

GELOY™ CR7500 resin

Acrylonitrile Styrene Acrylate

SABIC Innovative Plastics

Message:

High heat ASA with optimum flow-impact balance. For Automotive applications and Automotive colors only.

General Information			
UL YellowCard	E207780-642462		
Features	Impact resistance, good		
	Good liquidity		
	Heat resistance, high		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.08	g/cm ³	ASTM D792
--	1.07	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	6.3	g/10 min	ASTM D1238
260°C/5.0 kg	11	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR)			ISO 1133
220°C/10.0 kg	6.60	cm ³ /10min	ISO 1133
260°C/5.0 kg	10.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1970	MPa	ASTM D638
--	2040	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	40.0	MPa	ASTM D638
Yield	43.0	MPa	ISO 527-2/5
Fracture ³	33.0	MPa	ASTM D638
Fracture	35.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	3.6	%	ASTM D638
Yield	3.3	%	ISO 527-2/5

Fracture ⁵	60	%	ASTM D638
Fracture	19	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	2170	MPa	ASTM D790
-- ⁷	2060	MPa	ISO 178
Flexural Stress			
--	64.0	MPa	ISO 178
Yield, 50.0mm span ⁸	68.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	14	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	60	J/m	ASTM D256
23°C	400	J/m	ASTM D256
-30°C ¹⁰	6.0	kJ/m ²	ISO 180/1A
23°C ¹¹	15	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	30.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	90.0	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹²	88.0	°C	ISO 75-2/Ae
1.8 MPa, unannealed, 64.0mm span ¹³	89.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	98.0	°C	ASTM D1525 ¹⁴
--	102	°C	ISO 306/B50
--	105	°C	ISO 306/B120
Ball Pressure Test ¹⁵ (98°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	8.4E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	9.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	85.0 - 95.0	°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	230 - 250	°C	
Middle Temperature	235 - 255	°C	
Front Temperature	245 - 260	°C	
Nozzle Temperature	235 - 255	°C	
Processing (Melt) Temp	255 - 270	°C	
Mold Temperature	60.0 - 85.0	°C	

Back Pressure	0.300 - 1.00	MPa
Screw Speed	30 - 80	rpm
Vent Depth	0.038 - 0.076	mm

NOTE		
1.	5.0 mm/min	
2.	Type 1, 5.0 mm/min	
3.	Type 1, 5.0 mm/min	
4.	Type 1, 5.0 mm/min	
5.	Type 1, 5.0 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.	80*10*4 mm	
14.	标准 B (120°C/h), 载荷2 (50N)	
15.	Approximate maximum	

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