

GELOY™ RESIN XP4025

REGION ASIA

DESCRIPTION

PC/ASA. Excellent weatherability.

TYPICAL PROPERTY VALUES

Revision 20260509

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	25	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2580	MPa	ASTM D790
Hardness, Rockwell R	114	-	ASTM D785
IMPACT			
Izod Impact, notched, 23°C	170	J/m	ASTM D256
Izod Impact, notched, -30°C	64	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	39	J	ASTM D3763
Instrumented Dart Impact Total Energy, -30°C	33	J	ASTM D3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	102	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D648
CTE, -20°C to 150°C, flow	7.2E-05	1/°C	ASTM E831
CTE, -20°C to 150°C, xflow	7.2E-05	1/°C	ASTM E831
Thermal Conductivity	0.25	W/m·°C	ASTM C177
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.14	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.24	%	ASTM D570
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			
260°C/5.0 kgf	18	g/10 min	ASTM D1238
OPTICAL			
Gloss, untextured, 60 degrees	90	-	ASTM D523
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating	1.47	mm	UL 94
INJECTION MOLDING			
Drying Temperature	90 – 100	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.04	%	

© 2026 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	255 – 270	°C	
Nozzle Temperature	240 – 255	°C	
Front - Zone 3 Temperature	245 – 260	°C	
Middle - Zone 2 Temperature	240 – 255	°C	
Rear - Zone 1 Temperature	230 – 250	°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	
SHEET EXTRUSION			
Drying Temperature	90 – 100	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Minimum Moisture Content	0.04	%	
Melt Temperature	255 – 270	°C	
Barrel - Zone 1 Temperature	220 – 230	°C	
Barrel - Zone 2 Temperature	230 – 245	°C	
Barrel - Zone 3 Temperature	245 – 255	°C	
Barrel - Zone 4 Temperature	255 – 265	°C	
Adapter Temperature	255 – 265	°C	
Die Temperature	255 – 265	°C	
Roll Stack Temp - Top	100 – 120	°C	
Roll Stack Temp - Middle	95 – 110	°C	
Roll Stack Temp - Bottom	75 – 90	°C	

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NON-INFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.

