GLS AC1-513 CHARCOAL

Thermoplastic Elastomer

Key Characteristics

Product Description		
GLS AC1-513 CHARCOAL is a customized material for injection molding applications.		
General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	
Features	• Abrasion Resistant	• High Strength
Appearance	• Grey	
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (300% Strain)	1620 psi	11.2 MPa	ASTM D412
Tensile Strength (Break, 73°F (23°C))	3170 psi	21.9 MPa	ASTM D412
Tensile Elongation [2] (Break, 73°F (23°C))	810 %	810 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	87	87	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	51.7 Pa·s	51.7 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	140 to 194 °F	60 to 90 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Suggested Max Moisture	0.030 %	0.030 %
Rear Temperature	338 to 374 °F	170 to 190 °C
Middle Temperature	374 to 410 °F	190 to 210 °C
Front Temperature	383 to 428 °F	195 to 220 °C
Nozzle Temperature	375 to 428 °F	191 to 220 °C
Mold Temperature	68 to 122 °F	20 to 50 °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

Notes

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

[2] 2 hr

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