

Ixef® 1032

Polyarylamide
Solvay Specialty Polymers

Message:

Ixef 1032 is a 60% glass fiber reinforced universal polyaramide compound with extremely high strength and rigidity, excellent surface gloss and excellent creep resistance. -natural color: Ixef 1032/0008
black: Ixef 1032/9008
customers can color by themselves

General Information				
UL YellowCard		E95746-253212		
Filler / Reinforcement		Glass fiber reinforced material, 60% filler by weight		
Features		Super rigidity		
		Good dimensional stability		
		Excellent appearance		
		Low hygroscopicity		
		High strength		
		Good creep resistance		
		High liquidity		
		Good chemical resistance		
Uses		Highlight applications		
		Furniture		
		Metal substitution		
		Automotive Electronics		
		Application in Automobile Field		
		Car interior parts		
		Sporting goods		
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)		
		Secant Modulus vs. Strain (ISO 11403-1)		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.77	--	g/cm ³	ISO 1183

Molding Shrinkage	0.10 - 0.30	--	%	Internal method
Water Absorption (23°C, 24 hr)	0.13	--	%	ISO 62
Water absorption-Equil, 65% RH	1.3	--	%	Internal method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	24000	23000	MPa	ISO 527-2
Tensile Stress (Break)	280	250	MPa	ISO 527-2
Tensile Strain (Break)	1.8	2.0	%	ISO 527-2
Flexural Modulus	23500	--	MPa	ISO 178
Flexural Stress	400	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	120	--	J/m	ASTM D256
Unnotched Izod Impact	900	--	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	230	--	°C	ISO 75-2/A
CLTE - Flow	1.4E-5	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+13	--	ohms · cm	IEC 60093
Dielectric Strength	24	--	kV/mm	IEC 60243-1
Dielectric Constant (110 Hz)	4.50	--		IEC 60250
Dissipation Factor (110 Hz)	9.0E-3	--		IEC 60250
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating ¹	HB	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
0.800 mm	775	--	°C	IEC 60695-2-12
1.50 mm	775	--	°C	IEC 60695-2-12
3.00 mm	960	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature				IEC 60695-2-13
0.800 mm	800	--	°C	IEC 60695-2-13
1.50 mm	800	--	°C	IEC 60695-2-13
3.00 mm	825	--	°C	IEC 60695-2-13
Oxygen Index	25	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	12		hr	
Suggested Max Moisture	0.30		%	
Rear Temperature	250 - 260		°C	

Middle Temperature	260 - 270	°C
Front Temperature	270 - 280	°C
Nozzle Temperature	260 - 290	°C
Processing (Melt) Temp	280	°C
Mold Temperature	120 - 140	°C
Injection Pressure	50.0 - 150	MPa
Injection Rate	Fast	
Holding Pressure	75.0	MPa
Back Pressure	0.00 - 1.00	MPa
Screw L/D Ratio	15.0:1.0 to 20.0:1.0	

Injection instructions

射出时间: 0.5~2.5秒保压时间: 3e 秒冷却时间:2.5e²秒(e =壁厚,毫米)

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 烘烤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 1032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120~140°C(248~284°F)之间.成型温度低,容易产生翘曲,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

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

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