GLS AF1-995 BLACK

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS AF1-995 BLACK is a performance TPE alloy designed for IC tray applications.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Abrasion Resistant	• Good Moldability	• Good Processability
Uses	• Business Equipment • Consumer Applications	• Electrical/Electronic Applications • Overmolding	• Thin-walled Parts
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	1.09	1.09	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength [2, 3] (Break, 73°F (23°C))	3950 psi	27.2 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	740 %	740 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	83	83	ASTM D2240

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
Suggested Max Moisture	< 0.030 %	< 0.030 %
Suggested Max Regrind	20 %	20 %
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).

Regrind levels up to 20% can be used with GLS AF1-995 BLACK 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.

The GLS AF1-995 BLACK 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

CONTACT INFORMATION

North America
Avon Lake, United States
33587 Walker Road
Avon Lake, OH, United States , 44012
+1 440 930 1000
+1 844 4AVIENT

South America
Sao Paulo, Brazil
Av. Francisco Nakasato, 1700
13295-000 Itupeva
Sao Paulo, Brazil
+55 11 4593 9200

Asia
Shanghai, China
2F, Block C
200 Jinsu Road
Pudong, 201206
Shanghai, China
+86 (0) 21 6028 4888

Europe
Pommerloch, Luxembourg
19 Route de Bastogne
Pommerloch, Luxembourg , L-9638
+352 269 050 35

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