

GELOY™ XP4034 resin

Acrylonitrile Styrene Acrylate + PC
SABIC Innovative Plastics

Message:

Weatherable, injection moldable ASA+PC blend. In a wide range of colors. Recommended for unpainted exterior/high heat applications.

General Information			
UL YellowCard	E207780-100080704		
Features	Good weather resistance		
	Heat resistance, high		
Appearance	Available colors		
Processing Method	Sheet extrusion molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/3.8 kg)	24	g/10 min	ASTM D1238
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.70	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.70	%	Internal method
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	62.1	MPa	ASTM D638
Tensile Elongation ² (Break)	25	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2520	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	80	J/m	ASTM D256
23°C	320	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	30.5	J	ASTM D3763
23°C, Total Energy	47.5	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	116	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	104	°C	ASTM D648

Linear thermal expansion coefficient			ASTM E831
Flow: -20 to 150°C	7.2E-5	cm/cm/°C	ASTM E831
Lateral: -20 to 150°C	7.2E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.25	W/m/K	ASTM C177
Optical	Nominal Value		Test Method
Gardner Gloss (60°, Untextured)	94		ASTM D523
Injection	Nominal Value		Unit
Drying Temperature	93.3 - 104	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	40 - 80	%	
Rear Temperature	238 - 254	°C	
Middle Temperature	243 - 260	°C	
Front Temperature	249 - 266	°C	
Nozzle Temperature	243 - 266	°C	
Processing (Melt) Temp	260 - 277	°C	
Mold Temperature	54.4 - 71.1	°C	
Back Pressure	0.345 - 1.03	MPa	
Screw Speed	30 - 80	rpm	
Vent Depth	0.038 - 0.076	mm	
Extrusion	Nominal Value		Unit
Drying Temperature	87.8 - 98.9	°C	
Drying Time	3.0 - 4.0	hr	
Cylinder Zone 1 Temp.	227 - 238	°C	
Cylinder Zone 2 Temp.	238 - 249	°C	
Cylinder Zone 3 Temp.	249 - 260	°C	
Cylinder Zone 4 Temp.	260 - 271	°C	
Adapter Temperature	260 - 271	°C	
Melt Temperature	260 - 282	°C	
Die Temperature	260 - 271	°C	
Extrusion instructions			
Drying Time (Cumulative): 8 hrsMinimum Moisture Content: 0.04 %Roll Stack Temp - Bottom: 74 - 91 °CRoll Stack Temp - Middle: 93 - 110 °CRoll Stack Temp - Top: 102 - 118 °C			
NOTE			
1.	Type 1, 50mm/min		
2.	Type 1, 50mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		

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