**Technical Data Sheet**

# SCHULABLEND® (ABS/PA) M/MK 6503 U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

| Product Description | |
|---|---|
| ABS/PA6 blend with high impact strength, UV stabilised. (Former name: SCHULABLEND® M/MK SF UV) | |

| General | | |
|---|---|---|
| Automotive Specifications | • GM QK 002451 U Color: 14735 Cocoa | • GM QK 002451 U Color: 72765 Jet Black |
| Processing Method | • Injection Molding | |
| Resin ID (ISO 1043) | • PA+ABS | |

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|---|---|---|
| Density | 1.08 g/cm³ | 1.08 g/cm³ | ISO 1183/A |
| Melt Volume-Flow Rate (MVR) (260°C/5.0 kg) | 15 cm³/10min | 15 cm³/10min | ISO 1133 |
| Molding Shrinkage | 0.80 to 1.2 % | 0.80 to 1.2 % | ISO 294-4 |
| **Mechanical** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Tensile Modulus | 247000 psi | 1700 MPa | ISO 527-2/1A/1 |
| Tensile Stress (Yield) | 5800 psi | 40.0 MPa | ISO 527-2/1A/50 |
| Tensile Strain | | | |
| Yield | 4.0 % | 4.0 % | ISO 527-2/1A/50 |
| Break | 120 % | 120 % | ISO 527-2/1A/5 |
| Flexural Modulus [1] | 189000 psi | 1300 MPa | ISO 178 |
| Flexural Stress [1] | | | ISO 178 |
| 7.0% Strain | 6670 psi | 46.0 MPa | |
| 3.5% Strain | 5370 psi | 37.0 MPa | |
| **Impact** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Charpy Notched Impact Strength | | | ISO 179/1eA |
| -22°F (-30°C) | 8.6 ft·lb/in² | 18 kJ/m² | |
| 73°F (23°C) | 38 ft·lb/in² | 80 kJ/m² | |
| Charpy Unnotched Impact Strength | | | ISO 179/1eU |
| -22°F (-30°C) | No Break | No Break | |
| 73°F (23°C) | No Break | No Break | |
| **Hardness** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Ball Indentation Hardness (H 358/30) | 13200 psi | 91.0 MPa | ISO 2039-1 |
| **Thermal** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Heat Deflection Temperature | | | |
| 66 psi (0.45 MPa), Unannealed | 203 °F | 95.0 °C | ISO 75-2/Bf |
| 264 psi (1.8 MPa), Unannealed | 154 °F | 68.0 °C | ISO 75-2/Af |
| Vicat Softening Temperature | | | |
| -- | 392 °F | 200 °C | ISO 306/A50 |
| -- | 284 °F | 140 °C | ISO 306/B50 |
| **Electrical** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Surface Resistivity | > 1.0E+15 ohms | > 1.0E+15 ohms | IEC 60093 |
| Volume Resistivity | > 1.0E+13 ohms·m | > 1.0E+13 ohms·m | IEC 62631-3-1 |

**Technical Data Sheet**

# SCHULABLEND® (ABS/PA) M/MK 6503 U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

| 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 (1.5 mm) | HB | HB | |
| 0.12 in (3.0 mm) | HB | HB | |

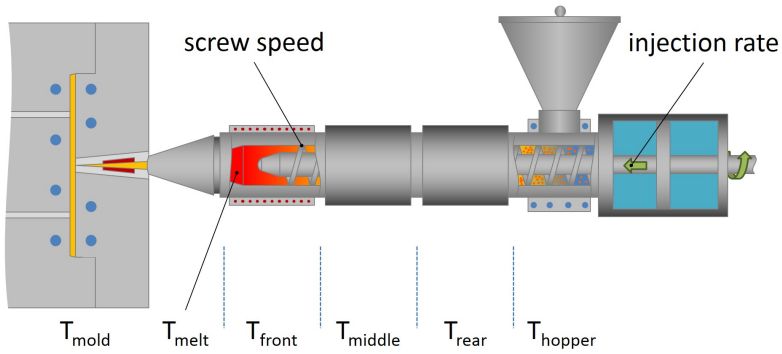
**Additional Information**

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

**Technical Data Sheet**

# SCHULABLEND® (ABS/PA) M/MK 6503 U

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics




| Injection | Nominal Value (English) | Nominal Value (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 |

**Notes**

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

**Notes**

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