction coefficient		
	Rigidity, high		
	High strength		
	Low liquidity		
	Good chemical resistance		
	Good wear resistance		
	Compliance of Food Exposure		
Agency Ratings	FDA Food Exposure, Not Rated		
Appearance	Black		
Forms	Particles		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density ¹	1.40	g/cm³	ISO 1183
Spiral Flow ²			Internal method
-- ³	8.00	cm	Internal method
-- ⁴	37.5	cm	Internal method
Molding Shrinkage ⁵			ISO 294-4
Vertical flow direction	0.50	%	ISO 294-4
Flow direction	0.10	%	ISO 294-4
Water Absorption			ISO 62
23°C, 24 hr, 3.20 mm	0.040	%	ISO 62
Equilibrium, 23°C, 50% RH	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	27000	MPa	ISO 527-2
Tensile Stress			ISO 527-2

Fracture, 23°C	250	MPa	ISO 527-2
Fracture, 125°C	150	MPa	ISO 527-2
Fracture, 175°C	85.0	MPa	ISO 527-2
Fracture, 275°C	50.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.2	%	ISO 527-2
Flexural Modulus (23°C)	23000	MPa	ISO 178
Flexural Stress			ISO 178
23°C	370	MPa	ISO 178
125°C	250	MPa	ISO 178
175°C	120	MPa	ISO 178
275°C	60.0	MPa	ISO 178
Compressive Stress			ISO 604
23°C	280	MPa	ISO 604
120°C	180	MPa	ISO 604
200°C	60.0	MPa	ISO 604
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	60	kJ/m ²	ISO 179/1U
Notched Izod Impact (23°C)	12	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength (23°C)	60	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	333	°C	ISO 75-2/Af
Glass Transition Temperature	143	°C	ISO 11357-2
Melting Temperature	343	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow: > 143°C	6.0E-6	cm/cm/°C	ISO 11359-2
Flow: < 143°C	6.0E-6	cm/cm/°C	ISO 11359-2
Lateral: < 143°C	5.0E-5	cm/cm/°C	ISO 11359-2
Lateral: > 143°C	1.4E-4	cm/cm/°C	ISO 11359-2
Specific Heat (23°C)	1800	J/kg/°C	DSC
Thermal Conductivity (23°C)	0.95	W/m/K	ISO 22007-4
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity ⁶ (23°C)	1.0E+5	ohms · cm	IEC 60093
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (420°C)	775	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	390	°C	
Middle Temperature	405	°C	

Front Temperature	410	°C
Nozzle Temperature	415	°C
Mold Temperature	180 - 210	°C

Injection instructions

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

NOTE

1.	Crystalline
2.	Mold temperature: 200°C, melt temperature: 415°C
3.	1 mm
4.	3 mm
5.	415°C nozzle, 200°C tool
6.	1V

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