



## Technical Data Sheet

# Ixef® 1622

## polyarylamide

Ixef® 1622 is an impact modified, 50% glass-fiber reinforced polyarylamide. which exhibits very high strength and rigidity, outstanding surface gloss, and excellent impact resistance.

- Natural: Ixef® 1622/0003
- Black: Ixef® 1622/9003
- Custom Colorable

### General

Material Status	• Commercial: Active	
Availability	• Africa & Middle East • Asia Pacific • Europe	• Latin America • North America
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight	
Additive	• Impact Modifier	
Features	• Chemical Resistant • Creep Resistant • Good Dimensional Stability • High Flow • High Stiffness	• High Strength • Impact Modified • Low Moisture Absorption • Outstanding Surface Finish
Uses	• Appliance Components • Appliances • Automotive Applications • Automotive Electronics • Business Equipment • Camera Applications • Electrical Housing • Electrical/Electronic Applications	• Furniture • Gears • Housings • Industrial Applications • Lawn and Garden Equipment • Machine/Mechanical Parts • Metal Replacement • Power/Other Tools
RoHS Compliance	• RoHS Compliant	
Appearance	• Black • Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Dry	Conditioned	Unit	Test method
Density	1.60	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage - Flow <sup>1</sup>	0.10 to 0.30	--	%	Internal Method
Water Absorption				
24 hr, 23°C	0.19	--	%	ISO 62
Equilibrium, 65% RH	1.5	--	%	Internal Method

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Mechanical	Dry	Conditioned	Unit	Test method
Tensile Modulus	17000	16000	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield	--	200	MPa	
Break	235	--	MPa	
Tensile Strain (Break)	2.6	2.7	%	ISO 527-2
Flexural Modulus	17000	--	MPa	ISO 178
Flexural Stress	360	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test method
Notched Izod Impact	120	--	J/m	ASTM D256
Unnotched Izod Impact	1100	--	J/m	ASTM D4812
Thermal	Dry	Conditioned	Unit	Test method
Heat Deflection Temperature				ISO 75-2/A
1.8 MPa, Annealed	220	--	°C	
Electrical	Dry	Conditioned	Unit	Test method
Electric Strength	25	--	kV/mm	IEC 60243-1
Dielectric Constant <sup>2</sup>				ASTM D2520
1.00 GHz	4.23	--		
2.40 GHz	4.27	--		
Dissipation Factor <sup>2</sup>				ASTM D2520
1.00 GHz	9.5E-3	--		
2.00 GHz	9.5E-3	--		
Flammability	Dry	Conditioned	Unit	Test method
Flame Rating (> 0.60 mm)	HB	--		UL 94
Oxygen Index	25	--	%	ISO 4589-2

### Additional Information

Dry Unless otherwise specified, Typical Values are obtained from Dry (also called DAM, Dry as Molded) samples. For Conditioned data, samples are tested at 50% Relative Humidity.

Injection	Dry	Unit
Drying Temperature	120	°C
Drying Time	0.50 to 1.5	hr
Rear Temperature	250 to 260	°C
Front Temperature	260 to 280	°C
Processing (Melt) Temp	270	°C
Mold Temperature	120 to 140	°C

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### Injection Notes

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Hot Runners: 250°C to 260°C (482°F to 500°F)

Injection Pressure: rapid

### Storage

Ixef® 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.

### 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

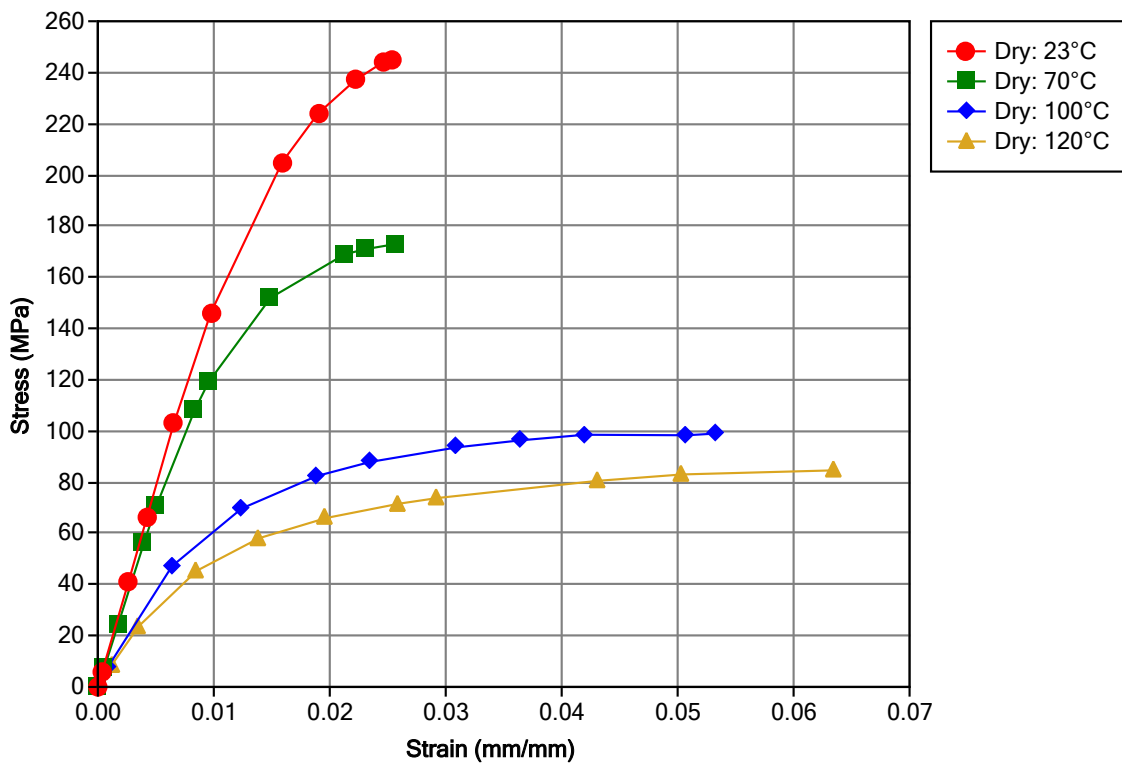
IXEF 1622 compound can be readily injection molded in most screw injection molding machines. A general purpose screw is recommended, with minimum back pressure.

