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## Product Data Sheet & General Processing Conditions

### Polabond® 6042-50A HF Speciality Thermoplastic Elastomer PC, ABS bondable High Flow

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

| PERMANENCE                                                                  | English   | SI Metric | ASTM<br>TEST |
|-----------------------------------------------------------------------------|-----------|-----------|--------------|
| Specific Gravity                                                            | 1.07      | 1.07      | D 792        |
| <b>MECHANICAL</b>                                                           |           |           |              |
| Tensile Strength<br>Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min)          | 650 psi   | 4 MPa     | D 412        |
| Tensile Elongation<br>Break, Die C, 0.125 in, 20 in/min (3.2mm, 500 mm/min) | > 700.0 % | > 700.0 % | D 412        |
| Tensile Stress<br>Die C 0.125 in, 20 in/min (3.2 mm, 500 mm/min)<br>@ 100 % | 155.0 psi | 1.1 MPa   | D 412        |
| Tear Strength, Die C                                                        | 115.0 pli | 20.2 N/mm | D 624        |
| Compression Set<br>22 h @ 23 °C (73 °F), Method B, Type 2                   | 24 %      | 24 %      | D 395        |
| 22 h @ 70 °C (158 °F), Method B, Type 2                                     | 70 %      | 70 %      | D 395        |
| Hardness<br>Shore A, 10 s delay                                             | 47        | 47        | 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 | 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.