GLS AC4-673

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS AC4-673 is a SEBS based Blueberry material bondable to Nylon.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• North America	
Features	• Good Processability		
Uses	• Consumer Applications	• Overmolding	• Soft Touch Applications
RoHS Compliance	• RoHS Compliant		
Appearance	• Purple		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.10	1.10	ISO 1183
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain, 73°F (23°C))	479 psi	3.30 MPa	ISO 37
Tensile Strength [2, 3] (Break, 73°F (23°C))	522 psi	3.60 MPa	ISO 37
Tensile Elongation [2, 3] (Break, 73°F (23°C))	510 %	510 %	ISO 37
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	63	63	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			Internal Method
392°F (200°C), 11200 sec^-1	18.3 Pa·s	18.3 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	120 to 140 °F	49 to 60 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Rear Temperature	356 to 374 °F	180 to 190 °C
Middle Temperature	392 to 464 °F	200 to 240 °C
Front Temperature	428 to 500 °F	220 to 260 °C
Nozzle Temperature	428 to 500 °F	220 to 260 °C
Processing (Melt) Temp	428 to 482 °F	220 to 250 °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

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

GLS AC4-673 should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Hot Runners: 380°F-480°F
Hot Tip: 380°F-480°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] 7.9 in/min (200 mm/min)

[3] 2 hr

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