The measured melt temperature should be about 270°C (518°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 280°C (500°F to 536°F) in the front zone. If hot runners are used, they should be set to 250°C to 260°C (482°F to 500°F).

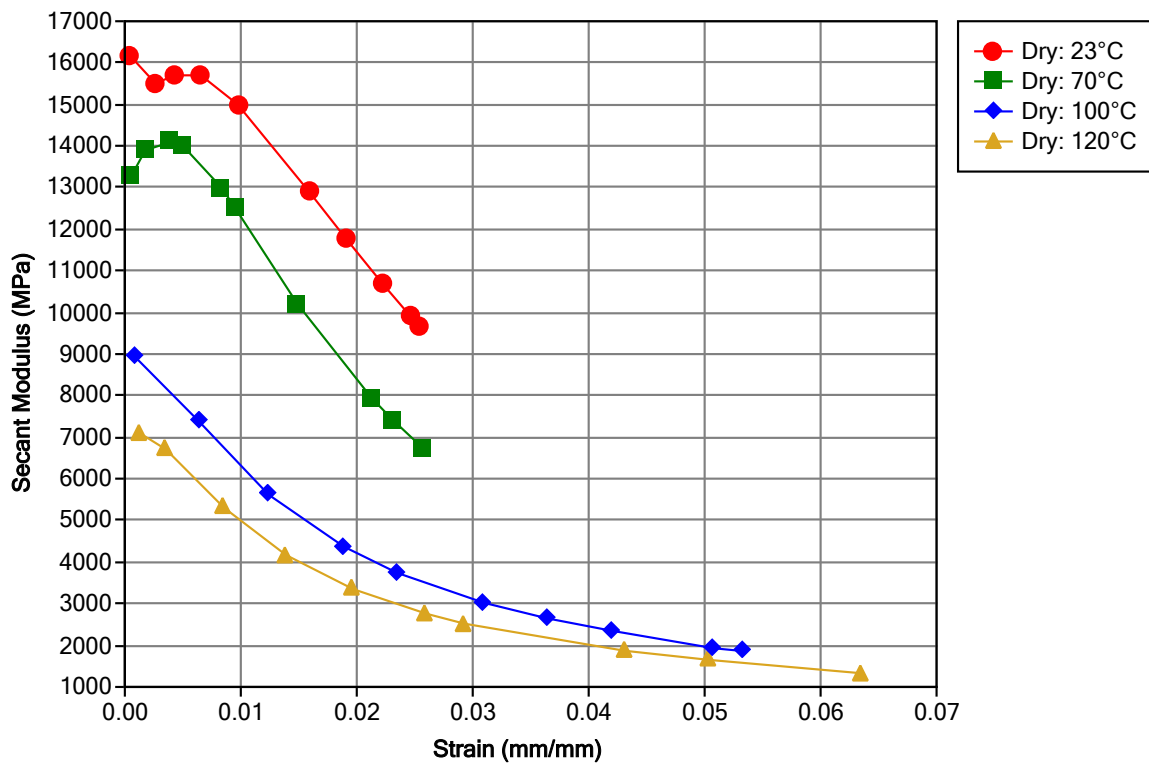
To maximize crystallinity, the temperature of the mold cavity surface must be held between 120°C and 140°C (248°F and 284°F). Molding at lower temperatures will produce articles that may warp, have poor surface appearance, and have a greater tendency to creep. Set injection pressure to give rapid injection.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

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Isothermal Stress vs. Strain (ISO 11403-1)



Secant Modulus vs. Strain (ISO 11403-1)



## Notes

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Typical properties: these are not to be construed as specifications.

<sup>1</sup> 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.)

<sup>2</sup> Method B



Progress beyond

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