

Ixef® 1622

Polyarylamide
Solvay Specialty Polymers

Message:

Ixef 1622 is 50% glass fiber reinforced impact modified polyacrylamide. It has very high strength and rigidity, excellent surface gloss and excellent impact resistance. -natural color: Ixef 1622/0003
black: Ixef 1622/9003
customers can color by themselves

General Information	
UL YellowCard	E95746-481133
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight
Additive	Impact modifier
Features	Good dimensional stability
	Impact modification
	Excellent appearance
	Low hygroscopicity
	Rigidity, high
	High strength
	Good creep resistance
	High liquidity
	Good chemical resistance
Uses	Lawn and Garden Equipment
	Gear
	Electrical/Electronic Applications
	Electrical housing
	Electrical appliances
	Power/other tools
	Industrial application
	Machine/mechanical parts
	Home appliance components
	Furniture
	Metal substitution
	Automotive Electronics
	Application in Automobile Field
	Business equipment
	Shell
	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)		
		Secant Modulus vs. Strain (ISO 11403-1)		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.60	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.10 - 0.30	--	%	Internal method
Water Absorption				
23°C, 24 hr	0.19	--	%	ISO 62
Equilibrium, 65% RH	1.5	--	%	Internal method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	17000	16000	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield	--	200	MPa	ISO 527-2
Fracture	235	--	MPa	ISO 527-2
Tensile Strain (Break)	2.6	2.7	%	ISO 527-2
Flexural Modulus	17000	--	MPa	ISO 178
Flexural Stress	360	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	120	--	J/m	ASTM D256
Unnotched Izod Impact	1100	--	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Annealed)	220	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Dielectric Strength	25	--	kV/mm	IEC 60243-1
Dielectric Constant ²				ASTM D2520
1.00 GHz	4.23	--		ASTM D2520
2.40 GHz	4.27	--		ASTM D2520
Dissipation Factor ³				ASTM D2520
1.00 GHz	9.5E-3	--		ASTM D2520
2.00 GHz	9.5E-3	--		ASTM D2520
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (> 0.600 mm)	HB	--		UL 94
Oxygen Index	25	--	%	ISO 4589-2
Additional Information				

干燥

除非另有说明,常规数据均由干燥样品提取(也称DAM,即干燥成型)样本.对于空调环境数据,样品在50%相对湿度下测试.

Injection	Dry	Unit
Drying Temperature	120	°C
Drying Time	0.50 - 1.5	hr
Rear Temperature	250 - 260	°C
Front Temperature	260 - 280	°C
Processing (Melt) Temp	270	°C
Mold Temperature	120 - 140	°C

Injection instructions

射出压力:快速 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 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: IXEF1622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. Su Wei internal procedure,
pressure 750 bars (10.9
kpsi), sample 40mm x
20mm x 2-4mm. (1.6 in. x
0.8 in. x 0.08-0.16 in.)
2. Method B
3. Method B

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