



**Product Data Sheet &  
General Processing Conditions**

**Polabond® 6042-50A MD  
Speciality Thermoplastic Elastomer  
PC, ABS 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	1.09	1.09	D 792
<b>MECHANICAL</b>			
Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	1000 psi	7 MPa	D 412
Tensile Elongation Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	430.0 %	430.0 %	D 412
Tensile Stress Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min) @ 100 %	210.0 psi	1.4 MPa	D 412
Tear Strength, Die C	150.0 pli	26.3 N/mm	D 624
Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2	20 %	20 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	75 %	75 %	D 395
Hardness Shore A, 10 s delay	50	50	D 2240
<b>THERMAL</b>			
Ignition Resistance* Flammability**	HB @ 1/32 in	HB @ 0.8 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.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Melt Temperature	360 - 450 °F	182 - 232 °C
Mold Temperature	60 - 90 °F	16 - 32 °C
Drying	2 hrs @ 175 °F	2 hrs @ 79 °C
Moisture Content	< 0.03 %	< 0.03 %
Dew Point	0 °F	-18 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.