

Witcom PEEK 2007/020

Polyetheretherketone

Witcom Engineering Plastics B.V.

Message:

Article code KTA2007/351

General Information			
Additive	Lubricant		
Features	Good formability		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.80 - 1.2	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	0.40	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	90.0	MPa	ISO 527-2
Tensile Strain (Break)	1.5 - 3.0	%	ISO 527-2
Flexural Modulus	7500	MPa	ISO 178
Flexural Stress	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	3.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	155	°C	ISO 75-2/A
RTI Imp (3.00 mm)	180	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	V-0		ISO 1210
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	150 - 180	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Processing (Melt) Temp	380 - 410	°C	
Mold Temperature	160 - 200	°C	
Injection Rate	Fast		

Back Pressure	0.250 - 1.00	MPa
Injection instructions		

Screw speed: 0.1 - 0.2 m/sInjection pressure: Keep to a minimumHold pressure: Keep to a minimum

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