GELOY™ RESIN FXTW26SK

REGION ASIA

DESCRIPTION

ASA, Xtreme weatherability, high heat, with VisualFx.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	46	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	37	MPa	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	43	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	36	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	2.7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	17	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	18	%	ASTM D 638
Tensile Modulus, 5 mm/min	2460	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	74	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2570	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	36	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.8	%	ISO 527
Tensile Strain, break, 50 mm/min	24	%	ISO 527
Tensile Modulus, 1 mm/min	2450	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	64	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	140	J/m	ASTM D 256
Izod Impact, notched, -30°C	23	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	18	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	2	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	97	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	84	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	9.4E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	95	°C	ISO 306
Vicat Softening Temp, Rate B/120	99	°C	ISO 306

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	84	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.11	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.4 – 0.7	%	SABIC method
Melt Flow Rate, 220°C/10.0 kgf	12	g/10 min	ASTM D 1238
Density	1.11	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	13	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	85 – 90	°C	
Drying Time	4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.04	%	
Melt Temperature	240 – 270	°C	
Nozzle Temperature	220 – 255	°C	
Front - Zone 3 Temperature	230 – 260	°C	
Middle - Zone 2 Temperature	220 – 255	°C	
Rear - Zone 1 Temperature	215 – 250	°C	
Mold Temperature	60 – 85	°C	
Back Pressure	0.3 – 1	MPa	
Screw Speed	30 – 80	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.038 – 0.076	mm	

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