

Geloy* Resin XP7560

Europe-Africa-Middle East: LIMITED USE

GELOY XP7560 is a general purpose ASA/PC injection moulding grade, available in various colours.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.7	%	ISO 527
Tensile Strain, break, 50 mm/min	20	%	ISO 527
Tensile Modulus, 1 mm/min	2460	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
Hardness, H358/30	92	MPa	ISO 2039-1
Hardness, Rockwell R	111	-	ISO 2039-2
IMPACT	Value	Unit	Standard
Izod Impact, notched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	9.5E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Ball Pressure Test, approximate maximum	95	°C	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	113	°C	ISO 306
Vicat Softening Temp, Rate B/50	102	°C	ISO 306
Vicat Softening Temp, Rate B/120	107	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	102	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	86	°C	ISO 75/Ae
PHYSICAL	Value	Unit	Standard
Mold Shrinkage on Tensile Bar, flow (2)	0.4 - 0.6	%	SABIC Method
Density	1.1	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.8	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.3	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	20	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Compliant, 94HB Flame Class Rating (3)(4)	3.2	mm	UL 94 by GE

Source GMD, last updated:07/15/2002

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.05	%
Melt Temperature	250 - 270	°C

Nozzle Temperature	230 - 260	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	230 - 260	°C
Rear - Zone 1 Temperature	220 - 250	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	50 - 70	°C

Source GMD, last updated:07/15/2002

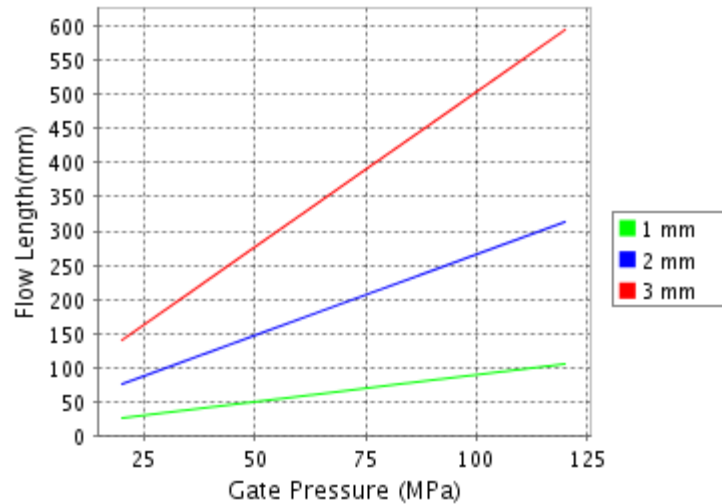
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Geloy® FXW710SK

Melt Temperature : 250°C

Mold Temperature : 60°C



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

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THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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