GLS AE0-613 Clear

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS AE0-613 Clear is a custom thermoplastic elastomer formulation. Product will overmold onto 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
Appearance	• Clear/Transparent		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.18	1.18	ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 0.012 in/in	0.50 to 1.2 %	ASTM D955
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	1590 psi	11.0 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	4690 psi	32.3 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	730 %	730 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	88	88	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	77.0 Pa·s	77.0 Pa·s	

Legal Statement

Bags of GLS AD0-154 Clear should be left in the box with the top closed and not stored in direct sunlight.

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	140 to 176 °F	60 to 80 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Rear Temperature	350 to 370 °F	177 to 188 °C
Middle Temperature	360 to 390 °F	182 to 199 °C
Front Temperature	370 to 420 °F	188 to 216 °C
Nozzle Temperature	380 to 446 °F	193 to 230 °C
Processing (Melt) Temp	380 to 425 °F	193 to 218 °C
Mold Temperature	55 to 130 °F	13 to 54 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	50 to 80 rpm	50 to 80 rpm

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Injection Notes

Typical colorant letdown ratios are 50:1 to 25:1 - loading levels should be as low as possible to minimize the effect on adhesion. 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. Contact GLS for more information on appropriate color concentrate base resins.

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

GLS AE0-613 Clear 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

Injection Speed: 0.5 to 2 in/sec
1st Stage - Boost Pressure: 500 to 1,000 psi
2nd Stage - Hold Pressure: 20-60% of Boost
Hold Time (Thick Part): 2 to 4 sec
Hold Time (Thin Part): 1 to 2 sec

Notes

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

[2] Die C

[3] 2 hr

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