Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 6501

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description
ABS/PA6 blend, standard injection molding grade. (Former name: SCHULABLEND® M/MK)

General		
Features	• Chemical Resistant	• High Impact Resistance
Automotive Specifications	• FORD WSS-M4D960-A Color: Black	
UL File Number	• E86615	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• ABS-PA	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.08	--	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	11	--	cm³/10min	ISO 1133
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	247000 (1700)	131000 (900)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Yield)	5660 (39.0)	3920 (27.0)	psi (MPa)	ISO 527-2/1A/50
Tensile Strain (Yield)	3.4	21	%	ISO 527-2/1A/50
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	10 (22)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	38 (80)	43 (91)	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	151 (66.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	399 (204)	--	°F (°C)	ISO 306/A50
--	248 (120)	--	°F (°C)	ISO 306/B50

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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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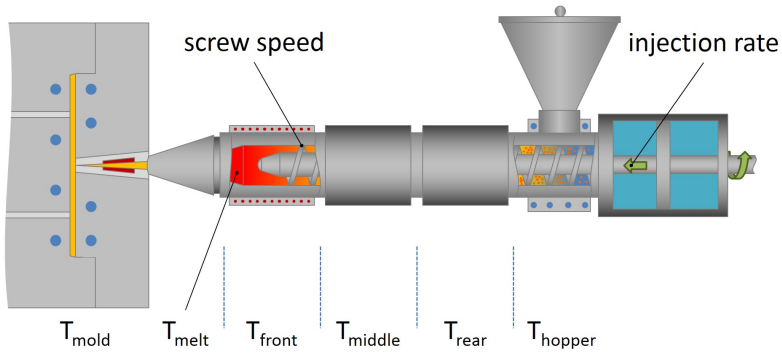

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

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