



**Product Data Sheet &
General Processing Conditions**

**Polabond® 6041-55A
Speciality Thermoplastic Elastomer
PC, PMMA, ABS & alloys bondable**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.04	1.04	D 792
MECHANICAL			
Tensile Strength Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	650 psi	4 MPa	D 412
Tensile Elongation Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)	650.0 %	650.0 %	D 412
Tensile Stress Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min) @ 100 %	205.0 psi	1.4 MPa	D 412
Tear Strength, Die C	110.0 pli	19.3 N/mm	D 624
Peel Strength *** 90 degrees, 20 in/min (500 mm/min)			
ABS, Failure Type D	22.0 pli	3.9 N/mm	RTP 55
ABS/Nylon, Failure Type D	19.0 pli	3.3 N/mm	RTP 55
Compression Set 22 h @ 23 °C (73 °F), Method B, Type 2	30 %	30 %	D 395
22 h @ 70 °C (158 °F), Method B, Type 2	42 %	42 %	D 395
Hardness Shore A, 10 s delay	56	56	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	410 - 485 °F	210 - 252 °C
Mold Temperature	75 - 125 °F	24 - 52 °C
Drying	2 - 4 hrs @ 160 °F	2 - 4 hrs @ 71 °C
Moisture Content	< 0.05 %	< 0.05 %

PROCESSING NOTES

21 Mar 2018 SAC

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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