

1524

IXEF 1524 is a 50% glass-fiber reinforced, halogen-free flame retardant polyarylamide which exhibits high strength and stiffness, good surface gloss, and excellent creep resistance. The color of this grade is natural (cream).

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 1524 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	230		MPa	33300		psi
Tensile Elongation	ISO 527	1.9		%	1.9		%
Tensile Modulus	ISO 527	20		GPa	2900		kpsi
Flexural Strength	ISO 178	330	240	MPa	47900	34800	psi
Flexural Modulus	ISO 178	18.5	15.5	GPa	2680	2250	kpsi
Charpy Impact, Notched	ISO 179/1eA	9.3		kJ/m ²	4.4		ft-lb/in ²
Charpy Impact, Unnotched	ISO 179/1eU	48		kJ/m ²	23		ft-lb/in ²
Thermal							
Heat Deflection Temperature	ISO 75A	227		°C	441		°F
Flammability ⁽⁴⁾ at 1.6 mm	UL 94	V-0			V-0		
Flammability ⁽⁴⁾ at 0.8 mm	UL 94	V-0			V-0		
Flammability ⁽⁴⁾ at 1.6 mm	UL 94 - 500 W	5VB			5VB		
Limiting Oxygen Index	ISO 4589	37		%	37		%
Electrical							
Glow Wire	IEC 695-2-1	960		°C	1760		°F
Comparative Tracking Index (CTI)	IEC 112	>600		V	>600		V
General							
Specific Gravity	ISO 1183	1.68			1.68		
Reinforcement Content		50		%	50		%
Moisture Absorption, 24 hr.	ISO 62	0.3		%	0.3		%
Moisture Absorption (Equil) 50% RH	Solvay	1.0		%	1.0		%
Moisture Absorption (Equil) 65% RH	Solvay	1.3		%	1.3		%
Mold Shrinkage in Flow Direction ⁽³⁾	Solvay	0.1-0.3		%	0.1-0.3		%

⁽¹⁾ Actual properties of individual batches will vary within specification limits.

⁽²⁾ Dry as molded.

⁽³⁾ 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.)

⁽⁴⁾ Tests run by Solvay according to UL Standards.

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 1524 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 1524 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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