

GELOY™ XP4045LG resin

Acrylonitrile Styrene Acrylate + PC

SABIC Innovative Plastics

Message:

Available in a wide range of colors. Recommended for weatherable/unpainted interior/low gloss/high heat applications.

General Information			
Features	Good Weather Resistance		
	High Heat Resistance		
	Low Gloss		
Appearance	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	28.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.60 to 0.90	%	
Across Flow : 3.20 mm	0.60 to 0.90	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2330	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	60.0	MPa	
Break	45.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	5.2	%	
Break	47	%	
Flexural Modulus ¹	2270	MPa	ISO 178
Flexural Stress	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-40°C ²	12	kJ/m ²	
-30°C ³	14	kJ/m ²	
23°C ⁴	25	kJ/m ²	
Notched Izod Impact Strength ⁵			ISO 180/1A
-40°C	8.0	kJ/m ²	
-30°C	8.0	kJ/m ²	
23°C	15	kJ/m ²	
Instrumented Dart Impact			ASTM D3763

-30°C, Energy at Peak Load	15.0	J
-30°C, Total Energy	17.0	J
23°C, Energy at Peak Load	45.0	J
23°C, Total Energy	53.7	J

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			
0.45 MPa, Unannealed, 64.0 mm Span	125	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	103	°C	ISO 75-2/Af
Vicat Softening Temperature	126	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : -30 to 80°C	6.7E-5	cm/cm/°C	
Transverse : -30 to 80°C	7.6E-5	cm/cm/°C	

Injection	Nominal Value	Unit
Drying Temperature	95.0 to 105	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.040	%
Suggested Shot Size	40 to 80	%
Rear Temperature	260 to 280	°C
Middle Temperature	250 to 275	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	260 to 275	°C
Processing (Melt) Temp	265 to 285	°C
Mold Temperature	50.0 to 82.0	°C
Back Pressure	0.300 to 1.00	MPa
Screw Speed	30 to 80	rpm
Vent Depth	0.038 to 0.076	mm

NOTE	
1.	2.0 mm/min
2.	80*10*3 sp=62mm
3.	80*10*4 sp=62mm
4.	80*10*4 sp=62mm
5.	80*10*4
6.	80*10*4 mm

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