



**Product Data Sheet &
General Processing Conditions**

**Nylabond® 7091 131-90B Black
Thermoplastic Vulcanizate (TPV)**

Shore A (15s) = 94A

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.11	1.11	D 792
Melt Flow Rate @ 230 °C, / 21.6 kg	2.00 - 8.00 g/10 min	2.00 - 8.00 g/10 min	D 1238

MECHANICAL

Tensile Strength 20 in/min (500 mm/min)	2000 psi	14 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	200.0 %	200.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	1600.0 psi	11.0 MPa	D 412
Tear Strength, Die C	310.0 pli	54.3 N/mm	D 624
Hardness			
Shore A, 10 s delay	96	96	D 2240
Shore D, instantaneous	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.

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.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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