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IXEF 1002 is a 30% glass-fiber reinforced, general purpose polyarylamide compound which exhibits high strength and rigidity, outstanding surface finish, and excellent creep resistance.

The IXEF family of materials consists of polyarylamide resins compounded with glass fibers, minerals, and other additives. The compounds in this family are characterized by high strength and stiffness, creep resistance at high

stress levels, high flow, low moisture pickup, excellent dimensional stability, and excellent surface quality and gloss. They can be easily processed on conventional injection molding equipment.

Typical Properties of IXEF 1002 Compound

Property	Test Method	Typical Values ⁽¹⁾					
		SI Units			U.S. Customary Units		
		DAM ⁽²⁾	50% RH	Units	DAM ⁽²⁾	50% RH	Units
Mechanical							
Tensile Strength	ISO 527	190		MPa	27.6		kpsi
Tensile Elongation	ISO 527	2.0		%	2.0		%
Tensile Modulus	ISO 527	11.5		GPa	1.67		Mpsi
Flexural Strength	ISO 178	285		MPa	41.3		kpsi
Flexural Modulus	ISO 178	11.5		GPa	1.67		Mpsi
Izod Impact, Notched	ASTM D 256	70		J/m	1.3		ft-lb/in
Izod Impact, Unnotched	ASTM D 256	460		J/m	9		ft-lb/in
Thermal							
Heat Deflection Temperature	ISO 75A	230		°C	446		°F
Coefficient of Thermal Expansion	ISO 11395	18		10 ⁻⁶ K ⁻¹	10		10 ⁻⁶ in/in°F
Flammability ⁽³⁾	UL 94	HB			HB		
Limiting Oxygen Index	ISO 4589	25		%	25		%
Electrical							
Dielectric Strength	IEC 243	30		kV/mm	762		V/mil
Volume Resistivity	IEC 93/167	10 ¹³		ohm-cm	10 ¹³		ohm-cm
Comparative Tracking Index (CTI)	IEC 112	400		V	400		V
Dielectric Constant at 100 Hz	IEC 250	3.9			3.9		
Dielectric Loss Angle at 100 Hz	IEC 250	.010			.010		
General							
Specific Gravity	ISO 1183	1.43			1.43		
Reinforcement Content		30		%	30		%
Moisture Absorption, 24 hr.	ISO 62	0.20		%	0.20		%
Moisture Absorption (Equil) 65% RH	Solvay	1.9		%	1.9		%
Mold Shrinkage in Flow Direction ⁽⁴⁾	Solvay	0.1-0.4		%	0.1-0.4		%

(1) Actual properties of individual batches will vary within specification limits. Properties are typical of uncolored resin. Colorants or other additives will alter values.

(2) Dry as molded.

(3) These flammability ratings are not intended to reflect hazards presented by these or any other materials under actual fire conditions.

(4) Solvay Internal procedure, Pressure 750 bars (10.9 kpsi); specimen 40 mm x 20 mm x 2-4 mm. (1.6 in. x 0.8 in. x 0.08-0.16 in.)

Drying

The 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 Molding

IXEF 1002 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 to 260°C (482 to 500°F) in the rear zone, gradually increasing to 260 to 290°C (500 to 554°F) in the front zone. If hot runners are used, they should be set to 250 to 260°C (482 to 500°F).

To maximize crystallinity, the temperature of the mold cavity surface must be held between 120 and 140°C (248 and 284°F). Molding at lower temperatures will produce articles that may warp, have poor surface appearance, and have a greater tendency to creep.

Set 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 (95-99%).

Standard Packaging and Labeling

IXEF 1002 compound is packaged in foil lined, multiwall paper bags containing 25 kg (55.115 pounds) of material. Special packaging can be supplied upon request.

Individual packages will be plainly marked with the product number, the color, the lot number, and the net weight.

Product Safety and Emergency Service

For product safety information or a Material Safety Data Sheet on a product of Solvay Advanced Polymers

1 (800) 621-4557

1 (770) 772-8880 outside of U.S.

For information or help in an emergency such as a spill, leak, fire or explosion, call day or night:

Emergency Health Information

1 (800) 621-4590 or

1 (770) 772-5177 outside of U.S.

Emergency Spill Information

CHEMTREC 1 (800) 424-9300

**1 (703) 527-3887 outside of U.S.
collect calls accepted**

For Additional Information

Europe

+49 211 513 590 00 (Germany)

USA and rest of world

Technical Service

1 (800) 621-4557 or

1 (770) 772-8760 outside of U.S.

Customer Service

1 (800) 848-9744 or

1 (770) 772-8762 outside of U.S.

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