GLS AC2-193 WHITE

Thermoplastic Elastomer

Key Characteristics

General	
Material Status	• Commercial: Active
Regional Availability	• North America
Processing Method	• Injection Molding

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.896	0.896	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength (Break)	637 psi	4.39 MPa	ASTM D412
Tensile Elongation (Break)	540 %	540 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A)	55	55	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	11.9 Pa·s	11.9 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	330 to 360 °F	166 to 182 °C
Middle Temperature	360 to 400 °F	182 to 204 °C
Front Temperature	370 to 410 °F	188 to 210 °C
Nozzle Temperature	370 to 410 °F	188 to 210 °C
Processing (Melt) Temp	380 to 430 °F	193 to 221 °C
Mold Temperature	60 to 80 °F	16 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

Color concentrates with polyproplene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (LDPE) carriers are most suitable for coloring GLS AC2-193. Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Liquid color can be used, but mineral oil based carriers may have an effect on the final hardness value. Concentrates based on PVC should not be used. A high color match consistency can be obtained by using precolored compounds available from GLS. The final determination of color concentrate suitability should be determined by customer trials.

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 AC2-193 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 AC2-193 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: 1 to 5 in/sec
1st Stage - Boost Pressure: 100 to 800 psi
2nd Stage - Hold Pressure: 20% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 4 sec

Extrusion	Typical Value (English)	Typical Value (SI)
Melt Temperature	380 to 400 °F	193 to 204 °C
Die Temperature	380 to 400 °F	193 to 204 °C

Extrusion Notes

Rear: 340 - 360F
Center: 380 - 400F
Front: 390 - 410F
Screw: 80 - 200 RPMs

Notes

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

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