

Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 6401U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

General			
Processing Method	• Injection Molding		
Part Marking Code (ISO 11469)	• >ABS+PA<		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.07 g/cm ³	1.07 g/cm ³	ISO 1183/A
Melt Mass-Flow Rate (MFR) (240°C/10.0 kg)	33 g/10 min	33 g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow : 48 hr	1.4 %	1.4 %	
Flow : 48 hr	1.2 %	1.2 %	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus (0.157 in (4.00 mm))	282000 psi	1950 MPa	ISO 527-2/1A/1
Tensile Stress (Yield, 0.157 in (4.00 mm))	5820 psi	40.1 MPa	ISO 527-2/1A/50
Tensile Elongation ¹			ISO 527-2
Break, 0.157 in (4.00 mm)	88 %	88 %	
Flexural Modulus - Chord ²			ISO 178
72°F (22°C), 0.157 in (4.00 mm), 2.52 in (64.0 mm) Span	294000 psi	2030 MPa	
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	9.4 ft·lb/in ²	20 kJ/m ²	
72°F (22°C)	38 ft·lb/in ²	79 kJ/m ²	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed, 0.157 in (4.00 mm)	208 °F	97.9 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed, 0.157 in (4.00 mm)	151 °F	66.2 °C	ISO 75-2/Af
Vicat Softening Temperature	241 °F	116 °C	ISO 306/B50
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	1.6 in/min	40 mm/min	ISO 3795
0.0787 in (2.00 mm)	1.6 in/min	40 mm/min	FMVSS 302

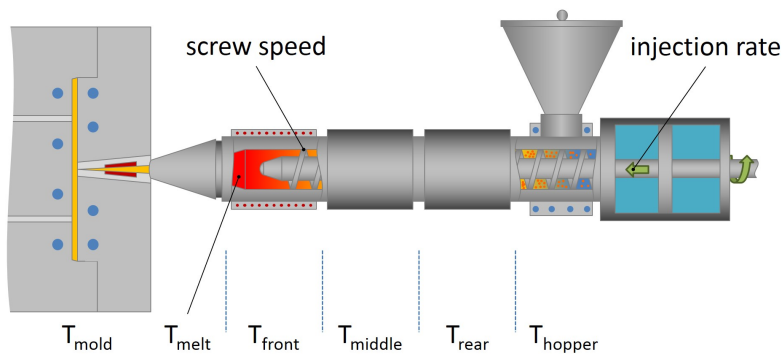
Additional Information

- 1.) Not for use in food contact applications
- 2.) Not for use in medical or pharmaceutical applications

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Injection	Nominal Value (English)	Nominal Value (SI)
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

¹ 2.0 in/min (50 mm/min)

² 0.079 in/min (2.0 mm/min)

Notes

These are typical property values not to be construed as specification limits.