

### Chemical Designation

PEEK (Polyetheretherketone)

### Colour

beige opaque

### Density

1.3 g/cm<sup>3</sup> (\*2)

### Main features

- inherent flame retardant
- very good chemical resistance
- good slide and wear properties
- good heat deflection temperature
- resistance against high energy radiation
- hydrolysis and superheated steam resistant

### Target Industries

- electronics
- food technology
- automotive industry
- chemical technology
- mechanical engineering
- aircraft and aerospace technology

General material information	parameter	value	unit	norm	comment
Diameter		1,75 +/- 0,05	mm	-	(1) standard spool body
Spool measurements	holder	Ø 52	mm	-	(2) do not dry spool >120°C
Spool measurements	width	55	mm	-	(3) Ø 1,75mm
Spool measurements	outer diameter	Ø 200	mm	-	1)
Spool Material		Polycarbonate	-	-	2)
Filament Load per Spool		500	g	-	
Filament Length per Spool		149	m	-	3)

Mechanical properties	parameter	value	unit	norm	comment
Tensile strength	5mm/min, Orientation XY	89,3	MPa	DIN EN ISO 527-2	1) (1) (*5), (*6)
Tensile strength	5mm/min, Orientation XZ	94,0	MPa	DIN EN ISO 527-2	2) (2) (*5), (*6)
Tensile strength	5mm/min, Orientation ZX	92,3	MPa	DIN EN ISO 527-2	3) (3) (*5), (*6)
Modulus of elasticity (tensile test)	5mm/min, Orientation XY	3543,0	MPa	DIN EN ISO 527-2	4) (4) (*5), (*6)
Modulus of elasticity (tensile test)	5mm/min, Orientation XZ	3777,0	MPa	DIN EN ISO 527-2	5) (5) (*5), (*6)
Modulus of elasticity (tensile test)	5mm/min, Orientation ZX	3668,3	MPa	DIN EN ISO 527-2	6) (6) (*5), (*6)
Elongation at yield (tensile test)	5mm/min, Orientation XY	22,3	%	DIN EN ISO 527-2	7) (7) (*5), (*6)
Elongation at yield (tensile test)	5mm/min, Orientation XZ	5,9	%	DIN EN ISO 527-2	8) (8) (*5), (*6)
Elongation at yield (tensile test)	5mm/min, Orientation ZX	5,5	%	DIN EN ISO 527-2	9) (9) (*5), (*6)
Elongation at break (tensile test)	5mm/min, Orientation XY	119,5	%	DIN EN ISO 527-2	10) (10) (*5), (*6)
Elongation at break (tensile test)	5mm/min, Orientation XZ	30,7	%	DIN EN ISO 527-2	11) (11) (*5), (*6)
Elongation at break (tensile test)	5mm/min, Orientation ZX	8,1	%	DIN EN ISO 527-2	12) (12) (*5), (*6)
Notched impact strength (Charpy)	max. 7,5J - 23°C	7,0	kJ/m <sup>2</sup>	DIN EN ISO 179-1eA	13) (13) (*1)

Thermal properties	parameter	value	unit	norm	comment
Glass transition temperature		143	°C	ASTM D 3418	1) (1) (*2)
Melting temperature		343	°C	DIN EN ISO 11357	2) (2) (*2)
Deflection temperature	HDT-A	162	°C	ISO-R 75 Method A	3) (3) (*2)
Service temperature	short term	300	°C	-	4) (4) (*2)
Service temperature	long term	260	°C	-	5) (5) (*2)
Thermal expansion (CLTE)		6,0	10 <sup>-5</sup> K <sup>-1</sup>	DIN EN ISO 11359-1;2	6) (6) (*2)

Other properties	parameter	value	unit	norm	comment
Moisture absorption		0,03	%	DIN EN ISO 62	1) (1) (*2)
Flammability (UL94)	125x13x1,5mm	V0		DIN IEC 60695-11-10;	2) (2) (*2)
MVR	380°C / 5kg	12	cm <sup>3</sup> /10 min	DIN EN ISO 1133	3) (3) (*2)

Processing parameter	parameter	value	unit	norm	comment
Nozzle temperature		420 - 440	°C	-	(1) required
Max. melt temperature		470	°C	-	
Print bed temperature		160 - 250	°C	-	
Build chamber temperature		160 - 230	°C	-	1)
Nozzle diameter		0,4	mm	-	
Print speed		20 - 30	mm/s	-	
Fan speed		0	%	-	

Predrying	parameter	value	unit	norm	comment
Drying temperature		120	°C	-	1) (1) (*4)
Drying time		8	h	-	



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