

VICTREX™ PEEK POLYMERS 450FE20

General Information

Product Description

High performance thermoplastic material, 20% filled with PTFE PolyEtherEtherKetone (PEEK), semi crystalline, granules for injection moulding and extrusion, standard flow, FDA food contact compliant, colour natural / beige.

Tribological applications. Excellent wear resistance, very low coefficient of friction. Chemically resistant to aggressive environments.

Material Properties

Physical	Nominal Value	Unit	Test Method
Density (Crystalline)	1.40	g/cm ³	ISO 1183
Spiral Flow ¹	13.0	cm	Internal Method
Molding Shrinkage ²			ISO 294-4
Across Flow	1.7	%	
Flow	1.2	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3200	MPa	ISO 527-1
Tensile Stress (Yield, 23°C)	78.0	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	25	%	ISO 527-2
Flexural Modulus (23°C)	3200	MPa	ISO 178
Flexural Stress			ISO 178
23°C ³	125	MPa	
3.5% Strain, 23°C	100	MPa	
125°C	70.0	MPa	
175°C	18.0	MPa	
275°C	13.0	MPa	
Compressive Stress			ISO 604
23°C	105	MPa	
120°C	65.0	MPa	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Notched Izod Impact Strength (23°C)	8.0	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180
Hardness	Nominal Value	Unit	Test Method
Shore Hardness (Shore D, 23°C)	81		ISO 868

VICTREX™ PEEK POLYMERS 450FE20

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	150	°C	ISO 75-2/Af
Glass Transition Temperature Onset	143	°C	ISO 11357-2
Midpoint	150	°C	
Melting Temperature	343	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow : < 143°C	4.0E-5	cm/cm/°C	
Flow : > 143°C	1.2E-4	cm/cm/°C	
Transverse : < 143°C	6.0E-5	cm/cm/°C	
Transverse : > 143°C	1.4E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+16	ohms·cm	IEC 60093
Electric Strength (2.00 mm)	26	kV/mm	IEC 60243-1
Dielectric Constant (23°C, 1 kHz)	2.80		IEC 60250
Dissipation Factor (23°C, 1 MHz)	4.0E-3		IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (400°C)	350	Pa·s	ISO 11443

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120 to 150	°C
Drying Time	3.0 to 5.0	hr
Hopper Temperature	< 100	°C
Rear Temperature	355	°C
Middle Temperature	360 to 365	°C
Front Temperature	370	°C
Nozzle Temperature	375	°C
Mold Temperature	170 to 200	°C

Injection Notes

Runner: Die / nozzle >3mm, manifold >3.5mm
Gate: >2mm or 0.5 x part thickness

Notes

¹ Mold Temperature: 180°C, Melt Temperature: 375°C, 1.00 mm

² 375°C nozzle, 180°C tool

³ At yield

Revision Date: 7/17/2023

This information is provided "as is". It is not intended to amount to advice. Use of the product is at the customer's/user's risk. It is the customer's/user's responsibility to thoroughly test the product in each specific application to determine its performance, efficacy and safety for each end-use product, device or other application and compliance with applicable laws, regulations and standards. Mention of a product is no guarantee of availability. Victrex reserves the right to modify products, data sheets, specifications and packaging. **Victrex makes no warranties, express or implied (including, without limitation, any warranty of fitness for a particular purpose or of intellectual property non-infringement) and will not be liable for any loss or damage of any nature (however arising) in connection with customer's/user's use or reliance on this information, except for any liability which cannot be excluded or limited by law.** This document may be modified or retracted at any time without notice to the customer/user.

Victrex Manufacturing Limited (or another member of the Victrex group) is the owner or the licensee of all intellectual property rights in and to this document including the following trademarks, VICTREX, INVIBIO, JUVORA, APTIV, 450G, PEEK-OPTIMA, SHAPING FUTURE PERFORMANCE, LMPAEK, TRIANGLE (Device). All rights are protected by intellectual property rights including copyright under relevant national and international intellectual property laws and treaties. All rights reserved. Copyright © Victrex Manufacturing Limited 2023.