# GLS 130-117C

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| GLS 130-117C BLACK is an easy processing, general purpose material designed for a wide variety of applications. | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Regional Availability | • Africa & Middle East<br>• Asia Pacific | • Europe<br>• Latin America | • North America |
| Agency Ratings | • UL 94 | | |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Black | | |
| Forms | • Pellets | | |
| Processing Method | • Extrusion | • Injection Molding | |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.16 | 1.16 | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Strength [2, 3] (Break) | 716 psi | 4.94 MPa | ASTM D412 |
| Tensile Elongation [2, 3] (Break) | 710 % | 710 % | ASTM D412 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness [3] | | | ASTM D2240 |
| Shore A, 10 sec, 73°F (23°C) | 57 | 57 | |
| **Flammability** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Flame Rating (0.06 in (1.5 mm)) | HB | HB | UL 94 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 392°F (200°C), 11200 sec^-1 | 12.0 Pa·s | 12.0 Pa·s | |

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Rear Temperature | 340 to 390 °F | 171 to 199 °C |
| Middle Temperature | 360 to 420 °F | 182 to 216 °C |
| Front Temperature | 360 to 420 °F | 182 to 216 °C |
| Nozzle Temperature | 380 to 440 °F | 193 to 227 °C |
| Mold Temperature | 80 to 120 °F | 27 to 49 °C |
| Injection Rate | Moderate-Fast | Moderate-Fast |
| Back Pressure | 100 to 200 psi | 0.689 to 1.38 MPa |
| Screw Speed | 25 to 100 rpm | 25 to 100 rpm |

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## 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).

Regrind levels up to 20% can be used with OnFlex™ G7720 with minimal property loss, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should remain as low as possible. The final determination of regrind effectiveness should be determined by the customer.

OnFlex™ G7720 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: 350 to 900 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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