Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 6101 GF8

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description
8% glass fiber reinforced ABS/PA6 blend standard injection molding grade. (Former name: SCHULABLEND® M/MK GF8)

General	
Filler / Reinforcement	• Glass Fiber, 8.0% Filler by Weight
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.10 g/cm³	1.10 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	4.00 cm³/10min	4.00 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	392000 psi	2700 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	7690 psi	53.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0 %	4.0 %	ISO 527-2/1A/50
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength (73°F (23°C))	6.2 ft·lb/in²	13 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
73°F (23°C)	33 ft·lb/in²	70 kJ/m²	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Ball Indentation Hardness (H 358/30)	13500 psi	93.0 MPa	ISO 2039-1
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	306 °F	152 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	169 °F	76.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	374 °F	190 °C	ISO 306/A50
--	239 °F	115 °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
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
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.6 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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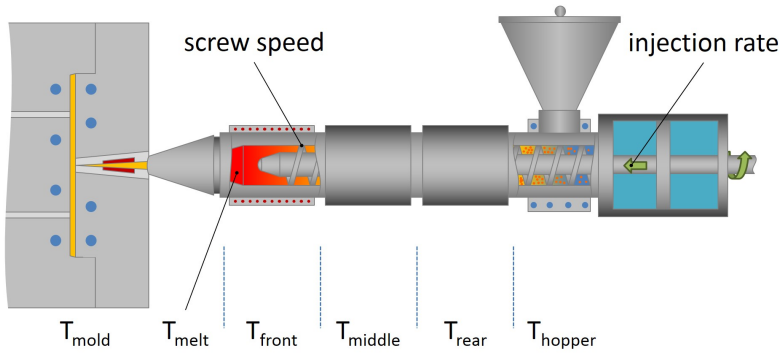

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

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