VESTAKEEP® 3300 G

PEEK — Evonik Operations GmbH

Product Texts

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

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

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**3600**	MPa	ISO 527
[C] Yield stress	**95**	MPa	ISO 527
[C] Yield strain	**5**	%	ISO 527
[C] Nominal strain at break	**25**	%	ISO 527
[C] Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**N**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**7**	kJ/m²	ISO 179/1eA
[C] Type of failure	**C**	-	-
[C] Charpy notched impact strength, -30°C	**6**	kJ/m²	ISO 179/1eA
[C] Type of failure	**C**	-	-

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**340**	°C	ISO 11357-1/-3
[C] Glass transition temperature, 10°C/min	**152**	°C	ISO 11357-1/-2
[C] Temp. of deflection under load, 1.80 MPa	**155**	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**205**	°C	ISO 75-1/-2
[C] Vicat softening temperature, B	**305**	°C	ISO 306
[C] Coeff. of linear therm. expansion, parallel	**60**	E-6/K	ISO 11359-1/-2

Yellow Card available	**yes**	-	-
[C] Oxygen index	**38**	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
[C] Relative permittivity, 100Hz	**2.8**	-	IEC 62631-2-1
[C] Relative permittivity, 1MHz	**2.8**	-	IEC 62631-2-1
[C] Dissipation factor, 100Hz	**30**	E-4	IEC 62631-2-1
[C] Dissipation factor, 1MHz	**50**	E-4	IEC 62631-2-1
[C] Volume resistivity	**>1E13**	Ohm*m	IEC 62631-3-1
[C] Surface resistivity	**1E15**	Ohm	IEC 62631-3-2
[C] Electric strength	**33.9**	kV/mm	IEC 60243-1
[C] Comparative tracking index	**200**	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	**0.5**	%	Sim. to ISO 62
[C] Density	**1300**	kg/m³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
[C] 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

[C]: CAMPUS

Characteristics

Processing
Injection Molding, Film Extrusion, Profile Extrusion, Other Extrusion

Delivery form
Pellets

Chemical Resistance
General Chemical Resistance