GLS 481-120 Natural

Thermoplastic Elastomer

PolyOne Corporation

Message:

GLS 481-120 Natural is a custom TPE compound

General Information	
Features	Shock absorption Good adhesion
Uses	overmolding Soft touch application General Consumer goods application field
RoHS Compliance	RoHS compliance
Appearance	Natural color
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm³	ASTM D792
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	54		ASTM D2240
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break, 23°C)	5.52	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	570	%	ASTM D412
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Apparent Viscosity (200°C, 1340 sec^-1)	70.0	Pa·s	ASTM D3835
Injection	**Nominal Value**	**Unit**	
Drying Temperature	52 - 60	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.030	%	
Suggested Max Regrind	20	%	
Rear Temperature	171 - 182	°C	
Middle Temperature	182 - 210	°C	
Front Temperature	188 - 216	°C	
Nozzle Temperature	193 - 221	°C	
Mold Temperature	13 - 29	°C	

Back Pressure	0.00 - 0.345	MPa

Injection instructions

Color concentrates based on GLS 481-120 Natural are most suitable for coloring GLS 481-120 Natural. Typical loadings for color concentrates are 1% to 4% by weight. 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 polypopylene (PP).Regrind levels up to 20% can be used with GLS 481-120 Natural 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 481-120 Natural 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.Suggested Dewpoint: -40°FInjection Speed: 0.5 to 2 in/sec1st Stage - Boost Pressure: 500 to 1000 psi2nd Stage - Hold Pressure: 20-60% of BoostHold Time (Thick Part): 2 to 4 secHold Time (Thin Part): 1 to 2 sec

Recommended distributors for this material

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