

Plaslube® PEEK CF10 TL10 HF LE

Polyetheretherketone

Techmer Engineered Solutions

Message:

Plaslube® PEEK CF10 TL10 HF LE is a Polyetheretherketone (PEEK) product filled with glass\carbon fiber. It can be processed by injection molding and is available in North America. Primary characteristic: lubricated.

General Information			
Filler / Reinforcement	Glass\Carbon Fiber		
Additive	Lubricant		
Features	Lubricated		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.0	%	ASTM D955
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	179	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	10300	MPa	ASTM D790
Flexural Strength	276	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.22		
vs. Steel - Static	0.19		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	288	°C	
1.8 MPa, Unannealed	288	°C	
CLTE - Flow	1.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+4 to 1.0E+6	ohms · cm	ASTM D257
Additional Information	Nominal Value	Unit	Test Method
Limiting Pressure Velocity			ASTM D3702
10 fpm	40000	psi · fpm	
100 fpm	45000	psi · fpm	

1000 fpm	28000	psi · fpm
Injection	Nominal Value	Unit
Drying Temperature	249	°C
Drying Time	2.0 to 4.0	hr
Rear Temperature	360 to 388	°C
Middle Temperature	360 to 388	°C
Front Temperature	360 to 388	°C
Processing (Melt) Temp	360 to 382	°C
Mold Temperature	177 to 218	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	50 to 100	rpm

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