

## VICTREX® PEEK 450FE20

### ➤ Product Description:

High performance thermoplastic material, 20% filled with PTFE PolyEtherEtherKetone (PEEK), semi crystalline, granules for injection moulding and extrusion, standard flow, FDA food contact compliant, colour natural / beige

### ➤ Typical Application Areas:

Tribological applications. Excellent wear resistance, very low coefficient of friction. Chemically resistant to aggressive environments.

### ➤ Material Properties

	CONDITIONS	TEST METHOD	UNITS	TYPICAL VALUE
<b>Mechanical Data</b>				
Tensile Strength	Yield, 23°C	ISO 527	MPa	78
Tensile Elongation	Break, 23°C	ISO 527	%	25
Tensile Modulus	23°C	ISO 527	GPa	3.2
Flexural Strength	At 3.5% strain, 23°C	ISO 178	MPa	100
	At yield, 23°C			125
	125°C			70
	175°C			18
	275°C			13
Flexural Modulus	23°C	ISO 178	GPa	3.2
Compressive Strength	23°C	ISO 604	MPa	105
	120°C			65
Charpy Impact Strength	Notched, 23°C	ISO 179/1eA	kJ m <sup>-2</sup>	6.0
	Unnotched, 23°C	ISO 179/U		n/b
Izod Impact Strength	Notched, 23°C	ISO 180/A	kJ m <sup>-2</sup>	8.0
	Unnotched, 23°C	ISO 180/U		n/b
<b>Thermal Data</b>				
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 <sup>-1</sup>	40
	Average below Tg			60
	Along flow above Tg			120
	Average above Tg			140
Heat Deflection Temperature	1.8 MPa	ISO 75-f	°C	150
<b>Flow</b>				
Melt Viscosity	400°C	ISO 11443	Pa.s	350
<b>Miscellaneous</b>				
Density	Crystalline	ISO 1183	g cm <sup>-3</sup>	1.40
Shore D hardness	23°C	ISO 868		81

Electrical Properties				
Dielectric Strength	2mm thickness	IEC 60243-1	kV mm <sup>-1</sup>	26
Comparative Tracking Index		IEC 60112	V	150
Loss Tangent	23°C, 1 MHz	IEC 60250	n/a	0.004
Dielectric Constant	23°C, 1 kHz	IEC 60250	n/a	2.8
Volume Resistivity	23°C	IEC 60093	Ω cm	10 <sup>16</sup>

Typical Processing Conditions	
Drying Temperature / Time	150°C / 3h or 120°C / 5h (residual moisture <0.02%)
Temperature settings	355 / 360 / 365 / 370 / 375°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	375°C nozzle, 180°C tool	1mm thick section	Victrex	mm	130
Mould Shrinkage	375°C nozzle, 180°C tool	Along flow	ISO 294-4	%	1.2
		Across flow			1.7

#### 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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