

Technical Data Sheet

Schulablend (ABS/PA) M/MK 6501SF U NAT



Acrylonitrile Butadiene Styrene + PA

Product Description

High flow ABS/PA6 blend, high impact strength, UV stabilised. (Former name: SCHULABLEND M/MK 2004 SF)

Processing Method Injection Molding

Resin ID PA+ABS

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/5.0 kg)	10	cm ³ /10 min	ISO 1133
Density, (Method A)	1.08	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield			
(Type 1A, 50 mm/min)	40.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	28.0	MPa	ISO 527-2
Tensile Strain at Break			
(Type 1A, 50 mm/min)	120	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	200	%	ISO 527-2
Flexural Modulus, (2.0 mm/min)	1700	MPa	ISO 178
Tensile Strain at Yield			
(Type 1A, 50 mm/min)	3.4	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	16	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 50 mm/min)	40.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	38.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	1800	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	850	MPa	ISO 527-1
Flexural Stress			
(2.0 mm/min, 3.5%)	50.0	MPa	ISO 178
(2.0 mm/min, 6.0%)	50.0	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	80	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	30	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	88	kJ/m ²	ISO 179

Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break	ISO 179	
(-30 °C, Type 1, Edgewise)	No Break	ISO 179	
(23 °C, Type 1, Edgewise) - Conditioned	No Break	ISO 179	
Thermal			
Vicat Softening Temperature, (B (50N), 50 °C/h)	129 °C	ISO 306	
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	60.0 °C	ISO 75-2/A	
Flammable			
Burning Rate			
(2.00 mm)	<100 mm/min	ISO 3795	
(2.00 mm)	<100 mm/min	FMVSS 302	

Injection Parameters	Nominal	
	Value	Units
Drying Time	4	hr
Drying Temperature	80	°C
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	40 to 80	°C