Edgetek™ PK-30GF/000 EM BK

Polyetheretherketone

Key Characteristics

Product Description		
30% Glass Fiber Reinforced PEEK Compound with High Flowability		
General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• General Purpose	• High Heat Resistance
Uses	• Automotive Applications • Consumer Applications	• General Purpose • Industrial Applications
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.48	1.48	ASTM D792
Melt Mass-Flow Rate (MFR) (400°C/2.16 kg)	6.0 g/10 min	6.0 g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0E-3 to 4.0E-3 in/in	0.20 to 0.40 %	ASTM D955
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Modulus [2]	1.74E+6 psi	12000 MPa	ASTM D638
Tensile Strength [2] (Yield)	26100 psi	180 MPa	ASTM D638
Tensile Elongation [2] (Break)	3.0 to 4.0 %	3.0 to 4.0 %	ASTM D638
Flexural Modulus	1.60E+6 psi	11000 MPa	ASTM D790
Flexural Strength	40600 psi	280 MPa	ASTM D790
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256A
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	2.1 ft·lb/in	110 J/m	
Unnotched Izod Impact			ASTM D256
73°F (23°C), 0.125 in (3.18 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, 0.125 in (3.18 mm)	617 °F	325 °C	
Electrical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Surface Resistivity	1.0E+14 ohms	1.0E+14 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

Injection	Typical Value (English)	Typical Value (SI)
Processing (Melt) Temp	680 to 734 °F	360 to 390 °C
Mold Temperature	338 to 374 °F	170 to 190 °C

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] Type I, 0.20 in/min (5.1 mm/min)

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