



**Product Data Sheet &
General Processing Conditions**

**Nylabond® 6091-85A 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)	1060 psi	7 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	400.0 %	400.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	640.0 psi	4.4 MPa	D 412
Tear Strength, Die C	164.0 pli	28.7 N/mm	D 624
Compression Set 22 h @ 70 °C (158 °F), Method B, Type 2	50 %	50 %	D 395
22 h @ 125 °C (257 °F), Method B, Type 2	69 %	69 %	D 395
Hardness Shore A, 10 s delay	84	84	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

	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 %