GLS AD6-721C Black

Thermoplastic Elastomer

Key Characteristics

Product Description

GLS AD6-721C Black is specifically designed to bond to a variety of standard and modified nylon materials, including those which are glass fibre filled, heat stabilized and/or impact modified.

- Outstanding Adhesion in Both Two-Shot and Insert Molding Processes
- Soft, Rubbery Grip
- Very Easy to Process

General			
Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Adhesion	• Good Colorability	• Good Processability
Uses	• Consumer Applications • Electrical/Electronic Applications • Flexible Grips	• Handles • Lawn & Garden Equipment • Overmolding	• Power/Other Tools
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	1.03 g/cm³	1.03 g/cm³	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress - Flow [2]			ISO 37
300% Strain, 73°F (23°C), 0.126 in (3.20 mm)	305 psi	2.10 MPa	
Tensile Elongation - Flow [2]			ISO 37
Break, 73°F (23°C), 0.126 in (3.20 mm)	540 %	540 %	
Tear Strength - Flow [3]			ISO 34-1
73°F (23°C), 0.126 in (3.20 mm)	331 lbf/in	58.0 kN/m	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness [4] (Shore A, 10 sec)	54	54	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	16.6 Pa·s	16.6 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	356 to 392 °F	180 to 200 °C
Middle Temperature	428 to 473 °F	220 to 245 °C
Front Temperature	446 to 491 °F	230 to 255 °C
Nozzle Temperature	473 to 500 °F	245 to 260 °C

Copyright ©, 2026 Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. Avient makes no warranties or guarantees respecting suitability of either Avient's products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. Avient MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.

Injection	Typical Value (English)	Typical Value (SI)
Processing (Melt) Temp	446 to 500 °F	230 to 260 °C
Mold Temperature	55 to 85 °F	13 to 29 °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

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).

GLS AD6-721C Black has good 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: 3 to 6 in/sec
1st Stage - Boost Pressure: 300 to 800 psi
2nd Stage - Hold Pressure: 0% of Boost
Hold Time (Thick Part): 0 to 4 sec
Hold Time (Thin Part): 0 to 3 sec

Notes

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

[2] 7.9 in/min (200 mm/min)

[3] 20 in/min (500 mm/min)

[4] ±5 Sh A

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

avient.com

Copyright ©, 2026 Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the Information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the Information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as “typical” or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the Information. Avient makes no warranties or guarantees respecting suitability of either Avient’s products or the Information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the Information and/or use or handling of any product. Avient MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the Information or products reflected by the Information. This data sheet shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.