Edgetek™ PK-30GF/000 FCR NC

Polyetheretherketone

Key Characteristics

Product Description	
30 % Glass Fiber Reinforced PEEK Compound with Ultra High Flowability	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.48	1.48	ASTM D792
Melt Mass-Flow Rate (MFR) (400°C/2.16 kg)	11 g/10 min	11 g/10 min	ISO 1133
Molding Shrinkage (0.118 in (3.00 mm))	0.20 to 0.50 %	0.20 to 0.50 %	ISO 294-4
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2]	27600 psi	190 MPa	ASTM D638
Tensile Elongation (Break)	3.0 to 4.0 %	3.0 to 4.0 %	ASTM D638
Flexural Modulus [3]	1.60E+6 psi	11000 MPa	ASTM D790
Flexural Strength [3]	42100 psi	290 MPa	ASTM D790
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	1.9 ft·lb/in	100 J/m	
Unnotched Izod Impact			ASTM D4812
73°F (23°C), 0.126 in (3.20 mm)	18 ft·lb/in	950 J/m	
Thermal	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	608 °F	320 °C	
Electrical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating (0.06 in (1.6 mm))	V-0	V-0	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	302 to 320 °F	150 to 160 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	662 to 734 °F	350 to 390 °C
Middle Temperature	662 to 734 °F	350 to 390 °C
Front Temperature	662 to 734 °F	350 to 390 °C
Mold Temperature	338 to 374 °F	170 to 190 °C

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Injection Notes
Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

Notes

[1] Typical values are not to be construed as specifications.

[2] 0.20 in/min (5.0 mm/min)

[3] 0.051 in/min (1.3 mm/min)

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