

Ketron® VMX Polyetheretherketone PEEK FG (Food Grade) is a EU 10/2011 and compositional FDA 21 CFR § 177.2415 compliant material that offers extreme dimensional stability, high strength and temperature resistance. Ketron® VMX PEEK FG shapes can be easily traced by different detection systems installed to detect contamination of the foodstuffs, allowing global food processors to safely avoid costly recalls caused by foreign contamination. Due to their superior resistance to wear and corrosion, Ketron® VMX PEEK FG components are favored for applications in the food processing and packaging industry such as pistons, manifolds, valves, and mixing vessels.

PRODUCT DATA SHEET

				ISO*	ASTM*				
				Test methods	Units	Indicative Values	Test methods	Units	Indicative Values
Thermal Properties (1)	Melting temperature (DSC, 10°C (50°F) / min)			ISO 11357-1/-3	°C	340	ASTM D3418	°F	644
	Glass transition temperature (DMA, tan delta)			DMA	°C	-	DMA	°F	-
	Thermal conductivity at 23°C (73°F)			-	W/(K.m)		-	BTU in./hr.ft².°F	1.73
	Coefficient of linear thermal expansion (-40 to 150 °C) (-40 to 300°F)			-			ASTM E-831 (TMA)	µin./in./°F	25
	Coefficient of linear thermal expansion (23 to 100°C) (73°F to 210°F)			-	µm/(m.K)	45			
	Coefficient of linear thermal expansion (23 to 150°C) (73°F to 300°F)			-	µm/(m.K)	50x10-6			
	Coefficient of linear thermal expansion (>150°C) (> 300°F) -			-	µm/(m.K)	75x10-6			
	Heat Deflection Temperature: method A: 1.8 MPa (264 PSI)			ISO 75-1/-2	°C	-	ASTM D648	°F	320
	Continuous allowable service temperature in air (20.000 hrs) (3)			-	°C	-	-	°F	480
	Min. service temperature (4)			-	°C	-	-	°F	-
Flammability: UL 94 (3 mm (1/8 in.)) (5)			-	-	V-0	-	-	V-0	
Flammability: Oxygen Index			ISO 4589-1/-2	%	40				
Mechanical Properties (6)	Tensile strength			ISO 527-1/-2 (7)	MPa	114	ASTM D638 (8)	PSI	15,000
	Tensile strain (elongation) at yield			ISO 527-1/-2 (7)	%	4.00	ASTM D638 (8)	%	-
	Tensile strain (elongation) at break			ISO 527-1/-2 (7)	%	5	ASTM D638 (8)	%	6
	Tensile modulus of elasticity			ISO 527-1/-2 (9)	MPa	4,900	ASTM D638 (8)	KSI	600
	Shear Strength			ASTM D732	MPa	83	ASTM D732	PSI	12,000
	Compressive stress at 1 / 2 / 5 % nominal strain			ISO 604 (10)	MPa	45 / 86 / 144			
	Compressive strength						ASTM D695 (11)	PSI	20,000
	Charpy impact strength - unnotched			ISO 179-1/1eU	kJ/m²	45.0			
	Charpy impact strength - notched			ISO 179-1/1eA	kJ/m²	3.2			
	Izod Impact notched						ASTM D256	ft.lb./in	1.00
	Flexural strength			ISO 178 (12)	MPa	-	ASTM D790 (13)	PSI	23,000
	Flexural modulus of elasticity			ISO 178 (12)	MPa	-	ASTM D790	KSI	700
	Rockwell M hardness (14)			ISO 2039-2	-	106	ASTM D785	-	105
	Rockwell R Hardness (14)			ISO 2039-2	-		ASTM D2240	-	125
Electrical Properties	Electric strength			IEC 60243-1 (15)	kV/mm	-	ASTM D149	Volts/mil	-
	Volume resistivity			IEC 62631-3-1	Ohm.cm		IEC 60093	Ohm.cm	
	Surface resistivity			ANSI/ESD STM 11.11	Ohm/sq.		ANSI/ESD STM 11.11	Ohm/sq.	
	Dielectric constant at 1 MHz			IEC 62631-2-1	-	-	ASTM D150	-	-
	Dissipation factor at 1 MHz			IEC 62631-2-1	-	-	ASTM D150	-	-
Miscellaneous	Colour			-	-	Blue	-	-	Blue
	Density			ISO 1183-1	g/cm³	1.44			
	Specific Gravity						ASTM D792	-	1.45
	Water absorption after 24h immersion in water of 23°C (73°F)			ISO 62 (16)	%		ASTM D570 (17)	%	0.07
	Water absorption at saturation in water of 23 °C (73°F)			-	%		ASTM D570 (17)	%	0.21
	Wear rate			ISO 7148-2 (18)	µm/km	15.00	QTM 55010 (19)	in³.min/ft.lbs.hr.x10 ⁻¹⁰	350.00
	Dynamic Coefficient of Friction (-)			ISO 7148-2 (18)	-	0.29-0.46	QTM 55007 (20)	-	0.32
	Limiting PV at 100 FPM						QTM 55007 (21)	ft.lbs/in².min	12,000
	Limiting PV at 0.1 / 1 m/s cylindrical sleeve bearings			-	Mpa.m/s	- / -			
Chemical Resistance			https://www.mcam.com/en/support/chemical-resistance-information/						

