

Geloy* Resin XP4034

Americas: COMMERCIAL

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

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	25	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2510	MPa	ASTM D 790
Hardness, Rockwell R	110	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	320	J/m	ASTM D 256
Izod Impact, notched, -30°C	80	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	47	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	30	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	104	°C	ASTM D 648
CTE, -20°C to 150°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	7.2E-05	1/°C	ASTM E 831
Thermal Conductivity	0.25	W/m·°C	ASTM C 177
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.15	-	ASTM D 792
Water Absorption, 24 hours	0.25	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 280°C/3.8 kgf	24	g/10 min	ASTM D 1238
OPTICAL	Value	Unit	Standard
Gloss, untextured, 60 degrees	94	-	ASTM D 523

Source GMD, last updated:01/05/2000

Processing

- May be used in co-extrusion or monolayer.

Parameter	Value	Unit
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	260 - 275	°C
Nozzle Temperature	245 - 265	°C
Front - Zone 3 Temperature	250 - 265	°C
Middle - Zone 2 Temperature	245 - 260	°C
Rear - Zone 1 Temperature	240 - 255	°C

Mold Temperature	55 - 70	°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
Parameter		
Sheet Extrusion	Value	Unit
Drying Temperature	90 - 100	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Minimum Moisture Content	0.04	%
Melt Temperature	260 - 280	°C
Barrel - Zone 1 Temperature	225 - 240	°C
Barrel - Zone 2 Temperature	240 - 250	°C
Barrel - Zone 3 Temperature	250 - 260	°C
Barrel - Zone 4 Temperature	260 - 270	°C
Adapter Temperature	260 - 270	°C
Die Temperature	260 - 270	°C
Roll Stack Temp - Top	100 - 120	°C
Roll Stack Temp - Middle	95 - 110	°C
Roll Stack Temp - Bottom	75 - 90	°C

Source GMD, last updated:01/05/2000

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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