

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	Good Weather Resistance		
	High Heat Resistance		
	High Impact Resistance		
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 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	1.0	%	
Equilibrium, 23°C, 50% RH	0.25	%	
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
Break ³	48.0	MPa	ASTM D638
Break	48.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	4.2	%	ASTM D638
Yield	4.2	%	ISO 527-2/50
Break ⁵	49	%	ASTM D638
Break	77	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	2750	MPa	ASTM D790
-- ⁷	2700	MPa	ISO 178
Flexural Stress			
--	78.0	MPa	ISO 178

Yield, 50.0 mm Span ⁸	95.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	17	kJ/m ²	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/m ²	ISO 180/1A
23°C ¹¹	17	kJ/m ²	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, 3.20 mm	89.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm 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
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	7.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.2E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	93.3 to 104	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	40 to 80	%	
Rear Temperature	238 to 254	°C	
Middle Temperature	243 to 260	°C	
Front Temperature	249 to 266	°C	
Nozzle Temperature	243 to 266	°C	
Processing (Melt) Temp	260 to 277	°C	
Mold Temperature	54.4 to 71.1	°C	
Back Pressure	0.345 to 1.03	MPa	
Screw Speed	30 to 80	rpm	
Vent Depth	0.038 to 0.076	mm	
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.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

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