**Technical Data Sheet**

# SCHULABLEND® (ABS/PA) M/MK 6401U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

| General | |
|---|---|
| Processing Method | • Injection Molding |
| Part Marking Code (ISO 11469) | • >ABS+PA< |

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|---|---|---|
| Density | 1.07 g/cm³ | 1.07 g/cm³ | ISO 1183/A |
| Melt Mass-Flow Rate (MFR) (240°C/10.0 kg) | 33 g/10 min | 33 g/10 min | ISO 1133 |
| Molding Shrinkage | | | ISO 294-4 |
| Across Flow : 48 hr | 1.4 % | 1.4 % | |
| Flow : 48 hr | 1.2 % | 1.2 % | |
| **Mechanical** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Tensile Modulus (0.157 in (4.00 mm)) | 282000 psi | 1950 MPa | ISO 527-2/1A/1 |
| Tensile Stress (Yield, 0.157 in (4.00 mm)) | 5820 psi | 40.1 MPa | ISO 527-2/1A/50 |
| Tensile Elongation [1] | | | ISO 527-2 |
| Break, 0.157 in (4.00 mm) | 88 % | 88 % | |
| Flexural Modulus - Chord [2] | | | ISO 178 |
| 72°F (22°C), 0.157 in (4.00 mm), 2.52 in (64.0 mm) Span | 294000 psi | 2030 MPa | |
| **Impact** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Charpy Notched Impact Strength | | | ISO 179/1eA |
| -22°F (-30°C) | 9.4 ft·lb/in² | 20 kJ/m² | |
| 72°F (22°C) | 38 ft·lb/in² | 79 kJ/m² | |
| **Thermal** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Heat Deflection Temperature | | | |
| 66 psi (0.45 MPa), Unannealed, 0.157 in (4.00 mm) | 208 °F | 97.9 °C | ISO 75-2/Bf |
| 264 psi (1.8 MPa), Unannealed, 0.157 in (4.00 mm) | 151 °F | 66.2 °C | ISO 75-2/Af |
| Vicat Softening Temperature | 241 °F | 116 °C | ISO 306/B50 |
| **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 |

**Additional Information**

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

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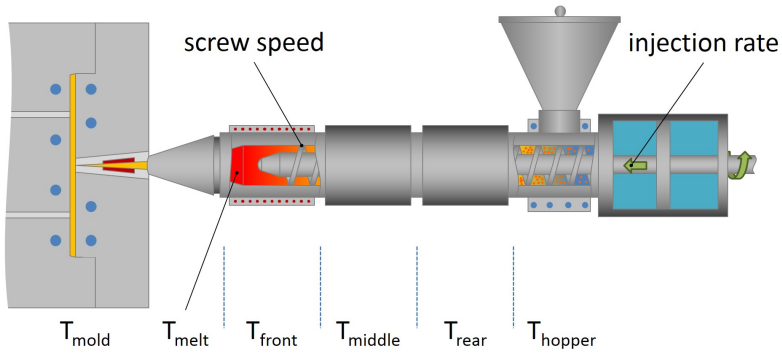


| Injection | Nominal Value (English) | Nominal Value (SI) |
|---|---|---|
| Suggested Max Moisture | 0.04 to 0.10 % | 0.04 to 0.10 % |
| Processing (Melt) Temp | 446 to 518 °F | 230 to 270 °C |
| Mold Temperature | 104 to 176 °F | 40 to 80 °C |

**Notes**

[1] 2.0 in/min (50 mm/min)

[2] 0.079 in/min (2.0 mm/min)

**Notes**

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