

Ixef® 1524

Polyarylamide

Solvay Specialty Polymers

Message:

Ixef 1524 is a 50% glass fiber reinforced, halogen-free flame retardant polyacrylamide with high strength, high rigidity, good surface gloss and excellent creep resistance. -black: Ixef 1524/9008

-customers can color by themselves

General Information				
UL YellowCard		E95746-568114		
Filler / Reinforcement		Glass fiber reinforced material, 50% filler by weight		
Additive		Flame retardancy		
Features		Super rigidity		
		Good dimensional stability		
		Excellent appearance		
		Low hygroscopicity		
		High strength		
		Good creep resistance		
		High liquidity		
		Good chemical resistance		
		Halogen-free		
		Bromine-free		
Uses		Electrical/Electronic Applications		
		Mobile phone		
		Shell		
RoHS Compliance		RoHS compliance		
Appearance		Black		
		Available colors		
Forms		Particle		
Processing Method		Injection molding		
Multi-Point Data		Isothermal Stress vs. Strain (ISO 11403-1)		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.68	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.10 - 0.30	--	%	Internal method
Water Absorption				
23°C, 24 hr	0.30	--	%	ISO 62
Balance, 50% RH	1.0	--	%	Internal method

Equilibrium, 65% RH	1.3	--	%	Internal method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	20000	--	MPa	ISO 527-2
Tensile Stress (Yield)	230	--	MPa	ISO 527-2
Tensile Strain (Break)	1.9	--	%	ISO 527-2
Flexural Modulus	18500	15500	MPa	ISO 178
Flexural Stress	330	240	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	9.3	--	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	48	--	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	227	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Constant ¹ (2.40 GHz)	4.44	--		ASTM D2520
Dissipation Factor ² (2.40 GHz)	0.012	--		ASTM D2520
Comparative Tracking Index (CTI) (3.00 mm)	> 600	--	V	UL 746
Comparative Tracking Index (CTI) (3.00 mm)	PLC 0	--		UL 746
Comparative Tracking Index	> 600	--	V	IEC 60112
High Amp Arc Ignition (HAI)				UL 746
0.400 mm	37.6	--		UL 746
0.750 mm	53.6	--		UL 746
1.50 mm	70.2	--		UL 746
3.00 mm	95.4	--		UL 746
High Amp Arc Ignition (HAI)				UL 746
0.400 mm	PLC 2	--		UL 746
0.750 mm	PLC 2	--		UL 746
1.50 mm	PLC 1	--		UL 746
3.00 mm	PLC 1	--		UL 746
High Voltage Arc Resistance to Ignition (HVAR) (3.00 mm)	PLC 0	--		UL 746
High Voltage Arc Tracking Rate (HVTR) (3.00 mm)	PLC 0	--		UL 746
Hot-wire Ignition (HWI)				UL 746
0.400 mm	95	--	sec	UL 746
0.750 mm	> 120	--	sec	UL 746

1.50 mm	> 120	--	sec	UL 746
3.00 mm	> 120	--	sec	UL 746
Hot-wire Ignition (HWI)				UL 746
0.400 mm	PLC 1	--		UL 746
0.750 mm	PLC 0	--		UL 746
1.50 mm	PLC 0	--		UL 746
3.00 mm	PLC 0	--		UL 746
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating ³ (mm, colored)	V-0	--		UL 94
Glow Wire Ignition Temperature				IEC 60695-2-13
0.400 mm	775	--	°C	IEC 60695-2-13
0.750 mm	800	--	°C	IEC 60695-2-13
1.50 mm	825	--	°C	IEC 60695-2-13
3.00 mm	850	--	°C	IEC 60695-2-13
Oxygen Index	37	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	100		°C	
Drying Time	1.0 - 3.0		hr	
Rear Temperature	250 - 260		°C	
Front Temperature	260 - 290		°C	
Processing (Melt) Temp	280		°C	
Mold Temperature	120 - 140		°C	

Injection instructions

热流道系统:250 °C~260 °C (482°F~500 °F) 射出压力:快速 干燥: 该树脂应该干燥~要求的0.10% 含湿率. 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 1~2小时, 100°C C(212°F)温度下2~4小时,或80 °C(176 °F)温度下2-8小时. 注塑成型: IXEF1524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,背压尽可能低. 测得的熔融温度应该在270°C (518° 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~275°C (500~527 °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,容易使产品产生翘曲,外观不良,并极可能产生蠕变.射出压力应确保快速射出.调整保压压力和时间,尽量提高零件的重量.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. Method B
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3. These flammability ratings do not represent the risk of these materials or any other materials in actual fire situations.

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