# Technical data
# KEBAPEAK PEEK XS2800

KEBAPEAK XS 2800 is an unreinforced, high-viscosity PEEK grade that is filtered to achieve particularly high purity. In addition to injection molding applications with high purity requirements, the material is particularly suitable for thin-walled extrusion applications, such as cable sheathing.

**Polymer:** PEEK

**ISO designation:** PEEK

**Productgroup:** PEEK, PEKK

**Brief description of the product family:**

KEBAPEAK is the trade name for a group of high-performance compounds based on polyaryletherketones (PEEK, PEK and PEKK). KEBAPEAK products exhibit exceptionally high thermal resistance, extremely good chemical resistance, and excellent sliding and wear characteristics. They are inherently flame retardant and are particularly suitable for aerospace applications due to very low smoke toxicity.

**Properties:**

dimensionally stable, good chemical resistance, good gliding properties, good aging behavior, good fire behavior, High wear resistance, Very high continuous used temperature, semi-crystalline, PFAS-free

**Typical areas of application:**

Fasteners, Housing, Cable and wire extrusion

**Industries:**

Automotive, Electrical and electronics industry, Household appliances, Aviation Industry, Mechanical Engineering, Medical Technology

## Physical properties

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|---|---|
| Water absorption in % \| in Anlehnung an ISO 62 | 0.3 |
| Humidity absorption 23°C/50% r.h. in %. \| in Anlehnung an ISO 62 | 0.07 |
| Density in kg/m³ \| ISO 1183-1 | 1300 |

## Mechanical properties

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|---|---|
| Tensile modulus in MPa \| ISO 527-1 | 3500 |
| Stress at break in MPa \| ISO 527-1 | N.B. |
| Strain at break in % \| ISO 527-1 | 40 |
| Impact strength (Charpy) at 23°C in kJ/m² \| ISO 179-1eU | 100 |
| Notched impact strength (Charpy) at 23°C in kJ/m² \| ISO 179-1eA | 6 |
| Shore D hardness \| DIN ISO 7619-1 | 85 |

## Rheological properties

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|---|---|
| Molding shrinkage in flow direction in % \| ISO 294-4 | 1.0 |
| Molding shrinkage transverse to the flow direction in % \| ISO 294-4 | 1.3 |

## Thermal properties

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|---|---|
| Melting temperature (DSC, 10°C/min) in °C \| ISO 11357-1/-3 | 343 |
| Maximum service temperature long term in °C \| ISO 2578 | 240 |
| Temp. of deflection under load, 1.80 MPa in °C \| ISO 75-1/-2 | 152 |
| Coeff. of linear therm. expansion in flow direction in E-6/K \| ISO 11359-1/-2 | 45 |
| Thermal conductivity in plane in W/mK \| DIN EN 821 | 0.3 |
| Thermal conductivity through plane in W/mK \| DIN EN 821 | 0.3 |
| Burning behavior at thickness 0.8 mm \| IEC 60695-11-10 | V0 |
| Glass transition temperature in °C \| DIN EN ISO 11357-1 | 143 |

## Electrical properties

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|---|---|
| Volume resistivity in Ohm*m \| IEC 60093 | 1e+14 |
| Electric strength in kV/mm \| IEC 60243-1 | 23 |
| Comparative tracking index (CTI) in V \| IEC 60112 | 150 |

**Processing instructions:**

**Pre-drying:**

Dryer type: dry air dryer.
Temperature: 150 – 160°C
Drying time: 2 – 4 h
Residual moisture: < 0.02%.

**Temperatures:**

Melt temperature: 365 – 400°C
Mold temperature: 170 – 200°C
Feed In: 60-80°C

**Injection molding machine equipment:**

Wear- and corrosion-protected injection units have proven their worth when processing KEBAPEAK. Nitrided screws and barrels should be avoided, since under unfavorable conditions the nitrided layer may flake off. Barrel heating should be done with ceramic heating bands and allow temperatures up to 420°C. Extended nozzles should be avoided, open nozzles preferred. For maximum processing reliability and service life, the use of bimetallic screws and barrels is recommended.
The injection unit should be selected so that the shot volume is 30 – 70% of the maximum metering volume.

**Basic settings:**

Back pressure should be selected low to medium to avoid excessive shear. We recommend 50 – 300 bar (specific) as the basic setting. The injection speed should be set as a slow – fast – slow profile. The basic principle is: as fast as possible, as slow as necessary. Depending on the part geometry, injection pressures between 1000 and 2000 bar can be expected. If the pressure requirement is high, an increase in mold and/or melt temperature can reduce the required injection pressure.
The holding pressure level and time should be selected so that the best possible compensation for volume shrinkage can be achieved in order to avoid sink marks and blowholes. It is advisable to determine the sealing time by weighing out the components in a test series. A value of 500 – 700 bar (specific) can serve as an orientation for the holding pressure level; in individual cases, higher values may also be appropriate.
The metering time should be selected in such a way that the cooling time is utilized as fully as possible. If the screw speed becomes too low for this purpose, a metering delay time can be set.

**Material change:**

Due to the high temperatures involved in processing KEBAPEAK, the barrel must be cleaned particularly carefully when changing material in order to remove the material without leaving any residue. Suitable, temperature-resistant cleaning granules (e.g. based on PEI or PES) must be used for this purpose, and it is recommended that the screw be pulled and mechanically cleaned each time the material is changed.

A typical material change takes place in the following steps:
– Empty the hopper and allow the screw to run empty.
– Fill in cleaning granulate (see above) and rinse until no more residues of KEBAPEAK are visible
– Reduce temperatures to 350°C while continuously rinsing with cleaning granules

– Change cleaning material to PC and further reduce temperatures to approx. 250°C.
– If necessary, continue rinsing with PE while lowering temperatures further
– Pull screw and clean mechanically

**Application engineering support:**

Our application engineers are at your disposal for all questions concerning the processing of KEBAPEAK. We will also be happy to support you on site at your injection molding machine, especially in problem solving and process optimization.

**Legal notices:**

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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