



**Product Data Sheet &
General Processing Conditions**

**Nylabond® 7091 100-80B Black
Thermoplastic Vulcanizate (TPV)**

Shore A (15s) = 83.5A

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.13	1.13	D 792
Melt Flow Rate @ 230 °C, / 21.6 kg	4.00 - 8.00 g/10 min	4.00 - 8.00 g/10 min	D 1238

MECHANICAL

Tensile Strength 20 in/min (500 mm/min)	1300 psi	9 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	215.0 %	215.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	1000.0 psi	6.9 MPa	D 412
Tear Strength, Die C	160.0 pli	28.0 N/mm	D 624
Hardness Shore A, 10 s delay	85	85	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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Melt Temperature	540 - 570 °F	282 - 299 °C
Mold Temperature	180 - 200 °F	82 - 93 °C
Drying	4 - 6 hrs @ 200 - 220 °F	4 - 6 hrs @ 93 - 104 °C
Moisture Content	< 0.07 %	< 0.07 %
Dew Point	-40 °F	-40 °C

PROCESSING NOTES

Desiccant Type Dryer Required.