# GLS AD0-150

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| GLS AD0-150 is a custom thermoplastic elastomer formulation. Product will overmold onto PC, ABS, PC/ABS, and Copolyester. | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Regional Availability | • Asia Pacific | | |
| Features | • Specialty Grade | | |
| Uses | • Consumer Applications | • Overmolding | • Soft Touch Applications |
| Appearance | • Clear/Transparent | | |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.18 | 1.18 | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress [2, 3] (300% Strain, 73°F (23°C)) | 1860 psi | 12.8 MPa | ASTM D412 |
| Tensile Strength [2, 3] (Break, 73°F (23°C)) | 5670 psi | 39.1 MPa | ASTM D412 |
| Tensile Elongation [2, 3] (Break, 73°F (23°C)) | 640 % | 640 % | ASTM D412 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness (Shore A, 10 sec) | 89 | 89 | ASTM D2240 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 392°F (200°C), 1340 sec^-1 | 350 Pa·s | 350 Pa·s | |

**Legal Statement**

Bags of GLS AD0-150 should be left in the box with the top closed and not stored in direct sunlight.

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Drying Temperature | 120 to 140 °F | 49 to 60 °C |
| Drying Time | 3.0 to 4.0 hr | 3.0 to 4.0 hr |
| Suggested Max Moisture | 0.020 to 0.030 % | 0.020 to 0.030 % |
| Rear Temperature | 350 to 370 °F | 177 to 188 °C |
| Middle Temperature | 360 to 390 °F | 182 to 199 °C |
| Front Temperature | 370 to 420 °F | 188 to 216 °C |
| Nozzle Temperature | 380 to 430 °F | 193 to 221 °C |
| Processing (Melt) Temp | 380 to 425 °F | 193 to 218 °C |
| Mold Temperature | 55 to 130 °F | 13 to 54 °C |
| Back Pressure | 0.00 to 50.0 psi | 0.00 to 0.345 MPa |
| Screw Speed | 50 to 80 rpm | 50 to 80 rpm |

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## Injection Notes

Typical colorant letdown ratios are 50:1 to 25:1 - loading levels should be as low as possible to minimize the effect on adhesion. A high color match consistency can be obtained by the use of precolored compounds available from GLS. Concentrates based on PVC should not be used. The final determination of color concentrate suitability should be determined by customer trials. Contact GLS for more information on appropriate color concentrate base resins.

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

GLS AD0-150 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] Die C

[3] 2 hr

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