# GLS AF8-721

## Thermoplastic Elastomer

### Key Characteristics

| Product Description | | | |
|---|---|---|---|
| GLS AF8-721 is a ESD TPE alloy designed for IC tray applications. | | | |
| **General** | | | |
| Material Status | • Commercial: Active | | |
| Regional Availability | • Asia Pacific | | |
| Features | • Abrasion Resistant | • Good Moldability | • Good Processability |
| Uses | • Consumer Applications<br>• Electrical/Electronic Applications | • Overmolding<br>• Semiconductor 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 | 1.10 | 1.10 | ASTM D792 |
| **Elastomers** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Tensile Stress [2, 3] (300% Strain, 73°F (23°C)) | 1980 psi | 13.7 MPa | ASTM D412 |
| Tensile Strength [2, 3] (Break, 73°F (23°C)) | 2630 psi | 18.2 MPa | ASTM D412 |
| Tensile Elongation [2, 3] (Break, 73°F (23°C)) | 700 % | 700 % | ASTM D412 |
| **Hardness** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Durometer Hardness (Shore D, 10 sec) | 42 | 42 | ASTM D2240 |
| **Electrical** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Surface Resistivity (73°F (23°C)) | 1.0E+6 to 9.9E+8 ohms | 1.0E+6 to 9.9E+8 ohms | ASTM D257 |
| **Fill Analysis** | **Typical Value (English)** | **Typical Value (SI)** | **Test Method** |
| Apparent Viscosity | | | ASTM D3835 |
| 428°F (220°C), 11200 sec^-1 | 52.0 Pa·s | 52.0 Pa·s | |

### Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|---|---|---|
| Drying Temperature | 140 to 176 °F | 60 to 80 °C |
| Drying Time | 3.0 to 4.0 hr | 3.0 to 4.0 hr |
| Rear Temperature | 325 to 370 °F | 163 to 188 °C |
| Middle Temperature | 360 to 390 °F | 182 to 199 °C |
| Front Temperature | 360 to 450 °F | 182 to 232 °C |
| Nozzle Temperature | 360 to 450 °F | 182 to 232 °C |
| Mold Temperature | 70 to 120 °F | 21 to 49 °C |
| Back Pressure | 0.00 to 80.0 psi | 0.00 to 0.552 MPa |
| Screw Speed | 75 to 125 rpm | 75 to 125 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).

The GLS AF8-721 should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Injection Speed: 0.5 to 2 in/sec
1st Stage - Boost Pressure: 200 to 800 psi
2nd Stage - Hold Pressure: 30% 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] Die C

[3] 2 hr

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