GELOY™ RESIN XTWE270M

REGION ASIA

DESCRIPTION

ASA, extrusion grade, low gloss, excellent weatherability.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	36	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	32	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	38	%	ASTM D 638
Tensile Modulus, 5 mm/min	1910	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	56	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1830	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	36	MPa	ISO 527
Tensile Stress, break, 50 mm/min	26	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.4	%	ISO 527
Tensile Strain, break, 50 mm/min	28	%	ISO 527
Tensile Modulus, 1 mm/min	1790	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	56	MPa	ISO 178
Flexural Modulus, 2 mm/min	1870	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	195	J/m	ASTM D 256
Izod Impact, notched, -30°C	70	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	28	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	13	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	12	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	85	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	69	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.09E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.16E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	82	°C	ISO 306
Vicat Softening Temp, Rate B/120	85	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	71	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.3 – 0.7	%	SABIC method

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Flow Rate, 220°C/10.0 kgf	9.7	g/10 min	ASTM D 1238
Density	1.09	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.8	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 220°C/5.0 kg	2	cm³/10 min	ISO 1133
PROFILE EXTRUSION			
Drying Temperature	85 – 95	°C	
Drying Time	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	190 – 210	°C	
Barrel - Zone 1 Temperature	180 – 200	°C	
Barrel - Zone 2 Temperature	180 – 200	°C	
Barrel - Zone 3 Temperature	180 – 205	°C	
Barrel - Zone 4 Temperature	180 – 205	°C	
Hopper Temperature	60 – 80	°C	
Adapter Temperature	180 – 205	°C	
Die Temperature	185 – 205	°C	
Calibrator Temperature	50 – 70	°C	

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