GELOY™ FXW751SK resin

Acrylonitrile Styrene Acrylate + PC

SABIC Innovative Plastics

Message:

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

General Information			
Features	Impact resistance, high Good weather resistance Heat resistance, high		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.16	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.3	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	7.20	cm³/10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	1.0	%	ISO 62
Equilibrium, 23°C, 50% RH	0.25	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	2690	MPa	ASTM D638
--	2900	MPa	ISO 527-2/1
Tensile Strength			
Yield [2]	62.0	MPa	ASTM D638
Yield	60.2	MPa	ISO 527-2/50
Fracture [3]	48.0	MPa	ASTM D638
Fracture	48.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield [4]	4.2	%	ASTM D638
Yield	4.2	%	ISO 527-2/50
Fracture [5]	49	%	ASTM D638
Fracture	77	%	ISO 527-2/50
Flexural Modulus			
50.0mm span [6]	2750	MPa	ASTM D790
-- [7]	2700	MPa	ISO 178
Flexural Stress			
--	78.0	MPa	ISO 178

Yield, 50.0mm span [8]	95.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [9] (23°C)	17	kJ/m²	ISO 179/1eA
Notched Izod Impact			
-30°C	50	J/m	ASTM D256
23°C	170	J/m	ASTM D256
-30°C [10]	5.2	kJ/m²	ISO 180/1A
23°C [11]	17	kJ/m²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	43.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	89.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span [12]	93.5	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	105	°C	ASTM D1525 [13]
--	108	°C	ISO 306/B50
--	109	°C	ISO 306/B120
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	7.2E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.2E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	93.3 - 104	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	40 - 80	%	
Rear Temperature	238 - 254	°C	
Middle Temperature	243 - 260	°C	
Front Temperature	249 - 266	°C	
Nozzle Temperature	243 - 266	°C	
Processing (Melt) Temp	260 - 277	°C	
Mold Temperature	54.4 - 71.1	°C	
Back Pressure	0.345 - 1.03	MPa	
Screw Speed	30 - 80	rpm	
Vent Depth	0.038 - 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		
5.	Type 1, 50mm/min		

6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	标准 B (120°C/h), 载荷2 (50N)

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

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