

## Technical Data Sheet

# SCHULABLEND<sup>®</sup> (ABS/PA) M/MK 7102 GF20

Acrylonitrile Butadiene Styrene + PA  
Engineering Plastics

### Product Description

20% glass fibre reinforced ABS/PA blend. (Former name: SCHULABLEND<sup>®</sup> M/MK GF20 K1752)

### 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	1.20 g/cm <sup>3</sup>	1.20 g/cm <sup>3</sup>	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	3.00 cm <sup>3</sup> /10min	3.00 cm <sup>3</sup> /10min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	725000 psi	5000 MPa	ISO 527-2/1A/1
Tensile Stress (Break)	11200 psi	77.0 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0 %	3.0 %	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)	2.4 ft·lb/in <sup>2</sup>	5.0 kJ/m <sup>2</sup>	
73°F (23°C)	4.3 ft·lb/in <sup>2</sup>	9.0 kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	16 ft·lb/in <sup>2</sup>	34 kJ/m <sup>2</sup>	
73°F (23°C)	17 ft·lb/in <sup>2</sup>	36 kJ/m <sup>2</sup>	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	354 °F	179 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	266 °F	130 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	415 °F	213 °C	ISO 306/A50
--	302 °F	150 °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 (1.5 mm)	HB	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	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.