GLS AB0-248

Thermoplastic Elastomer

Key Characteristics

Product Description

GLS AB0-248 is a thermoplastic elastomer developmental grade and may be appropriate where FDA and EU 10/2011 compliances are required.

- Overmolding adhesion to HDPE, LDPE and PP
- Excellent Organoleptic Properties
- Soft touch, rubbery feel

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	
Features	• Excellent Organoleptic Properties	• Good Adhesion	
Uses	• Caps • Closures	• General Purpose • Liners	• Packaging
Agency Ratings	• EU 10/2011 [1]	• FDA 21 CFR 177.1210 [1]	
RoHS Compliance	• RoHS Compliant		
Appearance	• Yellow		
Forms	• Pellets		
Processing Method	• Injection Molding	• Multi Injection Molding	

Technical Properties [2]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	0.885 g/cm³	0.885 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress			ISO 37
Across Flow : Break	1160 psi	8.00 MPa	
Flow : Break	711 psi	4.90 MPa	
Tensile Elongation			ISO 37
Across Flow : Break	> 1000 %	> 1000 %	
Flow : Break	> 1000 %	> 1000 %	
Compression Set			ISO 815
73°F (23°C), 72 hr	23 %	23 %	
158°F (70°C), 22 hr	44 %	44 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	60	60	ISO 48-4

Additional Information

Properties are measured using injection molded plaques.

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	329 to 347 °F	165 to 175 °C
Middle Temperature	347 to 374 °F	175 to 190 °C
Front Temperature	365 to 428 °F	185 to 220 °C
Nozzle Temperature	374 to 437 °F	190 to 225 °C
Mold Temperature	68 to 104 °F	20 to 40 °C
Back Pressure	0.00 to 131 psi	0.00 to 0.900 MPa
Screw Speed	40 to 100 rpm	40 to 100 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 AB0-248 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 AB0-248 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 3 in/sec (2.5-7.6cm/sec)
1st Stage - Boost Pressure: 350 to 900 psi (2.41-6.21MPa)
2nd Stage - Hold Pressure: 30% of Boost
Hold Time (Thick Part): 3 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

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) compliance.

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

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