

# PEEK

## Property Data

Property	Test Method	Value
Density g/cm <sup>3</sup>	ISO 1183	1.30
Water absorption/ %	ISO 62-1 (23°C/24hr)	0.45
Melt Viscosity/ Pa.s	ISO 11443	350
Heat Deflection Temperature/ °C	ISO 75-f	152
Melting Point/ °C	ISO 11357	343
Glass Transition (Tg)/ °C	ISO 11357	143
Flammability Rating	UL 94	V-0
Tensile Strength/ kpsi	ISO 527	14.2
Tensile Elongation/ %	ISO 527	30
Tensile Modulus/ kpsi	ISO 527	550
Flexural Strength/ kpsi	ISO 178	181
Flexural Modulus/ kpsi	ISO 178	400
Charpy Impact Strength (notched)/ kJ/m <sup>2</sup>	ISO 179	7
Volume resistivity/ ohm.cm (23°C / 125°C / 275°C)	IEC 60093	10 <sup>16</sup> / 10 <sup>15</sup> / 10 <sup>9</sup>

## Recommended Printer Settings

Parameter	Value
Nozzle temperature	380-400 °C
Heated bed temperature	> 130 °C
Heated Chamber	Recommended to reduce warping; 70-140 °C
Speed	40-60 mm/s
Infill	As needed, up to 100 %
Layer thickness	0.2 mm recommended starting point (adjust as needed)
Nozzles	0.4 mm recommended starting point
Drying	120 °C; keep filament in dry, sealed bag/container for storage

*These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters. Generally, slower speeds, larger nozzles and layers are beneficial. PEEK is moisture sensitive, take care to dry and maintain filament and store in a sealed container.*