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Product Data Sheet & General Processing Conditions

Polabond® 6041-55A Speciality Thermoplastic Elastomer PC, PMMA, ABS & alloys bondable

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.04	1.04	D 792
MECHANICAL			
Tensile Strength			
Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	650 psi	4 MPa	D 412
Tensile Elongation			
Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	650.0 %	650.0 %	D 412
Tensile Stress			
Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min)			
@ 100 %	205.0 psi	1.4 MPa	D 412
Tear Strength, Die C	110.0 pli	19.3 N/mm	D 624
Peel Strength ***			
90 degrees, 20 in/min (500 mm/min)			
ABS, Failure Type D	22.0 pli	3.9 N/mm	RTP 55
ABS/Nylon, Failure Type D	19.0 pli	3.3 N/mm	RTP 55
Compression Set			
22 h @ 23 °C (73 °F), Method B, Type 2	30 %	30 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	42 %	42 %	D 395
Hardness			
Shore A, 10 s delay	56	56	D 2240

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

*** Values per RTP Company testing. Failure types: R=overmold failure, D=interface failure, S=substrate failure.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Melt Temperature	410 - 485 °F	210 - 252 °C
Mold Temperature	75 - 125 °F	24 - 52 °C
Drying	2 - 4 hrs @ 160 °F	2 - 4 hrs @ 71 °C
Moisture Content	< 0.05 %	< 0.05 %