



GELOY™ RESIN XTWE480

REGION ASIA

DESCRIPTION

Anti-scratch GELOY grade with excellent weatherability, high flow, and good surface quality. XTWE480 is available in various colours.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	50	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	36	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	21	%	ASTM D638
Tensile Modulus, 50 mm/min	2470	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	70	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2060	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	50	MPa	ISO 527
Tensile Stress, break, 50 mm/min	38	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	25	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	70	MPa	ISO 178
Flexural Modulus, 2 mm/min	2410	MPa	ISO 178
Pencil Hardness test, 1kgf	F	-	ASTM D3363
IMPACT			
Izod Impact, notched, 23°C	49	J/m	ASTM D256
Izod Impact, notched, -30°C	27	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	6	J	ASTM D3763
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	78	°C	ASTM D1525
HDT, 1.82 MPa, 6.4 mm, unannealed	73	°C	ASTM D648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	79	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	73	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.15	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.3 – 0.6	%	SABIC method
Melt Flow Rate, 220°C/ 10.0 kgf	38	g/10 min	ASTM D1238
Density	1.15	g/cm ³	ISO 1183
PROFILE EXTRUSION			
Drying Temperature	75 – 85	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	200 – 230	°C	
Barrel - Zone 1 Temperature	205 – 220	°C	
Barrel - Zone 2 Temperature	210 – 225	°C	
Barrel - Zone 3 Temperature	215 – 225	°C	
Barrel - Zone 4 Temperature	215 – 225	°C	
Hopper Temperature	60 – 80	°C	
Adapter Temperature	200 – 225	°C	
Die Temperature	210 – 225	°C	
Calibrator Temperature	50 – 70	°C	