GLS AB3-095

Thermoplastic Elastomer

Key Characteristics

Product Description
GLS AB3-095 is an easy process compound designed for injection molding and extrusion applications that require food contact compliance. • Overmold Adhesion to Polypropylene • Rubbery Feel • Soft Touch

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Latin America • North America	
Features	• Ozone Resistant	• Recyclable Material	
Uses	• Consumer Applications • Medical/Healthcare Applications	• Overmolding • Personal Care	• Soft Touch Applications
Agency Ratings	• EU 10/2011 [1]	• FDA 21 CFR 177.1210 [1]	
RoHS Compliance	• RoHS Compliant		
Appearance	• Purple		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.890	0.890	ISO 1183
Melt Volume-Flow Rate (MVR) (190°C/5.0 kg)	45 cm³/10min	45 cm³/10min	ISO 1133
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [3]			DIN 53504
100% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	334 psi	2.30 MPa	
Tensile Stress [3]			DIN 53504
300% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	537 psi	3.70 MPa	
Tensile Strength [3]			DIN 53504
Break, 73°F (23°C), 0.0787 in (2.00 mm)	1260 psi	8.70 MPa	
Tensile Elongation [3]			DIN 53504
Break, 73°F (23°C), 0.0787 in (2.00 mm)	760 %	760 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	60	60	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ISO 11443
392°F (200°C), 11200 sec^-1	12.4 Pa·s	12.4 Pa·s	

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	320 to 374 °F	160 to 190 °C
Middle Temperature	356 to 374 °F	180 to 190 °C
Front Temperature	374 to 428 °F	190 to 220 °C
Nozzle Temperature	374 to 428 °F	190 to 220 °C
Mold Temperature	77 to 104 °F	25 to 40 °C
Back Pressure	290 to 1450 psi	2.00 to 10.0 MPa
Screw Speed	25 to 75 rpm	25 to 75 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).

Regrind levels up to 20% can be used with GLS AB3-095 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 AB3-095 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: 1 to 5 in/sec
1st Stage - Boost Pressure: 400 to 1000 psi
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Revision Date: June 10th 2022
New TDS revision due to alternate dusting agent

Notes

[1] Product rating may be influenced by end product design and/or conditions of use. Please contact GLS Thermoplastic Elastomers for information addressing EU (EU, 10/2011) and FDA (21 CFR 177.1210 & 21 CFR 177.2600) compliance.
Please contact PolyOne GLS Thermoplastic Elastomers for a complete copy of the GLS Healthcare policy.
1. The customer must notify GLS of any FDA class I, and/or European Union class I medical devices for each specific product and application.
2. The customer shall not knowingly manufacture, use or sell or otherwise supply, directly or indirectly products or compounds made from GLS products in any of the following without prior written approval by GLS for each specific product or application:
a. Cosmetics
b. Drugs or other pharmaceuticals
c. Temporary or permanent implantations in the human baody, regardless of the intended duration of the implantation
d. Class II and III medical devices as defined in 21CFR 860.3 ("Medical devices")
e. Class IIa, IIb and III as defined in Directive 93/42/EEC.

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

[3] 7.9 in/min (200 mm/min)

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