

GLS 481-122 Natural

Thermoplastic Elastomer

PolyOne Corporation

Message:

GLS 481-122 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	1.08	g/cm ³	ASTM D792
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	78		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	15.9	MPa	ASTM D412
Tensile Elongation (Break, 23°C)	690	%	ASTM D412
Fill Analysis	Nominal Value	Unit	Test Method
Apparent Viscosity (200°C, 1340 sec ⁻¹)	65.0	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 481-122 Natural are most suitable for coloring GLS 481-122 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 polypropylene (PP). Re grind levels up to 20% can be used with GLS 481-122 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 481-122 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°F Injection Speed: 0.5 to 2 in/sec 1st Stage - Boost Pressure: 500 to 1000 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

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