GLS 433-021 Silver

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS 433-021 is a custom material for the use of Gillette and its molders. • Custom Material			
General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Appearance	• Silver		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.982	0.982	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	218 psi	1.50 MPa	DIN 53504-S2
Tensile Strength [2, 3] (Yield, 73°F (23°C))	544 psi	3.75 MPa	DIN 53504-S2
Tensile Elongation [2, 3] (Break, 73°F (23°C))	700 %	700 %	DIN 53504-S2
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	30	30	ISO 48-4
Additional Information	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Capillary Stress			ASTM D3835
392°F (200°C) [4]	17400	17400	
392°F (200°C) [5]	31300	31300	
392°F (200°C) [6]	44400	44400	
392°F (200°C) [7]	26800	26800	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	300 to 340 °F	149 to 171 °C
Middle Temperature	360 to 390 °F	182 to 199 °C
Front Temperature	370 to 410 °F	188 to 210 °C
Nozzle Temperature	380 to 420 °F	193 to 216 °C
Processing (Melt) Temp	380 to 420 °F	193 to 216 °C
Mold Temperature	50 to 80 °F	10 to 27 °C
Back Pressure	0.00 to 80.0 psi	0.00 to 0.552 MPa
Screw Speed	80 to 120 rpm	80 to 120 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 433-021 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 433-021 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: 0.5 to 3 in/sec
1st Stage - Boost Pressure: 200 to 700 psi
2nd Stage - Hold Pressure: 20% of Boost
Hold Time (Thick Part): 1 to 5 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

[4] 199.67

[5] 2000.2

[6] 8025.3

[7] 999.8

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