Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 6301 E

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description
PA/ABS high impact strength and chemical resistance, UV-stabilized for Extrusion applications. (Former name: M/MK E)

General			
Features	• Chemical Resistant	• High Impact Resistance	• UV Resistant
UL File Number	• E86615		
Processing Method	• Extrusion		
Resin ID (ISO 1043)	• ABS-PA		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.05	--	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	0.400	--	cm³/10min	ISO 1133
Molding Shrinkage	0.80 to 1.2	--	%	ISO 294-4
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	236000 (1630)	167000 (1150)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Yield)	5510 (38.0)	4350 (30.0)	psi (MPa)	ISO 527-2/1A/50
Tensile Strain				
Yield	4.0	12	%	ISO 527-2/1A/50
Break	85	90	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	7.6 (16)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	21 (45)	29 (60)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	No Break	--		
73°F (23°C)	No Break	No Break		
Hardness	**Dry**	**Conditioned**	**Unit**	**Test Method**
Ball Indentation Hardness (H 358/30)	12300 (85.0)	--	psi (MPa)	ISO 2039-1
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	189 (87.0)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	162 (72.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	266 (130)	--	°F (°C)	ISO 306/A50
--	207 (97.0)	--	°F (°C)	ISO 306/B50

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Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	> 1.0E+12	ohms	IEC 62631-3-2
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·cm	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	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in (1.5 mm)	1200 (650)	--	°F (°C)	
0.12 in (3.0 mm)	1200 (650)	--	°F (°C)	

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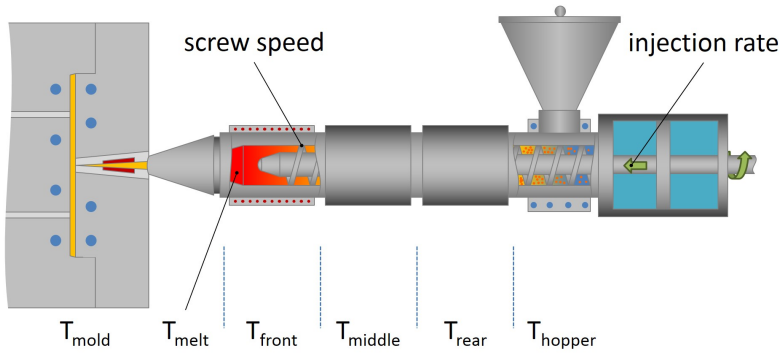

Injection	Dry (English)	Dry (SI)
Mold Temperature	104 to 176 °F	40 to 80 °C

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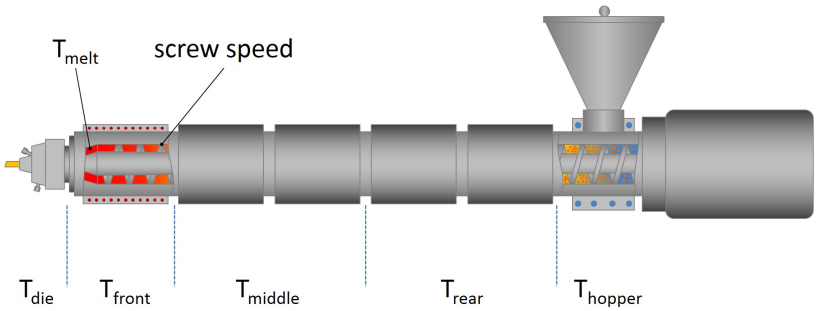

Extrusion	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Melt Temperature	446 to 518 °F	230 to 270 °C

Notes

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