GLS AD4-692

Thermoplastic Elastomer

Key Characteristics

Product Description			
GLS AD4-692 is a customized grade and it can also overmold to a variety of substrates including PC,ABS, PC/ABS and Copolyester.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Abrasion Resistant	• Chemical Resistant	• Good Processability
Uses	• Appliances • Consumer Applications	• Overmolding • Thin-walled Parts	
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.06	1.06	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2, 3] (300% Strain)	760 psi	5.24 MPa	ASTM D412
Tensile Strength [2, 3] (Break)	1400 psi	9.65 MPa	ASTM D412
Tensile Elongation [2, 3] (Break)	760 %	760 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	76	76	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	52.0 Pa·s	52.0 Pa·s	
Additional Information	**Typical Value (English)**	**Typical Value (SI)**	
Generic Material Type	Thermoplastic Elastomer	Thermoplastic Elastomer	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	158 to 194 °F	70 to 90 °C
Drying Time	1.0 to 3.0 hr	1.0 to 3.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 410 °F	182 to 210 °C
Front Temperature	370 to 421 °F	188 to 216 °C
Nozzle Temperature	380 to 430 °F	193 to 221 °C
Processing (Melt) Temp	380 to 424 °F	193 to 218 °C
Mold Temperature	55 to 84 °F	13 to 29 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa
Screw Speed	50 to 100 rpm	50 to 100 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 AD4-692 should not be left in the barrel for extended idle periods (greater than 5 minutes).

Suggested Dewpoint: -40°F

Injection Speed: 0.5 to 4 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] Die C

[3] 2 hr

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