

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		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	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	cm ³ /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/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, 3.20mm	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)

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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

