

PEEK-CLASSIX™ BC1 (Granules)

General Information

Product Description

High performance biocompatible thermoplastic material, PolyEtherEtherKetone (PEEK), semi crystalline. Granules for injection moulding and extrusion, standard flow, suitable for medical devices that will be in contact with human tissue for 30 days or less. Colour natural/beige.

Typical Application Areas

For use in applications requiring high strength, high stiffness, and high ductility. Suitable for medical devices that will be in contact with human tissue for 30 days or less. As PEEK is hygroscopic, drying before use is recommended. Further information is available upon request.

PEEK-CLASSIX™ offers a high-performance polymer solution with a low level of extractables and leachables, and chemical resistance to drug concentrates, and the extremes found within the human body.

Material Properties

Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.30	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (400°C/2.16 kg)	3.7	g/10 min	Internal Method
Spiral Flow ¹	11.5	cm	Internal Method
Molding Shrinkage			ASTM D955
Flow	1.3	%	
Across Flow	1.6	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.50	%	ISO 62
Crystallinity DSC	30.0	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ² (23°C)	5940	MPa	ISO 527-1
Tensile Stress			ISO 527-2
Yield, 23°C ³	104	MPa	
Yield, 23°C ⁴	100	MPa	
Yield, 23°C ⁵	96.9	MPa	
Tensile Strain			ISO 527-2
Break, 23°C ³	29	%	
Break, 23°C ⁴	34	%	
Break, 23°C ⁵	28	%	
Flexural Modulus			
23°C ³	4100	MPa	ISO 178
23°C ⁵	3800	MPa	ISO 178
Flexural Stress			ISO 178
Yield, 23°C ³	168	MPa	
Yield, 23°C ⁴	164	MPa	
Yield, 23°C ⁵	156	MPa	
3.5% Strain, 23°C ⁵	122	MPa	
Compressive Modulus ⁵ (23°C)	3970	MPa	ISO 604
Compressive Stress ⁵ (23°C)	130	MPa	ISO 604
Shear Modulus ⁵ (23°C)	1150	MPa	ISO 15310
Shear Strength ⁵ (23°C)	91.2	MPa	ASTM D732

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Mechanical	Nominal Value	Unit	Test Method
Poisson's Ratio ⁵ (23°C)	0.36		ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180
23°C ³	6.7	kJ/m ²	
23°C ⁴	7.3	kJ/m ²	
23°C ⁵	7.2	kJ/m ²	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale, 23°C)	99		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature (Onset)	145	°C	ISO 11357-2
Melting Temperature	340	°C	ISO 11357-3
CLTE			
Flow : 50 to 120°C	4.1E-5	cm/cm/°C	ASTM D696
Flow : 170 to 220°C	1.2E-4	cm/cm/°C	ASTM D696
Flow : 220 to 270°C	1.5E-4	cm/cm/°C	ASTM D696
Transverse : 50 to 120°C ⁶	3.5E-5	cm/cm/°C	ASTM D696
Transverse : 50 to 120°C	6.5E-5	cm/cm/°C	3rd Party Test Method
Transverse : 170 to 220°C ⁶	8.5E-5	cm/cm/°C	ASTM D696
Transverse : 170 to 220°C	1.3E-4	cm/cm/°C	ASTM D696
Transverse : 220 to 270°C ⁶	1.1E-4	cm/cm/°C	ASTM D696
Transverse : 220 to 270°C	1.6E-4	cm/cm/°C	ASTM D696
Specific Heat			Internal Method
37°C ⁷	1170	J/kg/°C	
37°C ⁸	2630	J/kg/°C	
400°C ⁹	1400	J/kg/°C	
Recrystallization Temperature (Peak)	294	°C	ISO 11357-3
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity 1000 s ⁻¹ (400°C)	440	Pa·s	Internal Method
Melt Stability 1000 s ⁻¹ , 1 hr (400°C)	1.0	%	Internal Method
Shear Viscosity 100 s ⁻¹ (400°C)	958	Pa·s	Internal Method
Shear Viscosity 1000 s ⁻¹ (400°C)	353	Pa·s	Internal Method
Shear Viscosity 10000 s ⁻¹ (400°C)	96.9	Pa·s	Internal Method
Shear Viscosity 200 s ⁻¹ (400°C)	73.4	Pa·s	Internal Method
Shear Viscosity 2000 s ⁻¹ (400°C)	246	Pa·s	Internal Method
Shear Viscosity 400 s ⁻¹ (400°C)	534	Pa·s	Internal Method
Shear Viscosity 4000 s ⁻¹ (400°C)	170	Pa·s	Internal Method

Typical Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120 to 150	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	< 100	°C
Rear Temperature	355	°C
Middle Temperature	360 to 365	°C
Front Temperature	370	°C
Nozzle Temperature	375	°C

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Injection	Nominal Value	Unit
Mould Temperature	180 to 200	°C

Injection Notes

Drying Temperature / Time: 150°C / 3h or 120°C / 5h (residual moisture <0.02%)

Runner: Die / Nozzle >3 mm, Manifold >3.5 mm

Gate: >1 mm or 0.5 x part thickness

Important Notes:

1) Processing conditions quoted in our datasheets are typical of those used in our processing laboratories

- Data for mould shrinkage should be used for material comparison. Actual mould shrinkage values are highly dependent on part geometry, mould configuration, and processing conditions.
- Mould shrinkage differs for along flow and across flow directions. "Along flow" direction is taken as the direction the molten material is travelling when it exits the gate and enters the mould.
- Mould shrinkage is expressed as a percent change in dimension of a specimen in relation to mould dimensions.

2) Data are generated in accordance with prevailing national, international and internal standards, and should be used for material comparison.

Actual property values are highly dependent on part geometry, mould configuration and processing conditions. Properties may also differ for along flow and across flow directions.

Detailed data available on our website www.invibio.com or upon request.

Notes

¹ 1.00 mm

² 0.05 – 0.25%

³ 3-Cycles Steam

⁴ 75 kGy Gamma

⁵ As Moulded

⁶ Through Flow

⁷ Amorphous

⁸ Crystalline

⁹ Molten

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