Ixef® 1025

Polyarylamide

Solvay Specialty Polymers

Message:

Ixef® 1025 is a 50% glass-fiber reinforced, UV stabilized polyarylamide which exhibits very high strength and rigidity, outstanding surface gloss, and excellent creep resistance.
Black: Ixef® 1025/9008

General Information	
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight
Additive	UV stabilizer
Features	Super rigidity Good dimensional stability Excellent appearance Low hygroscopicity High strength Good creep resistance High liquidity Good chemical resistance
Uses	Lawn and Garden Equipment Gear Electrical appliances Power/other tools Industrial application Machine/mechanical parts Home appliance components Furniture Metal substitution Application in Automobile Field Business equipment
RoHS Compliance	RoHS compliance
Appearance	Black
Forms	Particle
Processing Method	Injection molding
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)

Physical	Nominal Value	Unit	Test Method
Density	1.61	g/cm³	ISO 1183
Molding Shrinkage	0.10 - 0.30	%	Internal method
Water Absorption (23°C, 24 hr)	0.16	%	ISO 62

Water absorption-Equil, 65% RH	1.5	%	Internal method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	17000	MPa	ISO 527-2
Tensile Stress (Break)	230	MPa	ISO 527-2
Tensile Strain (Break)	1.9	%	ISO 527-2
Flexural Modulus	17000	MPa	ISO 178
Flexural Stress	310	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	95	J/m	ASTM D256
Unnotched Izod Impact	700	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	1.5E-5	cm/cm/°C	ISO 11359-2
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

Hot Runners: 250°C to 260°C (482°F to 500°F)StorageIxef® compounds are shipped in moisture-resistant packages at moisture levels according to specifications. Sealed, undamaged bags should be preferably stored in a dry room at a maximum temperature of 50°C (122°F) and should be protected from possible damage. If only a portion of a package is used, the remaining material should be transferred into a sealable container. It is recommended that Ixef® resins be dried prior to molding following the recommendations found in this datasheet and/or in the Ixef® processing guide.DryingThe material as supplied is ready for molding without drying. However, If the bags have been open for longer than 24 hours, the material needs to be dried. When using a desiccant air dryer with dew point of -28°C (-18°F) or lower, these guidelines can be followed: 0.5-1.5 hour at 120°C (248°F), 1-3 hours at 100°C (212°F), or 1-7 hours at 80°C (176°F).Injection MoldingIXEF 1025 compound can be readily injection molded in most screw injection molding machines. A general purpose screw is recommended, with minimum back pressure.The measured melt temperature should be about 280°C (536°F), and the barrel temperatures should be around 250°C to 260°C (482°F to 500°F) in the rear zone, gradually increasing to 260°C to 290°C (500°F to 554°F) in the front one. If hot runners are used, they should be set to 250°C to 60°C (482°F to 500°F).To maximize crystallinity, the temperature of the mold cavity surface must be held between 120°C and 140°C (248°F and 84°F). Molding at lower temperatures will produce articles hat may warp, have poor surface appearance, and have a greater tendency to creep. et injection pressure to give rapid injection. Adjust holding pressure and hold time to maximize part weight. Transfer from injection to hold pressure at the screw position just before the part is completely filled (95% to 99%).

NOTE

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

Recommended distributors for this material

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