

GELOY™ FXW710SK resin

Acrylonitrile Styrene Acrylate

SABIC Innovative Plastics

Message:

General purpose injection molding ASA with Visual Fx sparkle effect.

General Information			
Uses	General Purpose		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.06	g/cm ³	ASTM D792
--	1.09	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR)			ISO 1133
220°C/10.0 kg	7.00	cm ³ /10min	
260°C/5.0 kg	8.00	cm ³ /10min	
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.50 to 0.70	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Water Absorption			ISO 62
Saturation, 23°C	0.55	%	
Equilibrium, 23°C, 50% RH	0.20	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1790	MPa	ASTM D638
--	1900	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	38.0	MPa	ASTM D638
Yield	38.0	MPa	ISO 527-2/50
Break ³	30.0	MPa	ASTM D638
Break	30.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	2.5	%	ASTM D638
Yield	2.5	%	ISO 527-2/50
Break ⁵	4.0	%	ASTM D638
Break	4.0	%	ISO 527-2/50

Flexural Modulus			
50.0 mm Span ⁶	1790	MPa	ASTM D790
-- ⁷	1900	MPa	ISO 178
Flexural Stress			
--	50.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	55.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	4.0	kJ/m ²	
23°C	12	kJ/m ²	
Notched Izod Impact			
-30°C	56	J/m	ASTM D256
23°C	130	J/m	ASTM D256
-30°C ¹⁰	5.0	kJ/m ²	ISO 180/1A
23°C ¹¹	12	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	17.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 100 mm Span ¹²	88.0	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 3.20 mm	77.0	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹³	75.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	99.0	°C	ASTM D1525 ¹⁴
--	86.0	°C	ISO 306/B50
--	91.0	°C	ISO 306/B120
Ball Pressure Test (75°C)	Pass		IEC 60695-10-2
CLTE			
Flow : -40 to 40°C	8.6E-5	cm/cm/°C	ASTM E831
Flow : 23 to 60°C	9.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	9.2E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 60°C	1.0E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.040	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	210 to 240	°C	
Middle Temperature	220 to 250	°C	
Front Temperature	230 to 260	°C	
Nozzle Temperature	220 to 250	°C	
Processing (Melt) Temp	240 to 260	°C	

Mold Temperature	40.0 to 70.0	°C
NOTE		
1.	5.0 mm/min	
2.	Type I, 50 mm/min	
3.	Type I, 50 mm/min	
4.	Type I, 50 mm/min	
5.	Type I, 50 mm/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.	120*10*4 mm	
13.	120*10*4 mm	
14.	Rate B (120°C/h), Loading 2 (50 N)	

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