# Prime Tuff-X 200 HG

### Unspecified

#### Primex Plastics Corporation

#### Message:

Prime Tuff-X 200 HG offers the same great benefit as our Tuff-X 200 but also has a very high gloss before and after forming. Using the Gardner Gloss Meter at 60° angle gloss levels of 85 to 90 have been obtained after forming.

Applications:

This combination of materials is ideal for such applications as automotive, power tools, irrigation, fluid handling, lawn and garden, electronics, RV Interior and exterior parts.

Processing:

Prime Tuff-X 200 HG is a Semi-crystalline material that behaves differently in the thermoforming process when compared to an amorphous material like HIPS or ABS. Ideal forming conditions; mold temp. 170-190°F, Sheet temp. 320-360°F, part removal temp. 145-170°F. Aluminum temperature controlled grit blasted tools are preferred. Ceramic tools also work well if glass bead blasted. Quartz or ceramic heaters are preferred when working with Tuff-X. Calrod heaters may sometimes be used but gas fired ovens are not recommended.

Finishing:

Prime Tuff-X 200 HG can be fabricated by using the same method as the Prime Tuff-X 200. It may also be bonded by using certain adhesives. Prime Tuff-X 200 HG has a high gloss that can even improve in the thermoforming process if properly heated. Scratch and mar issues can be repaired on the gloss surface.

Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.

Colors, Textures and Capabilities:

Prime Tuff-X 200 HG is capable of accepting any color. The substrate may be color matched or a field of color. Both the cap and the substrate are capable of holding < 1.5 Delta E. Tuff-X 200 HG is offered in gauges ranging from .090 to .400 in. and widths up to 120". There are several different patterns available, however, typically this product is used when a smooth high-gloss appearance is required.

General Information					
Features	Good Chemical Resistance				
	Good Colorability				
	Good UV Resistance				
	High Gloss				
	High Heat Resistance				
	High Impact Resistance				
	High Tensile Strength Low Temperature Impact Resistance				
	Semi Crystalline				
Uses	Automotive Applications				
	Electrical/Electronic Applications				
	Lawn and Garden Equipment				
	Power/Other Tools				
	Sporting Goods				
Appearance	Colors Available				
Forms	Sheet				
Processing Method	Thermoforming				
Physical	Nominal Value	Unit	Test Method		
Specific Gravity	1.06	g/cm³	ASTM D792		

Melt Mass-Flow Rate (MFR)	1.1	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	67		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	20.2	MPa	ASTM D638
Flexural Modulus	1670	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	720	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45			
MPa, Unannealed)	102	°C	ASTM D648
CLTE - Flow	4.9E-5	cm/cm/°C	ASTM D696
Additional Information	Nominal Value	Unit	
De-mold Temperature	63 to 77	°C	
Mold Temperature (other)	77 to 88	°C	
Sheet Temperature	160 to 182	°C	

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#### Recommended distributors for this material

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