



GELOY™ Resin XP4045LG
Americas: COMMERCIAL

PC/ASA. Excellent weatherability, low gloss.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5.2	%	ISO 527
Tensile Strain, break, 50 mm/min	46.7	%	ISO 527
Tensile Modulus, 1 mm/min	2320	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	93	MPa	ISO 178
Flexural Modulus, 2 mm/min	2270	MPa	ISO 178
IMPACT			
Instrumented Impact Energy @ peak, 23°C	458	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -30	152	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, 23°C	547	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	173	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	8	kJ/m ²	ISO 180/1A
Charpy -40°C, V-notch Edgew 80*10*3 sp=62mm	12	kJ/m ²	ISO 179/1eA
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	25	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -30°C to 80°C, flow	6.7E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	7.6E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	126	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Bf



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	103	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.9	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.6 - 0.9	%	SABIC Method
Density	1.19	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	28	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	3 - 4	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	265 - 285	°C
Nozzle Temperature	260 - 275	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	250 - 275	°C
Rear - Zone 1 Temperature	260 - 280	°C
Mold Temperature	50 - 80	°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