



**Product Data Sheet &  
General Processing Conditions**

**Nylabond® 6091 B-60A NATURAL  
Speciality Thermoplastic Elastomer  
PA-6 bondable  
manufactured with Santoprene™ TPV  
technology**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	0.93	0.93	D 792

**MECHANICAL**

Tensile Strength 20 in/min (500 mm/min)	560 psi	4 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	300.0 %	300.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	340.0 psi	2.3 MPa	D 412
Tear Strength, Die C	88.0 pli	15.4 N/mm	D 624
Compression Set 22 h @ 70 °C (158 °F), Method B, Type 2	41 %	41 %	D 395
22 h @ 125 °C (257 °F), Method B, Type 2	59 %	59 %	D 395
Hardness Shore A, 10 s delay	67	67	D 2240

**THERMAL**

Ignition Resistance* Automotive**	≤ 4.0 in/mi @ 0.080 in	≤ 102 mm/mi @ 2.0 mm	FMVSS 302
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**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.

\* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

\*\* Values per RTP Company testing.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Melt Temperature	505 - 540 °F	263 - 282 °C
Mold Temperature	90 - 160 °F	32 - 71 °C
Drying	4 hrs @ 180 °F	4 hrs @ 82 °C
Moisture Content	< 0.08 %	< 0.08 %