



**Product Data Sheet &
General Processing Conditions**

**Nylabond® 6091-85A NATURAL
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	0.93	0.93	D 792
MECHANICAL			
Tensile Strength 20 in/min (500 mm/min)	995 psi	7 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	420.0 %	420.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	600.0 psi	4.1 MPa	D 412
Tear Strength, Die C	161.0 pli	28.2 N/mm	D 624
Compression Set 22 h @ 70 °C (158 °F), Method B, Type 2	57 %	57 %	D 395
22 h @ 125 °C (257 °F), Method B, Type 2	77 %	77 %	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

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 %