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Product Data Sheet &
General Processing Conditions

Polabond® 6042-70A
Speciality Thermoplastic Elastomer
PC, ABS bondable

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.17	1.17	D 792
MECHANICAL			
Tensile Strength			
Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	1450 psi	10 MPa	D 412
Tensile Elongation			
Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	510.0 %	510.0 %	D 412
Tensile Stress			
Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min)			
@ 100 %	370.0 psi	2.6 MPa	D 412
Tear Strength, Die C	225.0 pli	39.4 N/mm	D 624
Peel Strength ***			
90 degrees, 20 in/min (500 mm/min)			
PC, Failure Type R	50.0 pli	8.8 N/mm	RTP 55
ABS, Failure Type R	> 40.0 pli	> 7.0 N/mm	RTP 55
Compression Set			
22 h @ 23 °C (73 °F), Method B, Type 2	25 %	25 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	80 %	80 %	D 395
Hardness			
Shore A, 10 s delay	70	70	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

	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.