GLS 385-093 Silver

Thermoplastic Elastomer

Key Characteristics

Product Description

GLS 385-093 Silver is designed for overmolding onto a wide variety of substrates including PC, ABS, SAN, ASA, COPE.

Product highlights

- Bonds to a Variety Of Substrates
- Rubbery Feel
- Good surface Aesthetics
- Soft Touch
- Short cycle time
- Good UV resistance

General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific	• North America	
Features	• Good Moldability • Good Processability	• Good Processing Stability • Good Surface Finish	• UV Resistant
Uses	• Consumer Applications • Electrical/Electronic Applications	• Flexible Grips • Overmolding	• Power/Other Tools
RoHS Compliance	• RoHS Compliant		
Appearance	• Silver		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.920	0.920	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2]			ASTM D412
300% Strain, 0.126 in (3.20 mm)	390 psi	2.69 MPa	
Tensile Stress [2] (Break, 0.126 in (3.20 mm))	620 psi	4.27 MPa	ASTM D412
Tensile Elongation [2]			ASTM D412
Break, 0.126 in (3.20 mm)	650 %	650 %	
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	48	48	ASTM D2240

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	356 to 374 °F	180 to 190 °C
Middle Temperature	374 to 392 °F	190 to 200 °C
Front Temperature	392 to 428 °F	200 to 220 °C
Nozzle Temperature	392 to 446 °F	200 to 230 °C
Mold Temperature	68 to 104 °F	20 to 40 °C
Back Pressure	25.0 to 50.0 psi	0.172 to 0.345 MPa
Screw Speed	75 to 125 rpm	75 to 125 rpm

Injection Notes

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

Regrind levels up to 20% can be used with GLS 385-093 Silver 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 385-093 Silver 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 5 - 8 minutes or longer.

Drying is not Required

Injection Speed: 0.5 to 3 in/sec
1st Stage - Boost Pressure: 35 to 65 bars.
2nd Stage - Hold Pressure: 70% of Boost
Hold Time (Thick Part): 4 to 10 sec
Hold Time (Thin Part): 1 to 3 sec

Notes

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

[2] 20 in/min (500 mm/min)

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