

Edgetek™ PK-30GF/000 NC

Polyetheretherketone

PolyOne Corporation

Message:

30 % Glass Fiber Reinforced PEEK Compound with Standard Flowability

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (400°C/2.16 kg)	3.0	g/10 min	ISO 1133
Molding Shrinkage (3.00 mm)	0.20 - 0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	180	MPa	ASTM D638
Tensile Elongation (Break)	3.0 - 4.0	%	ASTM D638
Flexural Modulus ²	11000	MPa	ASTM D790
Flexural Strength ³	270	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	320	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	150 - 160	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	350 - 390	°C	
Middle Temperature	350 - 390	°C	
Front Temperature	350 - 390	°C	
Mold Temperature	170 - 190	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		

2.	1.3 mm/min
3.	1.3 mm/min

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