Note: 1 g/cm³ = 1,000 kg/m³ ; 1 MPa = 1 N/mm² ; 1 kV/mm = 1 MV/m

NYP: there is no yield point

This table, mainly to be used for comparison purposes, is a valuable help in the choice of a material. The data listed here fall within the normal range of product properties of dry material. However, they are not guaranteed and they should not be used to establish material specification limits nor used alone as the basis of design. See the remaining notes on the next page.

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NOTES, SEE DATASHEET ON PAGE 1

- 1 The figures given for these properties are for the most part derived from raw material supplier data and other publications.
- 2 Values for this property are only given here for amorphous materials and for materials that do not show a melting temperature (PBI, PAI & PI). DMA settings, oscillation amplitude of 0.20 mm; a frequency of 1 Hz ; heating rate of 2°C/min

Temperature resistance over a period of min. 20,000 hours. After this period of time, there is a decrease in tensile strength – measured at 23 °C – of about 50 % as compared with the original value. The temperature value given here is thus based on the thermal-oxidative degradation which takes place and causes a reduction in properties. Note, however, that the maximum allowable service temperature depends in many cases essentially on the duration and the magnitude of the mechanical stresses to which the material is subjected.
- 3 Impact strength decreasing with decreasing temperature, the minimum allowable service temperature is practically mainly determined by the extent to which the material is subjected to impact. The value given here is based on unfavourable impact conditions and may consequently not be considered as being the absolute practical limit.
- 5 These estimated ratings, derived from raw material supplier data and other publications, are not intended to reflect hazards presented by the material under actual fire conditions. There is no 'UL File Number' available for these stock shapes.
- 6 Most of the figures given for the mechanical properties are average values of tests run on dry test specimens machined out of rods 40-60 mm when available, else out of plate 10-20mm. All tests are done at room temperature (23° / 73°F)
- 7 Test speed: either 5 mm/min or 50 mm/min [chosen acc. to ISO 10350-1 as a function of the ductile behaviour of the material (tough or brittle)] using type 1B tensile bars
- 8 Test speed: either 0.2"/min or 2"/min or [chosen as a function of the ductile behavior of the material (brittle or tough)] using Type 1 tensile bars
- 9 Test speed: 1 mm/min, using type 1B tensile bars
- 10 Test specimens: cylinders Ø 8 mm x 16 mm, test speed 1 mm/min
- 11 Test specimens: cylinders Ø 0.5" x 1", or square 0.5" x 1", test speed 0.05"/min
- 12 Test specimens: bars 4 mm (thickness) x 10 mm x 80 mm ; test speed: 2 mm/min ; span: 64 mm.
- 13 Test specimens: bars 0.25" (thickness) x 0.5" x 5" ; test speed: 0.11"/min ; span: 4"
- 14 Measured on 10 mm, 0.4" thick test specimens.
- 15 Electrode configuration: Ø 25 / Ø 75 mm coaxial cylinders ; in transformer oil according to IEC 60296 ; 1 mm thick test specimens.
- 16 Measured on discs Ø 50 mm x 3 mm.
- 17 Measured on 1/8" thick x 2" diameter or square
- 18 Test procedure similar to Test Method A: "Pin-on-disk" as described in ISO 7148-2, Load 3MPa, sliding velocity= 0,33 m/s, mating plate steel Ra= 0.7-0.9 µm, tested at 23°C, 50%RH.
- 19 Test using journal bearing system, 200 hrs, 118 ft/min, 42 PSI, steel shaft roughness 16±2 RMS micro inches with Hardness Brinell of 180-200
- 20 Test using Plastic Thrust Washer rotating against steel, 20 ft/min and 250 PSI, Stationary steel washer roughness 16±2 RMS micro inches with Rockwell C 20-24
- 21 Test using Plastic Thrust Washer rotating against steel, Step by step increase pressure, Test ends when plastic begins to deform or if temperature increases to 300°F.

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