



**Product Data Sheet &
General Processing Conditions**

**Polabond® 6003-55A MD
Speciality Thermoplastic Elastomer
PC/PMMA, PC/PBT bondable
ISO 10993 tested**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	0.98	0.98	D 792
MECHANICAL			
Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	900 psi	6 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 %	300.0 psi	2.1 MPa	D 412
Tear Strength, Die C	170.0 pli	29.8 N/mm	D 624
Peel Strength *** 90 degrees, 20 in/min (500 mm/min) PC/PMMA, Failure Type D	33.0 pli	5.8 N/mm	RTP 55
PC/PBT, Failure Type D	31.0 pli	5.4 N/mm	RTP 55
CoPolyester, Failure Type R	25.0 pli	4.4 N/mm	RTP 55
Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2	19 %	19 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	65 %	65 %	D 395
Hardness Shore A, 10 s delay	55	55	D 2240

THERMAL

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

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

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
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