GLS AD6-794 Metallic Prussian Blue

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS AD6-794 Metallic Prussian Blue is targeted for consumer electronics applications where excellent surface appearance with long-term life, excellent abrasion resistance, performed UV and chemical resistance are required. GLS AD6-794 Metallic Prussian Blue can also overmold to a variety of substrates including TR90, PC, ABS and PC/ABS.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Good Processability	• Low Friction	• Pleasing Surface Appearance
Uses	• Consumer Applications	• Electrical/Electronic Applications	• Overmolding
RoHS Compliance	• RoHS Compliant		
Appearance	• Blue		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.06	1.06	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	561 psi	3.87 MPa	ISO 37
Tensile Strength [2, 3] (Break, 73°F (23°C))	2280 psi	15.7 MPa	ISO 37
Tensile Elongation [2, 3] (Break, 73°F (23°C))	970 %	970 %	ISO 37
Compression Set			ISO 815
140°F (60°C), 72 hr	74 %	74 %	
158°F (70°C), 22 hr	79 %	79 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	68	68	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			Internal Method
392°F (200°C), 11200 sec^-1	32.1 Pa·s	32.1 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	158 to 176 °F	70 to 80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 430 °F	182 to 221 °C
Front Temperature	370 to 440 °F	188 to 227 °C

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Injection	Typical Value (English)	Typical Value (SI)
Nozzle Temperature	380 to 460 °F	193 to 238 °C
Processing (Melt) Temp	380 to 450 °F	193 to 232 °C
Mold Temperature	55 to 110 °F	13 to 43 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	50 to 100 rpm	50 to 100 rpm

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 AD6-794 Metallic Prussian Blue should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Hot Runners: 380°F-440°F
Hot Tip: 380°F-450°F

Injection Speed: 0.5 to 2 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 values are not to be construed as specifications.

[2] 7.9 in/min (200 mm/min)

[3] 2 hr

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