GLS 484-119

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS 484-119 is based on styrenic blockcopolymer. This Compound is specially formulated to compliant to EU 10/2011, Code of Federal Regulations, Title 21 (CFR 21) "FDA" as well as to FDA medical device class I.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Flow		
Appearance	• Natural Color		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density (73°F (23°C))	1.04 g/cm³	1.04 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2]			ISO 37
Across Flow : 100% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	87.0 psi	0.600 MPa	
Flow : 100% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	131 psi	0.900 MPa	
Tensile Stress [2]			ISO 37
Across Flow : 300% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	145 psi	1.00 MPa	
Flow : 300% Strain, 73°F (23°C), 0.0787 in (2.00 mm)	247 psi	1.70 MPa	
Tensile Stress [2]			ISO 37
Across Flow : Break, 73°F (23°C), 0.0787 in (2.00 mm)	943 psi	6.50 MPa	
Flow : Break, 73°F (23°C), 0.0787 in (2.00 mm)	508 psi	3.50 MPa	
Tensile Elongation			ISO 37
Across Flow : Break, 73°F (23°C), 0.0787 in (2.00 mm)	950 %	950 %	
Flow : Break, 73°F (23°C), 0.0787 in (2.00 mm)	900 %	900 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	35	35	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ISO 11443
392°F (200°C), 11200 sec^-1	8.30 Pa·s	8.30 Pa·s	

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	360 to 380 °F	182 to 193 °C
Middle Temperature	370 to 395 °F	188 to 202 °C
Front Temperature	380 to 400 °F	193 to 204 °C
Nozzle Temperature	390 to 425 °F	199 to 218 °C
Mold Temperature	70 to 100 °F	21 to 38 °C
Back Pressure	25.0 to 50.0 psi	0.172 to 0.345 MPa
Screw Speed	75 to 125 rpm	75 to 125 rpm

Injection Notes

Color concentrates with polyethylene (PE) or polypropylene (PP) or EVA carriers are most suitable for coloring GLS 484-119. Typical letdown ratios are 50:1 to 25:1. 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.

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

Regrind levels up to 20% can be used with GLS 484-119 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 484-119 has good 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 5 - 8 minutes or longer.

Drying is not Required

Injection Speed: 0.5 to 3 in/sec
1st Stage - Boost Pressure: 35 to 65 bars.
2nd Stage - Hold Pressure: 70% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

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

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

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