



**Product Data Sheet &  
General Processing Conditions**

**Polabond® 6003-45A  
Speciality Thermoplastic Elastomer  
PC/PMMA, PC/PBT bondable**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	0.96	0.96	D 792
<b>MECHANICAL</b>			
Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	780 psi	5 MPa	D 412
Tensile Elongation Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	630.0 %	630.0 %	D 412
Tensile Stress Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min) @ 100 %	220.0 psi	1.5 MPa	D 412
Tear Strength, Die C	140.0 pli	24.5 N/mm	D 624
Peel Strength *** 90 degrees, 20 in/min (500 mm/min)			
PC/PMMA, Failure Type D	24.0 pli	4.2 N/mm	RTP 55
PC/PBT, Failure Type D	20.0 pli	3.5 N/mm	RTP 55
Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2	16 %	16 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	66 %	66 %	D 395
Hardness Shore A, 10 s delay	45	45	D 2240

**THERMAL**

Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635
--	--------------	-------------	-------

**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.

\*\*\* Values per RTP Company testing. Failure types: R=overmold failure, D=interface failure, S=substrate failure.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Melt Temperature	380 - 460 °F	193 - 238 °C
Mold Temperature	70 - 120 °F	21 - 49 °C
Drying	2 - 4 hrs @ 180 °F	2 - 4 hrs @ 82 °C
Moisture Content	< 0.03 %	< 0.03 %
Dew Point	0 °F	-18 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.