



**Product Data Sheet &
General Processing Conditions**

**Polabond® 6042-50A
Speciality Thermoplastic Elastomer
PC, ABS bondable**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.09	1.09	D 792
MECHANICAL			
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
Peel Strength *** 90 degrees, 20 in/min (500 mm/min) PC, Failure Type R	20.0 pli	3.5 N/mm	RTP 55
ABS, Failure Type D	17.0 pli	3.0 N/mm	RTP 55
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

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.
*** 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	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.