GELOY™ RESIN FXW751SK

REGION ASIA

DESCRIPTION

Sparkle Metallic VisualFx ASA+PC Resin - Weatherable, High Heat & Impact Resin

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	48	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	49	%	ASTM D 638
Tensile Modulus, 5 mm/min	2680	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	95	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2750	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	48	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.2	%	ISO 527
Tensile Strain, break, 50 mm/min	77	%	ISO 527
Tensile Modulus, 1 mm/min	2900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	78	MPa	ISO 178
Flexural Modulus, 2 mm/min	2700	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	170	J/m	ASTM D 256
Izod Impact, notched, -30°C	50	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	43	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	17	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	17	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	105	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	89	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	108	°C	ISO 306
Vicat Softening Temp, Rate B/120	109	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	93	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.16	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Flow Rate, 220°C/10.0 kgf	8.3	g/10 min	ASTM D 1238
Density	1.16	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.25	%	ISO 62
Melt Volume Rate, MVR at 220°C/10.0 kg	7	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	95 – 105	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.04	%	
Melt Temperature	260 – 275	°C	
Nozzle Temperature	245 – 265	°C	
Front - Zone 3 Temperature	250 – 265	°C	
Middle - Zone 2 Temperature	245 – 260	°C	
Rear - Zone 1 Temperature	240 – 255	°C	
Mold Temperature	55 – 70	°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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