

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	E45329-642460		
Features	Impact resistance, good		
	Good liquidity		
	Heat resistance, high		
Uses	Application in Automobile Field		
RoHS Compliance	RoHS compliance		
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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