GLS AC8-678 Black

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS AC8-678 Black is a SEBS based alloy.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Good Compression Set	• Soft	
Uses	• Consumer Applications	• Overmolding	• Soft Touch Applications
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	0.870	0.870	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.2 to 1.8 %	1.2 to 1.8 %	
Flow	1.0 to 1.6 %	1.0 to 1.6 %	
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress (100% Strain)	50.0 psi	0.345 MPa	ISO 37
Tensile Strength [2, 3] (Break, 73°F (23°C))	480 psi	3.31 MPa	ISO 37
Tensile Elongation [2, 3] (Break, 73°F (23°C))	980 %	980 %	ISO 37
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Shore Hardness (Shore A, 10 sec)	17	17	ISO 48-4
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			Internal Method
392°F (200°C), 11200 sec^-1	3.80 Pa·s	3.80 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Rear Temperature	350 to 370 °F	177 to 188 °C
Middle Temperature	360 to 390 °F	182 to 199 °C
Front Temperature	370 to 420 °F	188 to 216 °C
Nozzle Temperature	374 to 455 °F	190 to 235 °C
Processing (Melt) Temp	374 to 446 °F	190 to 230 °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).

Regrind levels up to 20% can be used with GLS AC8-678 Black with minimal property losses, provided that the regrind is free of contamination. To minimize losses during molding, the melt temperature should be as low as possible. The final determination of regrind effectiveness should be determined by the customer.

The GLS AC8-678 Black 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

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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