

## Geloy\* Resin CR7500

Americas: COMMERCIAL

High heat ASA with optimum flow-impact balance. For Automotive applications and Automotive colors only.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	40	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	33	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.6	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	1970	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2170	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	43	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.3	%	ISO 527
Tensile Strain, break, 5 mm/min	19	%	ISO 527
Tensile Modulus, 1 mm/min	2040	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	64	MPa	ISO 178
Flexural Modulus, 2 mm/min	2060	MPa	ISO 178
<b>IMPACT</b>			
	Value	Unit	Standard
Izod Impact, notched, 23°C	400	J/m	ASTM D 256
Izod Impact, notched, -30°C	60	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	30	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	15	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	90	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.4E-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	8.4E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	9.5E-05	1/°C	ISO 11359-2
Ball Pressure Test, approximate maximum	98	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	102	°C	ISO 306
Vicat Softening Temp, Rate B/120	105	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	88	°C	ISO 75/Ae
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	89	°C	ISO 75/Af
<b>PHYSICAL</b>			
	Value	Unit	Standard
Specific Gravity	1.08	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 220°C/10.0 kgf	6.3	g/10 min	ASTM D 1238
Melt Flow Rate, 260°C/5.0 kgf	11	g/10 min	ASTM D 1238
Density	1.07	g/cm <sup>3</sup>	ISO 1183

Water Absorption, (23°C/sat)	0.5	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 220°C/10.0 kg	6	cm <sup>3</sup> /10 min	ISO 1133
Melt Volume Rate, MVR at 260°C/5.0 kg	10	cm <sup>3</sup> /10 min	ISO 1133

Source GMD, last updated:03/17/2005

## Processing

Parameter	Value	Unit
<b>Injection Molding</b>		
Drying Temperature	85 - 95	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	255 - 270	°C
Nozzle Temperature	235 - 255	°C
Front - Zone 3 Temperature	245 - 260	°C
Middle - Zone 2 Temperature	235 - 255	°C
Rear - Zone 1 Temperature	230 - 250	°C
Mold Temperature	60 - 85	°C
Back Pressure	0.3 - 1	MPa
Screw Speed	30 - 80	rpm
Shot to Cylinder Size	40 - 80	%
Vent Depth	0.038 - 0.076	mm

Source GMD, last updated:03/17/2005

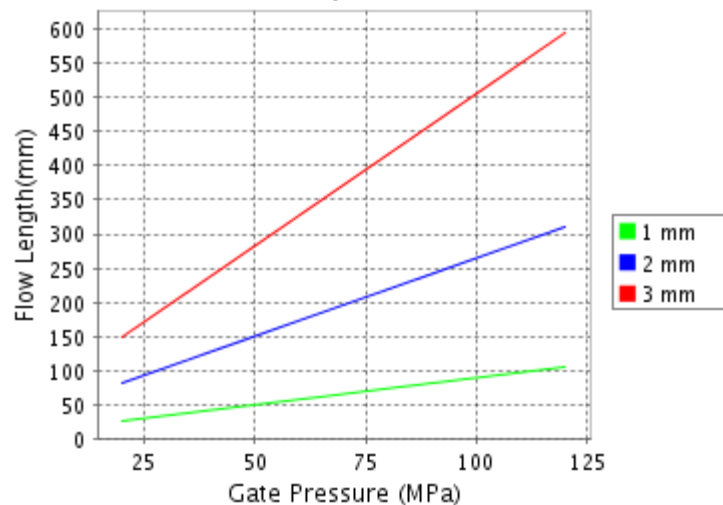
### CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Geloy® CR7500

Melt Temperature : 265°C

Mold Temperature : 80°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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