

Ixef® 1002

Polyarylamide
Solvay Specialty Polymers

Message:

Ixef 1002 is a 30% glass fiber reinforced universal polyaramide compound with high strength, high rigidity, excellent surface finish and excellent creep resistance. -Black: Ixef 1002/9008
natural color: Ixef 1002/0008
customers can color by themselves

General Information	
UL YellowCard	E95746-481132
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight
Features	Good dimensional stability
	Excellent appearance
	Low hygroscopicity
	Rigidity, high
	High strength
	Good creep resistance
	High liquidity
	Good chemical resistance
Uses	Bushing
	Gear
	Electrical/Electronic Applications
	Electrical housing
	Electrical appliances
	Power/other tools
	Industrial application
	Machine/mechanical parts
	Home appliance components
	Furniture
	Metal substitution
	Parts under the hood of a car
	Automotive Electronics
	Application in Automobile Field
	Car interior parts
	Automotive exterior parts
	Mobile phone
	Camera application
RoHS Compliance	RoHS compliance

Appearance	Black Available colors Natural color		
Forms	Particle		
Processing Method	Injection molding		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
Physical	Nominal Value	Unit	Test Method
Density	1.43	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.10 - 0.40	%	Internal method
Water Absorption (23°C, 24 hr)	0.20	%	ISO 62
Water absorption-Equil, 65% RH	1.9	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11500	MPa	ISO 527-2
Tensile Stress (Break)	190	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	11500	MPa	ISO 178
Flexural Stress	285	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	70	J/m	ASTM D256
Unnotched Izod Impact	460	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	230	°C	ISO 75-2/A
CLTE - Flow	1.8E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms · cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Dielectric Constant (110 Hz)	3.90		IEC 60250
Dissipation Factor (110 Hz)	0.010		IEC 60250
Comparative Tracking Index	400	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating ¹	HB		UL 94
Oxygen Index	25	%	ISO 4589-2
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	0.50 - 1.5	hr	
Rear Temperature	250 - 260	°C	
Front Temperature	260 - 290	°C	
Processing (Melt) Temp	280	°C	
Mold Temperature	120 - 140	°C	
Injection Rate	Fast		

Injection instructions

热流道系统:250 °C~260 °C (482°F~500 °F)

干燥:所提供的成型用材料无需干燥处理.但是,如果袋已被打开超过24小时,必须先干燥材料.如果使用的除湿空气干燥机露点为-28 ° C(-18 °F)或更低,应遵循以下规则:120 ° C(248 °F)温度下 烘干0.5~1.5小时, 100°C C(212°F)温度下,1~3个小时,或80 °C(176 °F)温度下,1-7个小时. 注塑成型: IXEF 1002混合物在大多数螺杆注塑机上均可以很容易地注射成型.建议采用通用螺杆,取最小背压. 测得的熔融温度应该在280°C (536° F)左右,机筒后端温度应该在250~260°C (482~500°F)左右,前端逐渐增至260 °C~290°C (500~554 °F).如果使用热流道,温度应设置为250~260 °C(482~500 ° F) . 为了最大限度地提高结晶度,模腔表面温度必须保持在120和140°C(248和284°F)之间.成型温度低,容易使产品产生翘曲,外观不良,并极可能产生蠕变. 射出压力的设定应确保快速射出.调整保压压力和时间,尽可能提高零件的重量.部件正好完全填充完毕(95-99%)前,将注塑件从射出部位转移到螺杆位置进行保压.

NOTE

1. These flammability ratings do not represent the risk of these materials or any other materials in actual fire situations.

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