



GELOY™ Resin XTWE480
Asia Pacific: COMMERCIAL

Anti-scratch GELOY grade with excellent weatherability, high flow, and good surface quality. XTWE480 is available in various colours.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	500	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	360	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	21	%	ASTM D 638
Tensile Modulus, 50 mm/min	25100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	710	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21000	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	50	MPa	ISO 527
Tensile Stress, break, 50 mm/min	38	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	25	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	70	MPa	ISO 178
Flexural Modulus, 2 mm/min	2410	MPa	ISO 178
Pencil Hardness test, 1kgf	F	-	ASTM D 3363
IMPACT			
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	2	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	66	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	78	°C	ASTM D 1525



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THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	73	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	79	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	73	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.3 - 0.6	%	SABIC Method
Melt Flow Rate, 220°C/10.0 kgf	38	g/10 min	ASTM D 1238
Density	1.15	g/cm ³	ISO 1183



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Profile Extrusion		
Drying Temperature	75 - 85	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	200 - 230	°C
Barrel - Zone 1 Temperature	205 - 220	°C
Barrel - Zone 2 Temperature	210 - 225	°C
Barrel - Zone 3 Temperature	215 - 225	°C
Barrel - Zone 4 Temperature	215 - 225	°C
Hopper Temperature	60 - 80	°C
Adapter Temperature	200 - 225	°C
Die Temperature	210 - 225	°C
Calibrator Temperature	50 - 70	°C

•\0020PLEASE NOTE: Processing condition recommended for profile extrusion over PVC substrate.