

Ixef® BM-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			
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	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.69	g/cm ³	ISO 1183
Water Absorption (Balanced, 65% RH)	0.28	%	ISO 62
Mold shrinkage-Flow	0.10 - 0.30	%	Internal method
Comparative Tracking Index	PLC 0		UL 746
Vertical combustion-60 seconds (8.89cm) ¹	5.0	sec	DMS 1510
Toxic gas emission			BSS 7239/ATS 1000/ABD 0031

CO	100	ppm	BSS 7239/ATS 1000/ABD 0031
HCL		ppm	BSS 7239/ATS 1000/ABD 0031
HCN	15	ppm	BSS 7239/ATS 1000/ABD 0031
HF		ppm	BSS 7239/ATS 1000/ABD 0031
NO + NO2		ppm	BSS 7239/ATS 1000/ABD 0031
SO2		ppm	BSS 7239/ATS 1000/ABD 0031
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	20000	MPa	ISO 527-2
Tensile Strength (Yield)	248	MPa	ASTM D638
Tensile Elongation (Break)	2.3	%	ASTM D638
Flexural Modulus	19300	MPa	ASTM D790
Flexural Strength (Yield)	376	MPa	ASTM D790
Compressive Modulus	16500	MPa	ASTM D695
Compressive Strength	328	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	227	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Dielectric Constant ² (2.40 GHz)	4.44		ASTM D2520
Dissipation Factor ³ (2.40 GHz)	0.012		ASTM D2520
Comparative Tracking Index (CTI) (3.00 mm)	> 600	V	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
0.40 mm	PLC 2		UL 746
0.75 mm	PLC 2		UL 746
1.5 mm	PLC 1		UL 746
3.0 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
0.40 mm	PLC 1		UL 746
0.75 mm	PLC 0		UL 746
1.5 mm	PLC 0		UL 746
3.0 mm	PLC 0		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating ⁴ (0.40 mm, ALL)	V-0		UL 94
Glow Wire Ignition Temperature			IEC 60695-2-13
0.40 mm	775	°C	IEC 60695-2-13
0.75 mm	800	°C	IEC 60695-2-13
1.5 mm	825	°C	IEC 60695-2-13
3.0 mm	850	°C	IEC 60695-2-13
Oxygen Index	37	%	ISO 4589-2
Injection	Nominal Value	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.	DMS 1510/14 CFR 25.853 Appendix F Part 1, (a), 1, (i)		
2.	Method B		
3.	Method B		
4.	These flammability ratings are not intended to reflect hazards presented by these or any other materials under actual fire conditions.		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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