

VESTAKEEP® 3300 G
PEEK

Evonik Operations GmbH

Medium-viscosity, unreinforced polyether ether ketone

VESTAKEEP® 3300 G is a medium-viscosity, unreinforced polyether ether ketone for injection molding and extrusion.

The semi-crystalline polymer features superior thermal and chemical resistance. Parts made from VESTAKEEP® 3300G are of low flammability.

VESTAKEEP® 3300 G can be processed by common machines for thermoplastics.

We recommend a melt temperature between 360°C and 380°C during the injection molding process. The mold temperature should be within a range of 160°C to 200°C, preferably 180°C.

VESTAKEEP® 3300 G is supplied as granules in 25 kg boxes with moisture-proof polyethylene liners.

Pigmentation may affect values.

Inside the original and undamaged packaging, the product has a shelf life of at least 2 years when stored in dry rooms at temperatures not exceeding 30°C.

For information about processing VESTAKEEP® 3300 G, please follow the general recommendations in our brochure "VESTAKEEP® PEEK Processing Guidelines".

The values presented are typical or average values, they do not constitute a specification.

FOR FURTHER INFORMATION PLEASE CONTACT US AT EVONIK-HP@EVONIK.COM OR VISIT OUR PRODUCT AT WWW.INDUSTRIAL.VESTAKEEP.COM

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	20	cm³/10min	ISO 1133
Temperature	380	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.9	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3600	MPa	ISO 527
Yield stress	95	MPa	ISO 527
Yield strain	5	%	ISO 527
Nominal strain at break	25	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	7	kJ/m²	ISO 179/1eA
Type of failure	C	-	-
Notched Impact Strength (Charpy), -30°C	6	kJ/m²	ISO 179/1eA
Type of failure	C	-	-

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	340	°C	ISO 11357-1/-3
Glass Transition Temperature (10°C/min)	152	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	155	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	205	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	305	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	60	E-6/K	ISO 11359-1/-2
UL recognition	yes	-	-
Oxygen index	38	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	2.8	-	IEC 62631-2-1

Relative permittivity, 1MHz	2.8	-	IEC 62631-2-1
Dissipation Factor, 100Hz	30	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	50	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E15	Ohm	IEC 62631-3-2
Electric Strength	33.9	kV/mm	IEC 60243-1
Comparative tracking index	200	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.5	%	Sim. to ISO 62
Density	1300	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	380	°C	ISO 294
Injection Molding, mold temperature	180	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294
Injection Molding, pressure at hold	120	MPa	ISO 294

Characteristics

Processing

Injection Molding, Film Extrusion, Profile Extrusion, Other Extrusion

Chemical Resistance

General Chemical Resistance

Delivery form

Pellets

Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass) (23°C)
- ✓ Citric Acid solution (10% by mass) (23°C)
- ✓ Hydrochloric Acid (36% by mass) (23°C)
- ✗ Nitric Acid (40% by mass) (23°C)
- ✓ Sulfuric Acid (38% by mass) (23°C)
- ✓ Sulfuric Acid (5% by mass) (23°C)
- ✓ Chromic Acid solution (40% by mass) (23°C)

Bases

- ✓ Sodium Hydroxide solution (35% by mass) (23°C)
- ✓ Sodium Hydroxide solution (1% by mass) (23°C)
- ✓ Ammonium Hydroxide solution (10% by mass) (23°C)

Alcohols

- ✓ Isopropyl alcohol (23°C)
- ✓ Methanol (23°C)
- ✓ Ethanol (23°C)

Hydrocarbons

- ✓ n-Hexane (23°C)
- ✓ Toluene (23°C)
- ✓ iso-Octane (23°C)

Ketones

- ✓ Acetone (23°C)

Ethers

- ✓ Diethyl ether (23 °C)

Mineral oils

- ✓ SAE 10W40 multigrade motor oil (23 °C)
- ✓ Insulating Oil (23 °C)

Standard Fuels

- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C) (23 °C)
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23 °C)
- ✓ Diesel fuel (pref. ISO 1817 Liquid F) (23 °C)

Salt solutions

- ✓ Sodium Chloride solution (10% by mass) (23 °C)
- ✓ Sodium Hypochlorite solution (10% by mass) (23 °C)
- ✓ Sodium Carbonate solution (20% by mass) (23 °C)
- ✓ Sodium Carbonate solution (2% by mass) (23 °C)
- ✓ Zinc Chloride solution (50% by mass) (23 °C)

Other

- ✓ Ethyl Acetate (23 °C)
- ✓ Hydrogen peroxide (23 °C)
- ✓ Ethylene Glycol (50% by mass) in water (108 °C)
- ✓ Water (23 °C)
- ✓ Deionized water (90 °C)

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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Important: irrespective of product type or designation, ALBIS does not recommend or support the use of any products it supplies which fall into the following medical, pharmaceutical or diagnostic application categories:

- risk class III applications according to EU directive 93/42/EEC
- any bodily implant application for greater than 30 days
- any critical component in any medical device that supports or sustains human life.

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