Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 6501 LE SF U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description
High flow ABS/PA6 blend, high impact strength, UV stabilised with optimized Low emission performance for automotive interior applications. (Former name: SCHULABLEND® M/MK K2004 SF LE)

General	
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA+ABS

Physical	Dry	Conditioned	Unit	Test Method
Density	1.08	--	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	10	--	cm³/10min	ISO 1133
Molding Shrinkage	0.80 to 1.2	--	%	Internal Method
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	261000 (1800)	131000 (900)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress				ISO 527-2/1A/50
Yield	5800 (40.0)	4350 (30.0)	psi (MPa)	
Break	5800 (40.0)	5510 (38.0)	psi (MPa)	
Tensile Strain				ISO 527-2/1A/50
Yield	3.4	21	%	
Break	120	200	%	
Flexural Modulus [1]	247000 (1700)	--	psi (MPa)	ISO 178
Flexural Stress [1]				ISO 178
6.0% Strain	7250 (50.0)	--	psi (MPa)	
3.5% Strain	7250 (50.0)	--	psi (MPa)	
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	14 (30)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	43 (90)	42 (88)	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		

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Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	194 (90.0)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	140 (60.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	392 (200)	--	°F (°C)	ISO 306/A50
--	266 (130)	--	°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)	2.4 (60)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	2.4 (60)	--	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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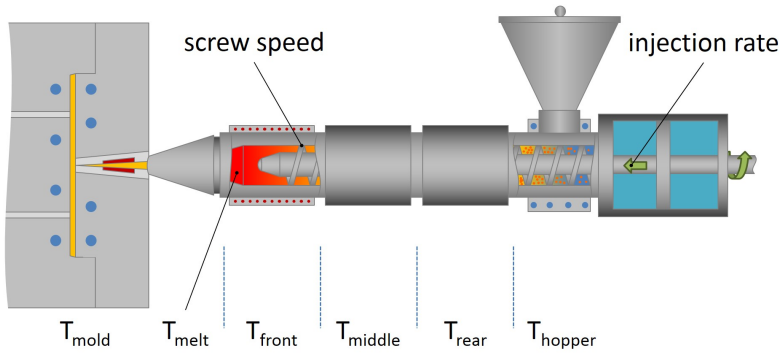

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Injection Notes

For applications that require a higher flow it might be useful to process the material without pre-drying. Material from opened bags should be dried. If material is transferred from cold inventory into warm production environment, it is necessary to apply a short 'warming phase' at 60 °C or store in the production area for >24h to avoid bedewing.

Notes

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

Notes

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