



**Product Data Sheet &
General Processing Conditions**

**Nylabond® 6091-70A BLACK
Speciality Thermoplastic Elastomer
PA-6 bondable
manufactured with Santoprene™ TPV
technology**



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	0.94	0.94	D 792
MECHANICAL			
Tensile Strength 20 in/min (500 mm/min)	685 psi	5 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	340.0 %	340.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	400.0 psi	2.8 MPa	D 412
Tear Strength, Die C	110.0 pli	19.3 N/mm	D 624
Compression Set 22 h @ 70 °C (158 °F), Method B, Type 2	44 %	44 %	D 395
22 h @ 125 °C (257 °F), Method B, Type 2	63 %	63 %	D 395
Hardness Shore A, 10 s delay	71	71	D 2240
THERMAL			
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
Glow Wire Ignitability Temperature	725 °C @ 1/16 in	725 °C @ 1.5 mm	IEC 60695-2-13
Glow Wire Flammability Index	700 °C @ 1/16 in	700 °C @ 1.5 mm	IEC 60695-2-12

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

	English	SI Metric
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 %