

CELAPEX® 300FC30 - PEEK

Description

Celapex® 300FC30 is an easy flow, 30% carbon fiber/graphite/PTFE reinforced polyether ether ketone (PEEK) for injection molding. It has excellent wear resistance, very low coefficient of friction and superior chemically resistant to aggressive environments. The typical applications of this product are standard geometry injection molded parts.

Physical properties	Value	Unit	Test Standard
Density	1450	kg/m ³	ISO 1183
Melt flow rate, MFR	14	g/10min	ISO 1133
MFR temperature	380	°C	ISO 1133
MFR load	5	kg	ISO 1133
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
Tensile stress at break, 5mm/min	145	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	2.2	%	ISO 527-2/1A
Flexural modulus, 23°C	11500	MPa	ISO 178
Flexural strength, 23°C	220	MPa	ISO 178
Charpy impact strength, 23°C	30	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4	kJ/m ²	ISO 179/1eA
Izod impact notched, 23°C	5	kJ/m ²	ISO 180/1A
Izod impact unnotched, 23°C	30	kJ/m ²	ISO 180/1U

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	343	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	143	°C	ISO 11357-1,-2,-3
DTUL at 1.8 MPa	315	°C	ISO 75-1, -2
CLTE below T _g , parallel	0.12	E-4/°C	ISO 11359-2
CLTE above T _g , parallel	15000	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Volume resistivity	1000000	Ohm*m	IEC 60093

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.03	%	-
Drying time	4 - 8	h	-
Drying temperature	140 - 150	°C	-
Temperature	Value	Unit	Test Standard
Melt temperature	375 - 400	°C	-
Mold temperature	170 - 195	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	20	bar	-
Speed	Value	Unit	Test Standard
Injection speed	medium-fast	-	-

Characteristics

Product Categories	Processing
Tribological	Injection molding