Technical Data Sheet

SCHULABLEND® (ABS/PA) M/MK 7101 GF20

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description
20% glass fibre reinforced ABS/PA blend. (Former name: SCHULABLEND® M/MK GF20)

General	
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Processing Method	• Injection Molding
Part Marking Code (ISO 11469)	• >ABS+PA-GF<

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.21 g/cm³	1.21 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	4.50 cm³/10min	4.50 cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.60 %	0.60 %	
Flow	0.20 %	0.20 %	
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	754000 psi	5200 MPa	ISO 527-2/1A/1
Tensile Stress (Break)	12500 psi	86.0 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.1 %	3.1 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	3.3 ft·lb/in²	7.0 kJ/m²	
73°F (23°C)	4.3 ft·lb/in²	9.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	26 ft·lb/in²	55 kJ/m²	
73°F (23°C)	27 ft·lb/in²	56 kJ/m²	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Ball Indentation Hardness (H 358/30)	14100 psi	97.0 MPa	ISO 2039-1
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	396 °F	202 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	307 °F	153 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	415 °F	213 °C	ISO 306/A50
--	315 °F	157 °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
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	

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Additional Information

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

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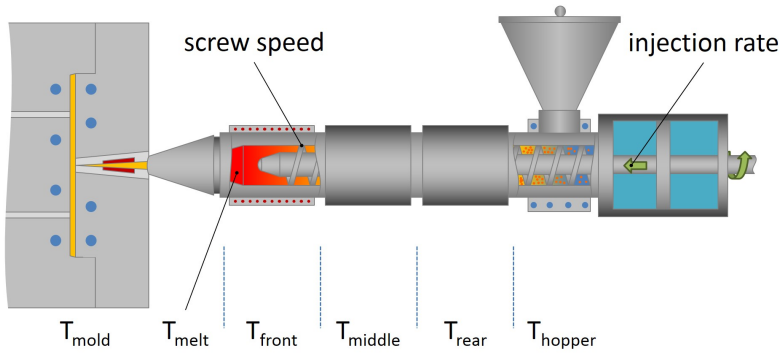

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Notes

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