GLS 406-024A BLACK

PolyOne Corporation - Thermoplastic Elastomer

Monday, January 28, 2019

General Information

Product Description

GLS 406-024A BLACK is a customized grade, and can also overmold to a variety of substrates including PC, ABS, PC/ABS, and Copolyester.

General			
Generic Name	• Thermoplastic Elastomer (TPE)		
Material Status	• Proprietary and/or Private		
Availability	• Asia Pacific		
Features	• Chemical Resistant	• Good Processability	• UV Resistant
Uses	• Computer Components	• Consumer Applications	• Overmolding
RoHS Compliance	• RoHS Compliant		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.09		ASTM D792
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F)	1300	psi	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F)	650	%	ASTM D412
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	79		ASTM D2240
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (392°F, 11200 sec^-1)	39.0	Pa·s	ASTM D3835

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	330 to 360	°F
Middle Temperature	360 to 390	°F
Front Temperature	380 to 430	°F
Nozzle Temperature	380 to 450	°F
Processing (Melt) Temp	380 to 450	°F
Mold Temperature	70 to 80	°F
Back Pressure	0.00 to 50.0	psi

Injection Notes

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP).

GLS 406-024A BLACK should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°C
Injection Speed: 0.5 to 4 in/sec
1st Stage - Boost Pressure: 500 to 1,000 psi
2nd Stage - Hold Pressure: 20-60% of Boost
Hold Time (Thick Part): 2 to 4 sec
Hold Time (Thin Part): 1 to 2 sec

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Die C

[3] 2 hr