

VICTREX® PEEK 450FC30

➤ Product Description:

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

➤ Typical Application Areas:

Tribological applications for high strength. Excellent wear resistance, very low coefficient of friction, low coefficient of thermal expansion. Chemically resistant to aggressive environments.

➤ Material Properties

	CONDITIONS	TEST METHOD	UNITS	TYPICAL VALUE
Mechanical Data				
Tensile Strength	Break, 23°C	ISO 527	MPa	150
	Break, 125°C			95
	Break, 175°C			55
	Break, 225°C			45
	Break, 275°C			35
Tensile Elongation	Break, 23°C	ISO 527	%	2.3
Tensile Modulus	23°C	ISO 527	GPa	13
Flexural Strength	23°C	ISO 178	MPa	230
	125°C			160
	175°C			80
	275°C			45
Flexural Modulus	23°C	ISO 178	GPa	11.5
Compressive Strength	23°C	ISO 604	MPa	170
	120°C			110
	200°C			45
Charpy Impact Strength	Notched, 23°C	ISO 179/1eA	kJ m ⁻²	5.0
	Unnotched, 23°C	ISO 179/1U		35
Izod Impact Strength	Notched, 23°C	ISO 180/A	kJ m ⁻²	7.0
	Unnotched, 23°C	ISO 180/U		35
Thermal Data				
Melting Point		ISO 11357	°C	343
Glass Transition (Tg)	Onset	ISO 11357	°C	143
	Midpoint			150
Coefficient of Thermal Expansion	Along flow below Tg	ISO 11359	ppm K ⁻¹	15
	Average below Tg			45
	Along flow above Tg			20
	Average above Tg			115
Heat Deflection Temperature	1.8 MPa	ISO 75-f	°C	315
Thermal Conductivity	Along flow, 23°C	ISO 22007-4	W m ⁻¹ K ⁻¹	1.7
	Average, 23°C			0.85
Relative Thermal Index	Mechanical w/o impact	UL 746B	°C	240
	Mechanical w/impact			180

Flow				
Melt Viscosity	400°C	ISO 11443	Pa.s	550
Miscellaneous				
Density	Crystalline	ISO 1183	g cm ⁻³	1.45
Shore D hardness	23°C	ISO 868		83
Water Absorption by immersion	Saturation, 23°C	ISO 62-1	%	0.35
	Saturation, 100°C			0.45
Electrical Properties				
Volume Resistivity	23°C, 1V	IEC 60093	Ω cm	10 ¹⁰
Fire Smoke Toxicity				
Glow Wire Test	2mm thickness	IEC 60695-2-12	°C	960
Limiting Oxygen Index		ISO 4289	%O ₂	43

Typical Processing Conditions	
Drying Temperature / Time	150°C / 3h or 120°C / 5h (residual moisture <0.02%)
Temperature settings	365 / 370 / 375 / 380 / 385°C (Nozzle)
Hopper Temperature	Not greater than 100°C
Mould Temperature	170°C - 200°C
Runner	Die / nozzle >3mm, manifold >3.5mm
Gate	>2mm or 0.5 x part thickness

Mould Shrinkage and Spiral Flow					
Spiral Flow	385°C nozzle, 200°C tool	1mm thick section	Victrex	mm	80
		3mm thick section			380
Mould Shrinkage	385°C nozzle, 200°C tool	Along flow	ISO 294-4	%	0.3
		Across flow			0.7

Important notes:

- Processing conditions quoted in our datasheets are typical of those used in our processing laboratories
Data for mould shrinkage should be used for material comparison. Actual mould shrinkage values are highly dependent on part geometry, mould configuration, and processing conditions.
Mould shrinkage differs for along flow and across flow directions. "Along flow" direction is taken as the direction the molten material is travelling when it exits the gate and enters the mould.
Mould shrinkage is expressed as a percent change in dimension of a specimen in relation to mould dimensions.
- Data are generated in accordance with prevailing national, international and internal standards, and should be used for material comparison. Actual property values are highly dependent on part geometry, mould configuration and processing conditions. Properties may also differ for along flow and across flow directions

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