

Technical Data Sheet

# SCHULABLEND<sup>®</sup> (ABS/PA) M/MK 6501 U

Acrylonitrile Butadiene Styrene + PA  
Engineering Plastics

**Product Description**

ABS/PA6 blend with high impact strength, UV stabilised, low emission. (Former name: SCHULABLEND<sup>®</sup> M/MK K2004)

**General**

Additive	• UV Stabilizer
Features	• Good Flow • High Impact Resistance
Processing Method	• Injection Molding
Part Marking Code (ISO 11469)	• >ABS+PA<

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.07 g/cm <sup>3</sup>	1.07 g/cm <sup>3</sup>	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	7.00 cm <sup>3</sup> /10min	7.00 cm <sup>3</sup> /10min	ISO 1133

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	247000 psi	1700 MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	5800 psi	40.0 MPa	
Break	6090 psi	42.0 MPa	
Tensile Strain (Yield)	4.0 %	4.0 %	ISO 527-2/1A/50
Nominal Tensile Strain at Break	90 %	90 %	ISO 527-2/1A/50

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	9.5 ft·lb/in <sup>2</sup>	20 kJ/m <sup>2</sup>	
73°F (23°C)	38 ft·lb/in <sup>2</sup>	80 kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			ISO 75-2/Af
264 psi (1.8 MPa), Unannealed	149 °F	65.0 °C	
Vicat Softening Temperature	257 °F	125 °C	ISO 306/B50

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.6 mm)	HB	HB	
Flammability	< 4 in/min	< 100 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)
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.