



Prime Super Tuff-X

Prime Super Tuff-X:

Is an engineered alloy that offers very high stiffness when rigidity is important. Prime Super Tuff-X has a very low C.L.T.E., excellent cold temperature impact, UV protection, improved rigidity and is highly chemical resistant.

Applications:

Ideal for : marine, automotive, power tools, electronics, lawn and garden and RV applications.

Processing:

Prime Super Tuff-X is a semi-crystalline material that behaves differently in the thermoforming process when compared to an amorphous material. 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 can also work well if they are glass bead blasted. Quartz or ceramic heaters are preferred when working with Tuff-X. Calrod heaters can sometimes be used but gas fired is not recommended. Mold Shrink is .007-.009 in/in in the MD, less in the TD.



Prime Tuff-X	Very High	High
Impact Strength	*	
Low Temperature Impact Strength	*	
Tensile Strength		*
Flexural Modulus	*	
Heat Deflection Temperature		*



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Finishing:

Super Tuff-X can be fabricated by using many techniques such as; drilling, routing, punching, sawing, laser or die cut. Mechanical screws and other types of fasteners may be used to join Tuff-X parts together. It may also be bonded with certain types of adhesives.

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

Colors, Textures and Capabilities:

Our Super Tuff-X material will accept any color. This product can also be painted with a two-part paint system. Tuff-X is offered in gauges from .090 to .400 in. and in widths up to 120". Super Tuff-X is offered in several different patterns that include; FL/HC, H/C, Diamond Plate, Smooth and Levant II.

Property	Test Method	Value	Unit
Specific Gravity	D 792	1.09	g/cc
Melt Flow	D 1238	1.7	g/10min
Flex Modulus	D 790	390,000	psi
Tensile @ Yield	D 638	3400	psi
Elongation	D 638	400	%
Multiaxial Impact @ 72 °F	D 3763	15.12	ft-lb/in
Multiaxial Impact @ 32 °F	D 3763	19.18	ft-lb/in
Gardner Impact @ - 30 °C	ISO 75 Edgewise	320	ft-lb/in
HDT @ 66 psi	D 648	215	°F
HDT @ 264 psi	D648	133	°F
CLTE	696 Modified	2.58x10 ⁻⁵	in/in/°F

Complies with UL 94 HB at thickness >1.5 mm

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