

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	E121562-642459		
Features	Good Flow		
	Good Impact Resistance		
	High Heat Resistance		
Uses	Automotive Applications		
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	
260°C/5.0 kg	11	g/10 min	
Melt Volume-Flow Rate (MVR)			ISO 1133
220°C/10.0 kg	6.60	cm ³ /10min	
260°C/5.0 kg	10.0	cm ³ /10min	
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.50	%	
Equilibrium, 23°C, 50% RH	0.20	%	
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
Break ³	33.0	MPa	ASTM D638
Break	35.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	3.6	%	ASTM D638
Yield	3.3	%	ISO 527-2/5

Break ⁵	60	%	ASTM D638
Break	19	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2170	MPa	ASTM D790
-- ⁷	2060	MPa	ISO 178
Flexural Stress			
--	64.0	MPa	ISO 178
Yield, 50.0 mm 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, 3.20 mm	90.0	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹²	88.0	°C	ISO 75-2/Ae
1.8 MPa, Unannealed, 64.0 mm 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
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	8.4E-5	cm/cm/°C	
Transverse : -40 to 40°C	9.5E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	85.0 to 95.0	°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	230 to 250	°C	
Middle Temperature	235 to 255	°C	
Front Temperature	245 to 260	°C	
Nozzle Temperature	235 to 255	°C	
Processing (Melt) Temp	255 to 270	°C	
Mold Temperature	60.0 to 85.0	°C	

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

NOTE

1.	5.0 mm/min
2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	Type I, 5.0 mm/min
5.	Type I, 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.	Rate B (120°C/h), Loading 2 (50 N)
15.	Approximate maximum

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