

GELOY™ XTWE480 resin

Acrylonitrile Styrene Acrylate
SABIC Innovative Plastics Asia Pacific

Message:

Anti-scratch GELOY grade with excellent weatherability, high flow, and good surface quality. XTWE480 is available in various colours.

General Information			
Features	Good Surface Finish		
	Good Weather Resistance		
	High Flow		
	Scratch Resistant		
Appearance	Colors Available		
Processing Method	Profile Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	38	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.60	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Pencil Hardness ¹	F		ASTM D3363
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2470	MPa	ASTM D638
--	2300	MPa	ISO 527-2/1
Tensile Strength			
Yield ³	50.0	MPa	ASTM D638
Yield	50.0	MPa	ISO 527-2/50
Break ⁴	36.0	MPa	ASTM D638
Break	38.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁵	3.0	%	ASTM D638
Yield	3.0	%	ISO 527-2/50
Break ⁶	21	%	ASTM D638
Break	25	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁷	2060	MPa	ASTM D790
-- ⁸	2410	MPa	ISO 178
Flexural Stress			
--	70.0	MPa	ISO 178

Yield, 50.0 mm Span ⁹	70.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C	27	J/m	ASTM D256
23°C	49	J/m	ASTM D256
-30°C ¹⁰	3.0	kJ/m ²	ISO 180/1A
23°C ¹¹	5.0	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	6.50	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	73.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	73.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	78.0	°C	ASTM D1525 ¹³
--	79.0	°C	ISO 306/B50
CLTE			
Flow : -40 to 40°C	8.1E-5	cm/cm/°C	
Transverse : -40 to 40°C	8.8E-5	cm/cm/°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Cylinder Zone 1 Temp.	205 to 220	°C	
Cylinder Zone 2 Temp.	210 to 225	°C	
Cylinder Zone 3 Temp.	215 to 225	°C	
Cylinder Zone 4 Temp.	215 to 225	°C	
Adapter Temperature	200 to 225	°C	
Melt Temperature	200 to 230	°C	
Die Temperature	210 to 225	°C	
Calibration Temp, First	50.0 to 70.0	°C	
NOTE			
1.	1 kgf		
2.	50 mm/min		
3.	Type I, 50 mm/min		
4.	Type I, 50 mm/min		
5.	Type I, 50 mm/min		
6.	Type I, 50 mm/min		
7.	1.3 mm/min		
8.	2.0 mm/min		
9.	1.3 mm/min		

10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

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