



## GLS 287-094

### Thermoplastic Elastomer

#### Key Characteristics

##### Product Description

GLS 287-094 is a custom, precolor grey TPE compound

##### General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Adhesion	• Good Processability	• Good Surface Finish
Appearance	• Grey		
Processing Method	• Injection Molding		

#### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.11	1.11	ASTM D792
Elastomers	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Stress <sup>2, 3</sup> (300% Strain, 73°F (23°C))	370 psi	2.55 MPa	ASTM D412
Tensile Strength <sup>2, 3</sup> (Break, 73°F (23°C))	370 psi	2.55 MPa	ASTM D412
Tensile Elongation <sup>2, 3</sup> (Break, 73°F (23°C))	370 %	370 %	ASTM D412
Hardness	Typical Value (English)	Typical Value (SI)	Test Method
Durometer Hardness (Shore A, 10 sec)	59	59	ASTM D2240
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Apparent Viscosity 392°F (200°C), 11200 sec <sup>-1</sup>	20.0 Pa·s	20.0 Pa·s	ASTM D3835

#### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Suggested Max Regrind	20 %	20 %
Rear Temperature	330 to 380 °F	166 to 193 °C
Middle Temperature	480 to 500 °F	249 to 260 °C
Front Temperature	490 to 530 °F	254 to 277 °C
Nozzle Temperature	490 to 530 °F	254 to 277 °C
Processing (Melt) Temp	500 to 530 °F	260 to 277 °C
Mold Temperature	60.0 to 100 °F	15.6 to 37.8 °C
Back Pressure	0.00 to 100 psi	0.00 to 0.689 MPa
Screw Speed	75 to 175 rpm	75 to 175 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 polpropylene (PP).

Regrind levels up to 20% can be used with GLS 287-094 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 287-094 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 8 - 10 minutes or longer.

Drying is not Required

Injection Speed: 2.5 to 5 in/sec  
 1st Stage - Boost Pressure: 400 to 600 psi  
 2nd Stage - Hold Pressure: 30% of Boost  
 Hold Time (Thick Part): 3 to 6 sec  
 Hold Time (Thin Part): 1 to 3 sec

**Notes**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> Die C

<sup>3</sup> 2 hr

**CONTACT INFORMATION****Americas**

United States - Avon Lake  
 +1 440 930 1000

United States - McHenry  
 +1 815 385 8500

**Asia**

China - Guangzhou  
 +86 20 8732 7260

China - Shenzhen  
 +86 755 2969 2888

China - Suzhou  
 +86 512 6823 24 38

China - Suzhou  
 +86 512 6265 2600

Hong Kong -  
 +852 2690 5332

Taiwan - Yonghe City,  
 +886 9396 99740, +886 2929 1849

**Europe**

Germany - Gaggenau  
 +49 7225 6802 0

Spain - Barbaastro (Huesca)  
 +34 974 310 314



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www.polyone.com

**PolyOne Americas**

33587 Walker Road  
 Avon Lake, Ohio 44012  
 United States  
 +1 440 930 1000  
 +1 866 POLYONE

**PolyOne Asia**

No. 88 Guoshoujing Road  
 Z.J Hi-tech Park, Pudong  
 Shanghai, 201203, China  
 +86 21 5080 1188

**PolyOne Europe**

6 Giällewee  
 +352 269 050 35

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