



Pyramid™ KK2219

Polyaryletherketone, Wear Grade, with Tg of 320 °F (160 °C)

General	ASTM No.	US Value	SI Unit
Form	---	Pellets (black)	
Composition (polyaryletherketone)	---	Carbon/PTFE/Graphite	
Filler Content (nominal value)	---	30%	
Specific Gravity	D792	1.45 g/ml	
Linear Mold Shrinkage, in/in	D955	0.02	
Water Absorption (24hr. @ 23 °C, %)	D570	0.1%	
Mechanical			
Tensile Strength	D638	21 Kpsi	145 MPa
Tensile Modulus	D638	1.45 Mpsi	10 GPa
Tensile Elongation (Break), %	D638	2.5%	
Flexural Strength	D790	34 Kpsi	234 MPa
Flexural Modulus	D790	1.38	9.5 GPa
Izod, notched, ft-lb/in @ 1/8"	D256	1.2	0.64 J/cm
Hardness, Rockwell M/Shore D	D2240/D792	M101	D90
Thermal			
Melting Point	DSC	662 °F	350 °C
Tg	D3418	360 °F	182 °C
HDT@ 264 psi	D648	580 °F	300 °C
Electrical			
Surface Resistivity	EOS/ESD	1 x 10 ⁷	
Other			
Dynaimc Coefficients of Friction	D1894	0.11	
Static Coefficients of Friction	D1894	0.11	
Poissons Ratio	---	0.45	



Processing

Drying Temperature	356°F (180°C)	Drying Time	4 hours
Feed Temperature	716°F (380°C)	Middle Temperature	716°F (380°C)
Front Temperature	716°F (380°C)	Nozzle Temperature	716°F (380°C)
Mold Temperature	392-410°F (200-210°C)	Injection Rate	Fast
Screw Compression	2.5 - 3.5:1		

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