



**Product Data Sheet &  
General Processing Conditions**

**Polabond® 6003-75A MD  
Speciality Thermoplastic Elastomer  
PC/PMMA, PC/PBT bondable  
ISO 10993 tested**

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

| <b>PERMANENCE</b>  | <b>English</b> | <b>SI Metric</b> | <b>ASTM TEST</b> |
|--|----------------|------------------|------------------|
| Specific Gravity   | 1.02           | 1.02             | D 792            |
| <b>MECHANICAL</b>  |                |                  |                  |
| Tensile Strength<br>Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)                 | 1200 psi       | 8 MPa            | D 412            |
| Tensile Elongation<br>Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)        | 680.0 %        | 680.0 %          | D 412            |
| Tensile Stress<br>Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min)<br>@ 100 %        | 455.0 psi      | 3.1 MPa          | D 412            |
| Tear Strength, Die C   | 270.0 pli      | 47.3 N/mm        | D 624            |
| Peel Strength ***<br>90 degrees, 20 in/min (500 mm/min)<br>PC/PMMA, Failure Type R | 35.0 pli       | 6.1 N/mm         | RTP 55           |
| PC/PBT, Failure Type R   | 35.0 pli       | 6.1 N/mm         | RTP 55           |
| Compression Set<br>22 h @ 23 °C (73 °F), Method B, Type 2                          | 23 %           | 23 %             | D 395            |
| 22 h @ 70 °C (158 °F), Method B, Type 2  | 65 %           | 65 %             | D 395            |
| Hardness<br>Shore A, 10 s delay  | 75             | 75               | D 2240           |
| <b>THERMAL</b>   |                |                  |                  |
| Ignition Resistance*<br>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 | < 0.05 %           | < 0.05 %          |
| Dew Point        | 0 °F               | -18 °C            |

**PROCESSING NOTES**

Desiccant Type Dryer Required.