



**Product Data Sheet &  
General Processing Conditions**

**Nylabond® 6091-55A BLACK  
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	0.94	0.94	D 792
<b>MECHANICAL</b>			
Tensile Strength 20 in/min (500 mm/min)	440 psi	3 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 %	250.0 psi	1.7 MPa	D 412
Tear Strength, Die C	76.0 pli	13.3 N/mm	D 624
Compression Set 22 h @ 70 °C (158 °F), Method B, Type 2	35 %	35 %	D 395
22 h @ 100 °C (212 °F), Method B, Type 2	39 %	39 %	D 395
70 h @ 100 °C (212 °F), Method B, Type 2	46 %	46 %	D 395
22 h @ 125 °C (257 °F), Method B, Type 2	56 %	56 %	D 395
Hardness Shore A, 10 s delay	57	57	D 2240
<b>THERMAL</b>			
Ignition Resistance* Flammability Automotive	HB @ 0.044 in ≤ 4.0 in/mi @ 0.080 in	HB @ 1.1 mm ≤ 102 mm/mi @ 2.0 mm	UL94 FMVSS 302

**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.

**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 %