



Product Data Sheet & General Processing Conditions

Nylabond® 6091-70A BLACK Speciality Thermoplastic Elastomer PA-6 bondable



PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	0.94	0.94	D 792
MECHANICAL			
Tensile Strength 20 in/min (500 mm/min)	685 psi	5 MPa	D 412
Tensile Elongation Break, 20 in/min (500 mm/min)	340.0 %	340.0 %	D 412
Tensile Stress 20 in/min (500 mm/min) @ 100 %	400.0 psi 110.0 pli	2.8 MPa 19.3 N/mm	D 412 D 624
Tear Strength, Die C			
Compression Set 22 h @ 70 °C (158 °F), Method B, Type 2 22 h @ 125 °C (257 °F), Method B, Type 2	44 % 63 %	44 % 63 %	D 395 D 395
Hardness Shore A, 10 s delay	71	71	D 2240
THERMAL			
Ignition Resistance*			
Flammability Automotive	HB @ 0.044 in ≤ 4.0 in/mi @ 0.080 in	HB @ 1.1 mm ≤ 102 mm/mi @ 2.0 mm	UL94 FMVSS 302
Glow Wire Ignitability Temperature	725 °C @ 1/16 in	725 °C @ 1.5 mm	IEC 60695-2-13
Glow Wire Flammability Index	700 °C @ 1/16 in	700 °C @ 1.5 mm	IEC 60695-2-12

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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Melt Temperature	505 - 540 °F	263 - 282 °C
Mold Temperature	90 - 160 °F	32 - 71 °C
Drying	4 hrs @ 180 °F	4 hrs @ 82 °C
Moisture Content	< 0.08 %	< 0.08 %

PROCESSING NOTES

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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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