



**Product Data Sheet &  
General Processing Conditions**

**Polabond® 6042-70A MD  
Speciality Thermoplastic Elastomer  
PC, ABS bondable  
ISO 10993 tested**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.17	1.17	D 792
<b>MECHANICAL</b>			
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
<b>THERMAL</b>			
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**

	<b>English</b>	<b>SI Metric</b>
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.

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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