

## VESTAKEEP® 3300 G

### PEEK

Evonik Operations GmbH

#### 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.

Rheological properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	20	cm³/10min	ISO 1133
Temperature	380	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.9	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	3600	MPa	ISO 527
Yield stress	95	MPa	ISO 527
Yield strain	5	%	ISO 527
Nominal strain at break	25	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	7	kJ/m²	ISO 179/1eA
Type of failure	C	-	-
Notched Impact Strength (Charpy), -30°C	6	kJ/m²	ISO 179/1eA
Type of failure	C	-	-

Thermal Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting Temperature (10°C/min)	340	°C	ISO 11357-1/-3
Glass Transition Temperature (10°C/min)	152	°C	ISO 11357-1/-2
Temp. of deflection under load (1.80 MPa)	155	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	205	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	305	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	60	E-6/K	ISO 11359-1/-2
UL recognition	yes	-	-
Oxygen index	38	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Relative permittivity, 100Hz	2.8	-	IEC 62631-2-1

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Relative permittivity, 1MHz	2.8	-	IEC 62631-2-1
Dissipation Factor, 100Hz	30	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	50	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E15	Ohm	IEC 62631-3-2
Electric Strength	33.9	kV/mm	IEC 60243-1
Comparative tracking index	200	-	IEC 60112

Other Properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Water Absorption	0.5	%	Sim. to ISO 62
Density	1300	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
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

### Characteristics

#### Processing

Injection Molding, Film Extrusion, Profile Extrusion, Other Extrusion

#### Chemical Resistance

General Chemical Resistance

#### Delivery form

Pellets

### Chemical Media Resistance

#### Acids

- ✓ Acetic Acid (5% by mass) (23°C)
- ✓ Citric Acid solution (10% by mass) (23°C)
- ✓ Hydrochloric Acid (36% by mass) (23°C)
- ✗ Nitric Acid (40% by mass) (23°C)
- ✓ Sulfuric Acid (38% by mass) (23°C)
- ✓ Sulfuric Acid (5% by mass) (23°C)
- ✓ Chromic Acid solution (40% by mass) (23°C)

#### Bases

- ✓ Sodium Hydroxide solution (35% by mass) (23°C)
- ✓ Sodium Hydroxide solution (1% by mass) (23°C)
- ✓ Ammonium Hydroxide solution (10% by mass) (23°C)

#### Alcohols

- ✓ Isopropyl alcohol (23°C)
- ✓ Methanol (23°C)
- ✓ Ethanol (23°C)

#### Hydrocarbons

- ✓ n-Hexane (23°C)
- ✓ Toluene (23°C)
- ✓ iso-Octane (23°C)

#### Ketones

- ✓ Acetone (23°C)

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### Ethers

- ✓ Diethyl ether (23 °C)

### Mineral oils

- ✓ SAE 10W40 multigrade motor oil (23 °C)
- ✓ Insulating Oil (23 °C)

### Standard Fuels

- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C) (23 °C)
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23 °C)
- ✓ Diesel fuel (pref. ISO 1817 Liquid F) (23 °C)

### Salt solutions

- ✓ Sodium Chloride solution (10% by mass) (23 °C)
- ✓ Sodium Hypochlorite solution (10% by mass) (23 °C)
- ✓ Sodium Carbonate solution (20% by mass) (23 °C)
- ✓ Sodium Carbonate solution (2% by mass) (23 °C)
- ✓ Zinc Chloride solution (50% by mass) (23 °C)

### Other

- ✓ Ethyl Acetate (23 °C)
  - ✓ Hydrogen peroxide (23 °C)
  - ✓ Ethylene Glycol (50% by mass) in water (108 °C)
  - ✓ Water (23 °C)
  - ✓ Deionized water (90 °C)
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