

**FORPRENE® 6K5901A60 NERO - TPV**

Physical properties	Value	Unit	Test Standard
Density	60.8	lb/ft <sup>3</sup>	ISO 1183
Mechanical properties (TPE)	Value	Unit	Test Standard
Tensile stress at 100%, perpendicular	319	psi	ISO 37
Tensile stress at 300%, perpendicular	493	psi	ISO 37
Compression set, 70 °C, 22h, Type A	34	%	ISO 815
Tensile strain at break, perpendicular	558	%	ISO 37
Tensile stress at break, perpendicular	870	psi	ISO 37
Shore A hardness-TPE, 15s	63	-	ISO 868
Tear strength, Method Ba, perpendicular	143	lb/in	ISO 34-1
Tensile set (elastomers)	12	%	ASTM D412

**Typical injection moulding processing conditions**

Temperature	Value	Unit
Zone1 temperature	320 - 338	°F
Zone2 temperature	347 - 365	°F
Zone3 temperature	356 - 374	°F
Nozzle temperature	329 - 347	°F
Mold temperature	104 - 140	°F

**Typical extrusion processing conditions**

Temperature	Value	Unit
Zone 1 temperature	320 - 338	°F
Zone 2 temperature	347 - 365	°F
Zone 3 temperature	356 - 374	°F
Die head temperature	365 - 383	°F

**Other text information**
**Pre-drying**

3h@80C

**Longer pre-drying times/storage**

Forprene must be stored indoors in the original, unopened and undamaged packaging, away from direct sunlight, moisture and heat.

**Characteristics**

<b>Special Characteristics</b>	Auto spec approved, UV resistant
<b>Processing</b>	Injection molding

**Other Approvals**

<b>OEM</b>	<b>Specification</b>
VW Group	VW50123