



# G-PAEK™ 1400G

**Product Details:** Ultra high Performance thermoplastic polymer, virgin, semicrystalline granules suitable for injection molding & compounding applications, high flow, Beige in color.

## Typical Application Areas:

Intricate geometries with thin cross sections or long flow lengths, for high strength and stiffness as well as good ductility.

## Typical Properties

PROPERTY	TEST METHOD/CONDITIONS	UNIT	G-PAEK™ 1400G
<b>General Properties</b>			
Density	23°C	g/cc	1.30
Water Absorption	ASTM D 570-98	%	0.08
Rockwell Hardness	ASTM D 785/M Scale		103
Shore D Hardness	ASTM D 2240-05		86
Mold Shrinkage (400°C nozzle, 210°C Mold)	Along Flow	%	1.0
	Across Flow	%	1.3
Spiral Flow (400°C nozzle, 220°C Mold)	ASTM D 3123, 2 mm	mm	648

<b>Thermal Properties</b>			
Glass Transition Temperature(Tg)	ASTM D 3418	°C	152
Melting Point (Tm)	ASTM D 3418	°C	372
Heat Deflection Temperature (HDT)	ASTM D 648 /1.8 MPa	°C	175
Continuous Use Temperature ( Expected)	UL 746B	°C	280

<b>Mechanical Properties at 23°C</b>			
Tensile Strength	ASTM D 638	MPa	80
Tensile Modulus	ASTM D 638	GPa	4.3
Elongation at Break	ASTM D 638	%	2-5
Flexural Strength	ASTM D 790	MPa	115
Flexural Modulus	ASTM D 790	GPa	4.5
Compressive Strength	ASTM D 695	MPa	125
Izod Impact Strength(Notched)	ASTM D 256	J/m	13
Izod Impact Strength(Un-notched)	ASTM D 256	J/m	No Break



PROPERTY	TEST METHOD/CONDITIONS	UNIT	G-PAEK™ 1400G
<b>Rheological Properties</b>			
Melt Viscosity at 400°C	ASTM D 3835/@1000 s <sup>-1</sup>	Pa.s	140-200

<b>Electrical Properties</b>			
Dielectric Strength	ASTM D 149/ 3.2 mm thickness	kVmm <sup>-1</sup>	17
Surface Resistivity	ASTM D 257	Ω	10 <sup>16</sup>
Volume Resistivity	ASTM D 257	Ωcm <sup>-1</sup>	10 <sup>16</sup>
Arc Resistance	ASTM D 495/@ 500 Volts	sec	175
CTI	ASTM D 3638	V/50 drops	145

<b>Fire Properties</b>			
Flammability	UL 94/0.8 mm	-	V-0

<b>Recommended Processing Conditions</b>	
Drying Temperature/Time	4-6 hrs at 150°C
Temperature Settings	390-410°C
Nozzle Temperature	410°C
Hopper/ Throat Temperature	60-80°C
Mold Temperature	200-220°C

<b>Nominal Granule Size</b>
• Dimensions, length 2.0 – 4.0 mm, diameter 2.0 – 3.5 mm
• No longs greater than 8.0 mm
• Granules of uniform cut and color

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