

SCHULABLEND® (ABS/PA) M/MK 6503 U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description

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

General

Automotive Specifications	• GM QK 002451 U Color: 14735 Cocoa	• GM QK 002451 U Color: 72765 Jet Black
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA+ABS	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.08 g/cm³	1.08 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	15 cm³/10min	15 cm³/10min	ISO 1133
Molding Shrinkage	0.80 to 1.2 %	0.80 to 1.2 %	ISO 294-4

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	247000 psi	1700 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	5800 psi	40.0 MPa	ISO 527-2/1A/50
Tensile Strain			
Yield	4.0 %	4.0 %	ISO 527-2/1A/50
Break	120 %	120 %	ISO 527-2/1A/5
Flexural Modulus ¹	189000 psi	1300 MPa	ISO 178
Flexural Stress ¹			ISO 178
7.0% Strain	6670 psi	46.0 MPa	
3.5% Strain	5370 psi	37.0 MPa	

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	8.6 ft·lb/in²	18 kJ/m²	
73°F (23°C)	38 ft·lb/in²	80 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	

Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	13200 psi	91.0 MPa	ISO 2039-1

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	203 °F	95.0 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	154 °F	68.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	392 °F	200 °C	ISO 306/A50
--	284 °F	140 °C	ISO 306/B50

Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1

Technical Data Sheet

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

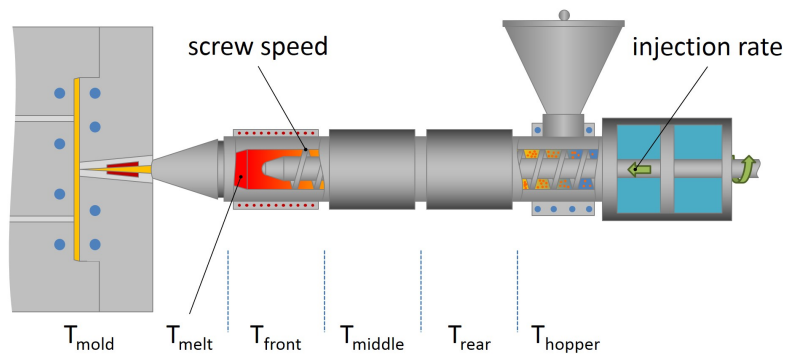
Additional Information

- 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)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

¹ 0.079 in/min (2.0 mm/min)

Notes

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