GLS AF4-614

Thermoplastic Elastomer

Key Characteristics

Product Description		
GLS AF4-614 is a customized thermoplastic elastomer formulation that offers an extremely soft touch.		
General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	
Features	• Specialty Grade	
Uses	• Personal Care	• Toys
Agency Ratings	• FDA	
RoHS Compliance	• RoHS Compliant	
Appearance	• Clear/Transparent	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.870	0.870	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Elongation [2, 3] (Break, 73°F (23°C))	990 %	990 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore OO, 10 sec)	15	15	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
266°F (130°C), 11200 sec^-1	3.10 Pa·s	3.10 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	320 to 360 °F	160 to 182 °C
Middle Temperature	340 to 380 °F	171 to 193 °C
Front Temperature	360 to 420 °F	182 to 216 °C
Nozzle Temperature	360 to 430 °F	182 to 221 °C
Processing (Melt) Temp	360 to 430 °F	182 to 221 °C

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 AF4-614 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 AF4-614 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 5-8 minutes or longer.

Drying is not Required

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Notes

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

[2] Die C

[3] 2 hr

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