

GELOY™ RESIN XP4020R

REGION ASIA

DESCRIPTION

ASA+PC may contain up to 20% post-industrial recycle. Excellent flow, weatherability, toughness and high heat for exterior uses.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	44	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	36	%	ASTM D 638
Tensile Modulus, 50 mm/min	3030	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2550	MPa	ASTM D 790
Hardness, Rockwell R	111	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	304	J/m	ASTM D 256
Izod Impact, notched, -30°C	69	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	33	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	22	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	121	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	106	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	90	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.1E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.13	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.6	%	SABIC method
Melt Flow Rate, 220°C/10.0 kgf	10	g/10 min	ASTM D 1238
Melt Flow Rate, 230°C/3.8 kgf	21.6	g/10 min	ASTM D 1238
OPTICAL			
Gloss, untextured, 60 degrees	98	-	ASTM D 523
FLAME CHARACTERISTICS			
FMVSS Burning Speed, thickness 1 mm	39	mm/min	FMVSS 302
INJECTION MOLDING			
Drying Temperature	90 – 100	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.04	%	
Melt Temperature	255 – 270	°C	
Nozzle Temperature	240 – 255	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	245 – 260	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 250	°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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