

# GELOY™ RESIN XP7550

REGION ASIA

## DESCRIPTION

PC/ASA. Excellent weatherability.

## TYPICAL PROPERTY VALUES

Revision 20190920

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	56	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	44	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	40	%	ASTM D638
Tensile Modulus, 5 mm/min	2550	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2480	MPa	ASTM D790
Hardness, Rockwell R	109	-	ASTM D785
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	44	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.8	%	ISO 527
Tensile Strain, break, 50 mm/min	37	%	ISO 527
Tensile Modulus, 1 mm/min	2550	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	74	MPa	ISO 178
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	375	J/m	ASTM D256
Izod Impact, notched, -30°C	53	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	36	J	ASTM D3763
Instrumented Dart Impact Total Energy, -30°C	10	J	ASTM D3763
Izod Impact, notched 80*10*4 +23°C	35	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	9	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	40	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	105	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	104	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	89	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.9E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.8E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	85	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	105	°C	ISO 306
Vicat Softening Temp, Rate B/120	106	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	103	°C	ISO 75/Bf

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HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	89	°C	ISO 75 /Af
<b>PHYSICAL</b>			
Specific Gravity	1.11	-	ASTM D792
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.6	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 220°C/10.0 kgf	14	g/10 min	ASTM D1238
Density	1.11	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/saturated)	0.8	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.3	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	26	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Gloss, untextured, 60 degrees	94	-	ASTM D523
<b>INJECTION MOLDING</b>			
Drying Temperature	90 – 100	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.04	%	
Melt Temperature	255 – 270	°C	
Nozzle Temperature	240 – 255	°C	
Front - Zone 3 Temperature	245 – 260	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 250	°C	
Mold Temperature	55 – 70	°C	
Back Pressure	0.3 – 1	MPa	
Screw Speed	30 – 80	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.038 – 0.076	mm	

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