



## GELOY™ Resin XTWE290

### Americas: OBSOLETE

Excellent weathering. Coextrusion capstock grade asa.Thermoformable.Spas and outdoor vehicles.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	360	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	15	%	ASTM D 638
Tensile Modulus, 5 mm/min	30500	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	810	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	27000	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 50 mm/min	53	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.8	%	ISO 527
Tensile Strain, break, 50 mm/min	52	%	ISO 527
Tensile Modulus, 1 mm/min	2900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	74	MPa	ISO 178
Flexural Modulus, 2 mm/min	2600	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	3	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	305	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	2	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	89	°C	ASTM D 1525

(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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	76	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	9.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	88	°C	ISO 306
Vicat Softening Temp, Rate B/120	90	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	78	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.1	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.35 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.35 - 0.7	%	SABIC Method
Melt Flow Rate, 200°C/3.8 kgf	0.5	g/10 min	ASTM D 1238
Density	1.13	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.8	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 220°C/5.0 kg	2	cm <sup>3</sup> /10 min	ISO 1133

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- Barrel temperatures should be banked TO 150°C (300°F)

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Sheet Extrusion</b>		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	12	hrs
Minimum Moisture Content	0.04	%
Melt Temperature	220 - 245	°C
Barrel - Zone 1 Temperature	180 - 225	°C
Barrel - Zone 2 Temperature	190 - 230	°C
Barrel - Zone 3 Temperature	205 - 240	°C
Barrel - Zone 4 Temperature	210 - 245	°C
Adapter Temperature	210 - 245	°C
Die Temperature	210 - 245	°C
Roll Stack Temp - Top	70 - 100	°C
Roll Stack Temp - Middle	70 - 95	°C
Roll Stack Temp - Bottom	65 - 90	°C

- Purge using HIPS or Ultra HDPE.

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