

## VICTREX® PEEK 450GL30

### ➤ Product Description:

High performance thermoplastic material, 30% glass fibre reinforced PolyEtherEtherKetone (PEEK), semi crystalline, granules for injection moulding and extrusion, standard flow, FDA food contact compliant, colour natural/beige.

### ➤ Typical Application Areas:

Applications for higher strength in a static system. Low coefficient of thermal expansion. Chemically resistant to aggressive environments, suitable for sterilization for medical and food contact applications.

### ➤ Material Properties

	CONDITIONS	TEST METHOD	UNITS	TYPICAL VALUE
<b>Mechanical Data</b>				
Tensile Strength	Break, 23°C	ISO 527	MPa	180
	Break, 125°C			115
	Break, 175°C			60
	Break, 275°C			35
Tensile Elongation	Break, 23°C	ISO 527	%	2.7
Tensile Modulus	23°C	ISO 527	GPa	11.8
Flexural Strength	23°C	ISO 178	MPa	270
	125°C			190
	175°C			80
	275°C			50
Flexural Modulus	23°C	ISO 178	GPa	11.3
Compressive Strength	23°C	ISO 604	MPa	250
	120°C			160
	200°C			55
Charpy Impact Strength	Notched, 23°C	ISO 179/1eA	kJ m <sup>-2</sup>	8.0
	Unnotched, 23°C	ISO 179/1U		55
Izod Impact Strength	Notched, 23°C	ISO 180/A	kJ m <sup>-2</sup>	10
	Unnotched, 23°C	ISO 180/U		60
<b>Thermal Data</b>				
Melting Point		ISO 11357	°C	343
Glass Transition (Tg)	Onset	ISO 11357	°C	143
Specific Heat Capacity	23°C	DSC	kJ kg <sup>-1</sup> °C <sup>-1</sup>	1.7
Coefficient of Thermal Expansion	Along flow below Tg	ISO 11359	ppm K <sup>-1</sup>	18
	Average below Tg			45
	Along flow above Tg			18
	Average above Tg			110
Heat Deflection Temperature	1.8 MPa	ISO 75-f	°C	328
Thermal Conductivity	23°C	ISO 22007-4	W m <sup>-1</sup> K <sup>-1</sup>	0.30
Relative Thermal Index	Electrical	UL 746B	°C	240
	Mechanical w/o impact			240
	Mechanical w/impact			220
<b>Flow</b>				
Melt Viscosity	400°C	ISO 11443	Pa.s	560

Miscellaneous				
Density	Crystalline	ISO 1183	$\text{g cm}^{-3}$	1.51
Shore D hardness	23°C	ISO 868		87.5
Water Absorption (3.2mm thick Tensile bar)	24h, 23°C	ISO 62-1	%	0.04
(by immersion)	Equilibrium, 23°C			0.3

Electrical Properties				
Dielectric Strength	2.5mm thickness	IEC 60243-1	$\text{kV mm}^{-1}$	20
Loss Tangent	23°C, 1 MHz	IEC 60250	n/a	0.005
Dielectric Constant	23°C, 1 kHz	IEC 60250	n/a	3.2
Volume Resistivity		IEC 60093	$\Omega \text{ cm}$	$10^{16}$

Fire Smoke Toxicity				
Glow Wire Test	2mm thickness	IEC 60695-2-12	°C	960

Recommended Processing Conditions	
Drying Temperature / Time	150°C / 3h or 120°C / 5h
Temperature settings	360 / 370 / 375 / 380 / 385°C (Nozzle)
Hopper Temperature	Not greater than 100°C
Mould Temperature	180°C - 200°C (max 250°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, 190°C tool	1mm thick section	Victrex	mm	85
		3mm thick section			410
Mould Shrinkage*	385°C nozzle, 190°C tool	Along flow	ISO 294-4	%	0.3
		Across flow			0.9

#### Important note:

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

Detailed data available on our website [www.victrex.com](http://www.victrex.com) or upon request

#### World Headquarters

Victrex plc, Hillhouse International, Thornton Cleveleys, Lancashire FY5 4QD United Kingdom  
Tel: + (44) 1253 897700 Fax: + (44) 1253 897701 Email: [victrexplc@victrex.com](mailto:victrexplc@victrex.com)

VICTREX PLC BELIEVES THAT THE INFORMATION CONTAINED IN THIS BROCHURE IS AN ACCURATE DESCRIPTION OF THE TYPICAL CHARACTERISTICS AND/OR USES OF THE PRODUCT OR PRODUCTS, BUT IT IS THE CUSTOMER'S RESPONSIBILITY TO THOROUGHLY TEST THE PRODUCT IN EACH SPECIFIC APPLICATION TO DETERMINE ITS PERFORMANCE, EFFICACY AND SAFETY FOR EACH END-USE PRODUCT, DEVICE OR OTHER APPLICATION. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ANY PARTICULAR PATENT. THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. MENTION OF A PRODUCT IN THIS DOCUMENTATION IS NOT A GUARANTEE OF AVAILABILITY. VICTREX PLC RESERVES THE RIGHT TO MODIFY PRODUCTS, SPECIFICATIONS AND/OR PACKAGING AS PART OF A CONTINUOUS PROGRAM OF PRODUCT DEVELOPMENT. VICTREX® IS A REGISTERED TRADEMARK OF VICTREX MANUFACTURING LIMITED. VICTREX PIPES™ IS A TRADEMARK OF VICTREX MANUFACTURING LIMITED. PEEK-ESD™, HT™, ST™ AND WG™ ARE TRADEMARKS OF VICTREX PLC. VICOTE® AND APTIV® ARE REGISTERED TRADEMARKS OF VICTREX PLC.

VICTREX PLC MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, A WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR OF INTELLECTUAL PROPERTY NON-INFRINGEMENT, INCLUDING, BUT NOT LIMITED TO PATENT NON-INFRINGEMENT, WHICH ARE EXPRESSLY DISCLAIMED, WHETHER EXPRESS OR IMPLIED, IN FACT OR BY LAW. FURTHER, VICTREX PLC MAKES NO WARRANTY TO YOUR CUSTOMERS OR AGENTS, AND HAS NOT AUTHORIZED ANYONE TO MAKE ANY REPRESENTATION OR WARRANTY OTHER THAN AS PROVIDED ABOVE. VICTREX PLC SHALL IN NO EVENT BE LIABLE FOR ANY GENERAL, INDIRECT, SPECIAL, CONSEQUENTIAL, PUNITIVE, INCIDENTAL OR SIMILAR DAMAGES, INCLUDING WITHOUT LIMITATION, DAMAGES FOR HARM TO BUSINESS, LOST PROFITS OR LOST SAVINGS, EVEN IF VICTREX HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES, REGARDLESS OF THE FORM OF ACTION.

