Technical Data Sheet

Schulablend M/MK 6501 LE SF U BEI94455

Acrylonitrile Butadiene Styrene + PA

Product Description

High flow ABS/PA6 blend, high impact strength, UV stabilised with optimized Low emission performance for automotive interior applications. (Former name: SCHULABLEND M/MK K2004 SF LE)

Processing Method	Injection Molding
Resin ID	PA+ABS

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/5.0 kg)	10	cm³/10 min	ISO 1133
Density, (Method A)	1.08	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield			
(Type 1A, 50 mm/min)	40.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	30.0	MPa	ISO 527-2
Tensile Strain at Break			
(Type 1A, 50 mm/min)	120	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	200	%	ISO 527-2
Flexural Modulus, (2.0 mm/min)	1700	MPa	ISO 178
Tensile Strain at Yield			
(Type 1A, 50 mm/min)	3.4	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	21	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 50 mm/min)	40.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	38.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	1800	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	900	MPa	ISO 527-1
Flexural Stress			
(2.0 mm/min, 3.5%)	50.0	MPa	ISO 178
(2.0 mm/min, 6.0%)	50.0	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	90	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	30	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	88	kJ/m²	ISO 179

Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	130	°C	ISO 306
(A (10N), 50 °C/h)	200	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	90.0	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	60.0	°C	ISO 75-2/A
Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
- Conditioned	>1.0E+10	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093
- Conditioned	>1.0E+12	ohm	IEC 60093
Flammable			
Burning Rate			
(2.00 mm)	60	mm/min	ISO 3795
(2.00 mm)	60	mm/min	FMVSS 302
UL Information			
Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	4	hr
Drying Temperature	80	°C
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	40 to 80	°C