

GLS AC1-595 Classical Blue

Thermoplastic Elastomer

Key Characteristics

Product Description

GLS AC1-595 Classical Blue is an easy processing, general purpose TPE designed for a wide variety of applications.

- Overmold adhesion to PC, ABS, PBT
- Good appearance

General

Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Good Flow	• Good Processability	• Pleasing Surface Appearance
Uses	• Consumer Applications	• Electrical/Electronic Applications	• Overmolding
RoHS Compliance	• RoHS Compliant		
Appearance	• Blue		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.15	1.15	ASTM D792
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress ^{2, 3} (300% Strain, 73°F (23°C))	1930 psi	13.3 MPa	ASTM D412
Tensile Strength ^{2, 3} (Break, 73°F (23°C))	3530 psi	24.4 MPa	ASTM D412
Tensile Elongation ^{2, 3} (Break, 73°F (23°C))	910 %	910 %	ASTM D412
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore D, 10 sec)	44	44	ASTM D2240
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity 392°F (200°C), 11200 sec ⁻¹	100 Pa·s	100 Pa·s	ASTM D3835

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 212 °F	80 to 100 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Suggested Max Moisture	0.020 to 0.030 %	0.020 to 0.030 %
Suggested Max Regrind	20 %	20 %
Rear Temperature	340 to 360 °F	171 to 182 °C
Middle Temperature	360 to 464 °F	182 to 240 °C
Front Temperature	392 to 491 °F	200 to 255 °C
Nozzle Temperature	392 to 482 °F	200 to 250 °C
Processing (Melt) Temp	392 to 482 °F	200 to 250 °C
Mold Temperature	55 to 110 °F	13 to 43 °C
Back Pressure	0.00 to 50.0 psi	0.00 to 0.345 MPa

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Injection	Typical Value (English)	Typical Value (SI)
Screw Speed	50 to 100 rpm	50 to 100 rpm
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).

Regrind levels up to 20% can be used with GLS AC1-595 Classical Blue 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 AC1-595 Classical Blue 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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