Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 6101 GF8 SF U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description
8% glass fiber reinforced ABS/PA6 blend with high impact strength, high flow, UV-stabilized. (Former name: M/MK GF8 SF UV)

General	
Filler / Reinforcement	• Glass Fiber, 8.0% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA ABS GF8

Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR)				ISO 1133
250°C/5.0 kg	5.00	--	cm³/10min	
260°C/5.0 kg	9.00	--	cm³/10min	
Molding Shrinkage				ISO 294-4
Across Flow	1.0	--	%	
Flow	0.40	--	%	

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	392000 (2700)	363000 (2500)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	6820 (47.0)	5800 (40.0)	psi (MPa)	ISO 527-2/1/5
Tensile Strain (Break)	3.5	--	%	ISO 527-2/1/5
Flexural Modulus [1]	348000 (2400)	--	psi (MPa)	ISO 178
Flexural Stress [1]				ISO 178
6.0% Strain	11300 (78.0)	--	psi (MPa)	
3.5% Strain	10200 (70.0)	--	psi (MPa)	

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	2.4 (5.0)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	7.1 (15)	11 (24)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	33 (70)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	26 (55)	38 (80)	ft·lb/in² (kJ/m²)	

Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	15800 (109)	--	psi (MPa)	ISO 2039-1

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Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	201 (94.0)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	320 (160)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	392 (200)	--	°F (°C)	ISO 306/A50
--	275 (135)	--	°F (°C)	ISO 306/B50
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+15	> 1.0E+12	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·m	IEC 62631-3-1
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate				
0.0787 in (2.00 mm)	1.6 (40)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	1.6 (40)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		

Additional Information

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

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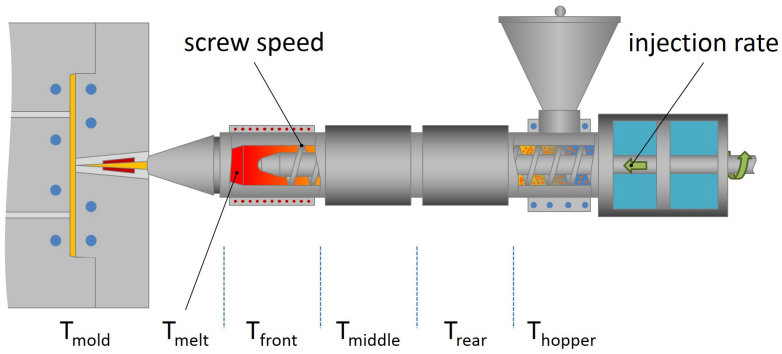

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

[1] 0.079 in/min (2.0 mm/min)

Notes

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