PEFLON

TECHNICAL DATA

https://peflon.com/
PEEK Resin PF-1G-M-BIO

Product Description: unfilled PEEK pellet. Processing: injection molding, extrusion.

Specifications

Test Item	Test Standard	Test Condition	Unit	Typical Value
Mechanical Properties				
Tensile Strength	ISO 527	Yield, 23°C	MPa	100
Elongation at Break	ISO 527	Break, 23°C	%	40
Flexural Strength	ISO 178	Yield, 23°C	MPa	170
Flexural Modulus	ISO 178	23°C	GPa	4
Izod Impact Strength, Notched	ISO 180/A	Notched	kJ/m²	6
Molding Shrinkage, Flow Direction	ISO 294-4	Flow Direction	%	1.0
Molding Shrinkage, Transverse Direction	ISO 294-4	Transverse Direction	%	1.3
Thermal Properties				
Melting Point	ISO 11357	-	°C	343
Glass Transition Temperature	ISO 11357	Onset	°C	143
Heat Deflection Temperature	ISO 75A-f	1.8MPa	°C	152
Flow Properties				
Melt Index	ISO 1133	380°C, 5 kg	g/10min	14
Other Properties				
Density	ISO 1183	23°C	g/cm³	1.3
Dielectric Strength	IEC 60243	2mm	kV/mm	16
Volume Resistivity	IEC 62631	-	Ω·m	3

Processing Guidance

Item	Unit	Recommended Value
Processing Method	-	injection molding, extrusion
Processing Temperature	°C	380 ± 20
Drying Condition	-	150°C / 3 h or minimum 120°C / 6 h
Moisture Absorption	%	< 0.3

Notes

Statement: This TDS is prepared according to internal testing standards and typical laboratory data. It does not constitute a warranty or guarantee for a specific application. Users should verify suitability before commercial use.

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