GLS 460-115C

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS 460-115C is a vibration damping thermoplastic elastomer for polypropylene overmolding, featuring improved compression set			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• Latin America	• North America
Features	• Vibration Damping		
Uses	• Appliance Components • Automotive Applications • Business Equipment	• Consumer Applications • Electrical/Electronic Applications • Flexible Grips	• Power/Other Tools • Soft Touch Applications • Sporting Goods
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.04	1.04	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F (23°C))	870 psi	6.00 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	540 %	540 %	ASTM D412
Tear Strength (73°F (23°C))	150 lbf/in	26.3 kN/m	ASTM D624
Compression Set [4]			ISO 815
77°F (25°C), 22 hr	19 %	19 %	
176°F (80°C), 22 hr	20 %	20 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	56	56	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	17.0 Pa·s	17.0 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	330 to 350 °F	166 to 177 °C
Middle Temperature	350 to 370 °F	177 to 188 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	370 to 440 °F	188 to 227 °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

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 460-115C 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.

GLS 460-115C 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 range: 1-5 in/sec
2nd Stage hold: 20-40% of boost
Hold time (thick) range: 4-10 sec
Hold time (thin) range: 1-4 sec

Notes

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

[2] Die C

[3] 2 hr

[4] Type A

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