GLS 393-058 Natural

Thermoplastic Elastomer

Key Characteristics

Product Description

GLS 393-058 Natural is designed for a wide variety of applications.

- Non-Slip Grip
- Overmold Adhesion to PC, ABS, PC/ABS, Copolyester.
- Soft Touch
- Rubbery Feel

General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	
Features	• Good Colorability • Good Flow	• Good Processability • Good Processing Stability
Uses	• Consumer Applications • Flexible Grips	• Overmolding • Soft Touch Applications
RoHS Compliance	• RoHS Compliant	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.910	0.910	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	276 psi	1.90 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	551 psi	3.80 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	630 %	630 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	38	38	ASTM D2240

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	320 to 370 °F	160 to 188 °C
Middle Temperature	350 to 380 °F	177 to 193 °C
Front Temperature	360 to 428 °F	182 to 220 °C
Nozzle Temperature	380 to 428 °F	193 to 220 °C
Mold Temperature	60 to 100 °F	16 to 38 °C
Back Pressure	0.00 to 100 psi	0.00 to 0.689 MPa
Screw Speed	25 to 100 rpm	25 to 100 rpm

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Injection Notes

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (PE) carriers are most suitable for coloring GLS 393-058 Natural. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials.

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

Regrind levels up to 20% can be used with GLS 393-058 Natural with minimal property losses, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should be as low as possible. The final determination of regrind effectiveness should be determined by the customer.

The GLS 393-058 Natural has excellent melt stability. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer.

Drying is not Required

Injection Speed: 1 to 3 in/sec
1st Stage - Boost Pressure: 175 to 800 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

[1] Typical values are not to be construed as specifications.

[2] Die C

[3] 2 hr

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