

TECHNICAL DATA AND PROCESS SHEET

10% GLASS FIBER REINFORCED HIGH FLOW PEEK

INSTRUC PEEKGF10HF

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.37		1.37	
SPECIFIC VOLUME		20.22	in ³ /lb	0.730	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.4	%	0.40	%
MOLD SHRINKAGE	D955	0.5-0.6	%	0.5-0.6	%
MECHANICAL					
TENSILE STRENGTH	D638	15,000	psi	103	MPa
ELONGATION, YIELD	D638	2-4	%	2-4	%
FLEXURAL STRENGTH	D790	27,000	psi	186	MPa
FLEXURAL MODULUS	D790	800,000	psi	5,516	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1	ft.lb./in.	53	J/m
UNNOTCHED 1/8"		8	ft.lb./in.	426	J/m
ROCKWELL HARDNESS		R124	R Scale	R124	R Scale
THERMAL					
HDTUL @ 264 PSI	D648	500	°F	260	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.2	in./in. F x10 ⁻⁵	3.96	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	V0@1/16	in	V0@1/16	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ¹⁶	ohms/sq	10e ¹⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		300	°F	149	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		660-740	°F	350- 390	°C
MOLD TEMPERATURE		300	°F	149	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	mm

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