# GLS AE0-630

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| GLS AE0-630 is customized grade and can overmold to a variety of substrates including 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 |
| RoHS Compliance | • RoHS Compliant | | |
| Appearance | • Black | | |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

### Technical Properties [1]

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.17 | 1.17 | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress [2, 3] (300% Strain, 73°F (23°C)) | 513 psi | 3.54 MPa | ASTM D412 |
| Tensile Strength [2, 3] (Break, 73°F (23°C)) | 1600 psi | 11.0 MPa | ASTM D412 |
| Tensile Elongation [2, 3] (Break, 73°F (23°C)) | 650 % | 650 % | ASTM D412 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness (Shore A, 10 sec) | 58 | 58 | ASTM D2240 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 392°F (200°C), 11200 sec^-1 | 14.5 Pa·s | 14.5 Pa·s | |

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Drying Temperature | 158 to 194 °F | 70 to 90 °C |
| Drying Time | 3.0 to 4.0 hr | 3.0 to 4.0 hr |
| Suggested Max Moisture | 0.030 % | 0.030 % |
| Rear Temperature | 340 to 360 °F | 171 to 182 °C |
| Middle Temperature | 360 to 410 °F | 182 to 210 °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 85 °F | 13 to 29 °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 |

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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).

GLS AE0-630 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

### Notes

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

[2] Die C

[3] 2 hr

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