

GELOY™ XP4025 resin

Acrylonitrile Styrene Acrylate + PC

SABIC Innovative Plastics

Message:

ASA+PC blend. Weatherable, injection grade. Available in a wide range of colors and is recommended for unpainted exterior applications.

General Information			
Features	Good weather resistance		
Uses	Outdoor application		
Appearance	Available colors		
Processing Method	Sheet extrusion molding		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	18	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)	0.24	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	59.3	MPa	ASTM D638
Tensile Elongation ² (Break)	25	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2590	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	64	J/m	ASTM D256
23°C	170	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	33.9	J	ASTM D3763
23°C, Total Energy	37.3	J	ASTM D3763

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	103	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	90.6	°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
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (1.47 mm)	HB	UL 94	
Optical	Nominal Value	Test Method	
Gardner Gloss (60°, Untextured)	90	ASTM D523	
Injection	Nominal Value	Unit	
Drying Temperature	87.8 - 98.9	°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	232 - 249	°C	
Middle Temperature	238 - 254	°C	
Front Temperature	243 - 260	°C	
Nozzle Temperature	238 - 254	°C	
Processing (Melt) Temp	254 - 271	°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.	221 - 232	°C	
Cylinder Zone 2 Temp.	232 - 243	°C	
Cylinder Zone 3 Temp.	243 - 254	°C	
Cylinder Zone 4 Temp.	254 - 266	°C	
Adapter Temperature	254 - 266	°C	
Melt Temperature	254 - 271	°C	
Die Temperature	254 - 266	°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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

