Product Data

IXEF® polyarylamide

2060

IXEF 2060 is a 55% reinforced, general purpose polyarylamide compound. This compound exhibits improved vibration resistance, low warpage, and excellent surface finish. This grade has excellent properties in the transverse direction.

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 and slow 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® 2060 Compound

		Typical Values (1)			
	Test	SI Units		U.S. Customary Units	
Property	Method	DAM(2)	Units	DAM(2)	Units
Mechanical					
Tensile Strength	ISO 527	180	MPa	26.1	kpsi
Tensile Elongation	ISO 527	1.5	%	1.5	%
Tensile Modulus	ISO 527	19	GPa	2.76	Mpsi
Flexural Strength	ISO 178	270	MPa	39.2	kpsi
Flexural Modulus	ISO 178	18	GPa	2.61	Mpsi
Weldline Tensile Strength	ISO 527	80	MPa	11.6	kpsi
Charpy, Notched	ISO 179	4.4	kJ/m^2	2.1	$ft\text{-}lb/in^2$
Charpy, Unnotched	SO 179	28	kJ/m^2	13	$ft\text{-}lb/in^2$
General					
Specific Gravity	ISO 1183	1.7		1.7	
Reinforcement Content		55	%	55	%
Moisture Absorption, 24 hr.	ISO 62	0.10	%	0.10	%
Moisture Absorption (Equil) 65% RH	Solvay	1.2	%	1.2	%
Mold Shrinkage in Flow Direction	Solvay	0.15-0.25	%	0.15-0.25	%
Mold Shrinkage inTransverse Direction	Solvay	0.25-0.45	%	0.25-0.45	%

(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.

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 2060 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 between 265-275°C (477-495°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 betwween 120 to 140°C (248 and 284°F). Molding at a lower temperature 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 2060 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.