



GELOY™ Resin HRA150

Europe-Africa-Middle East: COMMERCIAL

GELOY HRA150 is a high heat resistant ASA+PC. GELOY HRA150 shows high impact retention and color stability upon weathering, and hence can be positioned in various outdoor and indoor applications requiring superior weathering properties.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	125	mg/1000cy	SABIC Method
Tensile Stress, yield, 5 mm/min	55	MPa	ISO 527
Tensile Stress, break, 5 mm/min	55	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	59	MPa	ISO 527
Tensile Stress, break, 50 mm/min	59	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4	%	ISO 527
Tensile Strain, break, 5 mm/min	120	%	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	>50	%	ISO 527
Tensile Modulus, 1 mm/min	2500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
Hardness, H358/30	104	MPa	ISO 2039-1
Hardness, Rockwell R	118	-	ISO 2039-2
IMPACT			
Izod Impact, notched 80*10*4 +23°C	45	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	65	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
Ball Pressure Test, approximate maximum	105	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	119	°C	ISO 306
Vicat Softening Temp, Rate B/120	120	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	125	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	101	°C	ISO 75/Ae
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.4 - 0.6	%	SABIC Method
Density	1.15	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.6	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	15	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.9	-	IEC 60250
Dissipation Factor, 1 MHz	0.015	-	IEC 60250
Comparative Tracking Index	175	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.75	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94
Glow Wire Flammability Index 750°C, passes at	3.2	mm	IEC 60695-2-12
Oxygen Index (LOI)	20	%	ISO 4589



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 110	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	240 - 280	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	250 - 290	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 90	°C



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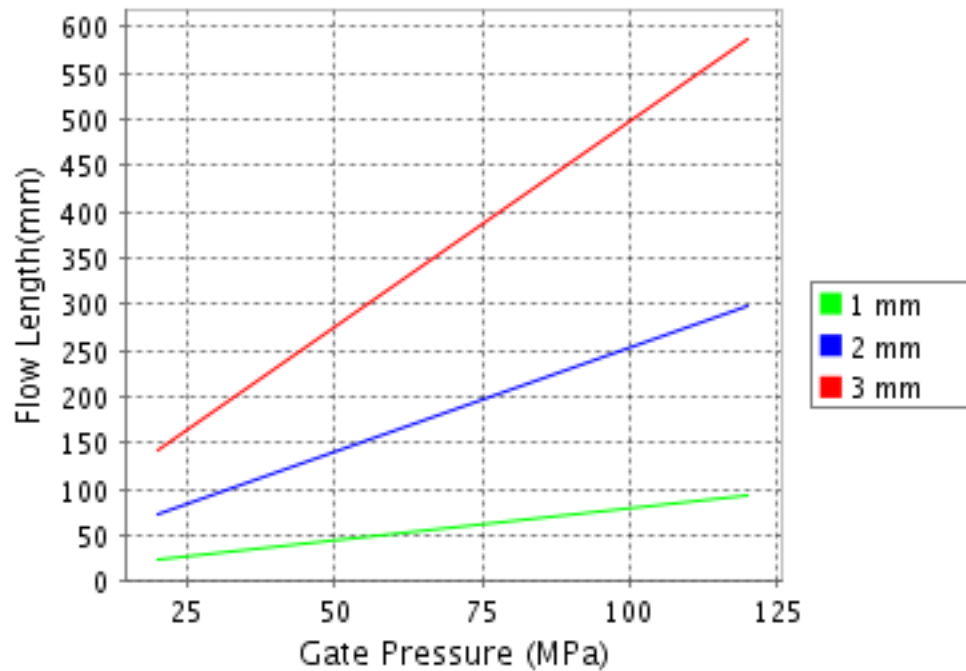
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

GELOY® HRA150

Melt Temperature : 275°C

Mold Temperature : 75°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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