



Prime Tuff-X HG

Prime Tuff-X HG:

This product offers the same great benefit as our Tuff-X but also has a very high gloss before and after forming. Using the Gardner Gloss Meter at 60° angle gloss levels of 85 to 90 have been obtained after forming.

Applications:

This combination of materials is ideal for such applications as automotive, power tools, irrigation, fluid handling, lawn and garden, electronics, RV interior and exterior parts.



Processing:

Prime Tuff-X HG 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 also work well if glass bead blasted. Quartz or ceramic heaters are preferred when working with Tuff-X. Calrod heaters may sometimes be used but gas fired ovens are not recommended. Mold Shrink Is .009-.012 in/in in the MD, less in the TD.

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



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Finishing:

Prime Tuff-X HG can be fabricated by using the same method as the Prime Tuff-X. It may also be bonded by using certain adhesives. Prime Tuff-X HG has a high gloss that can even improve in the thermoforming process if properly heated. Scratch and mar issues can be repaired on the gloss surface.

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

Colors, Textures and Capabilities:

Prime Tuff-X HG is capable of accepting any color. The substrate may be color matched or a field of color. Both the cap and the substrate are capable of holding < 1.5 Delta E. Tuff-X HG is offered in gauges ranging from .090 to .400 in. and widths up to 120". There are several different patterns available, however, typically this product is used when a smooth high-gloss appearance is required.

Property	Test Method	Value	Unit
Melt Flow	D1238	1.7	g/10 min
Specific Gravity	D792	1.03	
Tensile @ Yield	D638	3749	psi
Hardness, Shore D	D2240	59	
Notched Izod @ 73 °F	D256	8.1	ft-lb/in
HDT @ 66 psi	D648	244	°F
Flexural Modulus	D790	260,700	psi
Flexural Strength	D638	4100	psi
Mold Shrink		.0133	in/in
CLTE	D696	3.32 x10 ⁻⁵	in/in/°F

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