

Geloy* Resin CR3020

Americas: COMMERCIAL

Lower gloss ASA. Primarily for capstock over ABS in coextrusion and thermoforming.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	40	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	31	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	24	%	ASTM D 638
Tensile Modulus, 50 mm/min	2060	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	62	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2130	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	160	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	24	J	ASTM D 3763
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	99	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	87	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	77	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.64E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.18E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.06	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 220°C/10.0 kgf	5	g/10 min	ASTM D 1238

Source GMD, last updated:01/28/2003

Processing

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

Parameter	Value	Unit
Sheet Extrusion		
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

- Purge using HIPS or Ultra HDPE.

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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