Technical Data Sheet

# *Schulablend* M/MK 6503 U BLK72765

Acrylonitrile Butadiene Styrene + PA

**Product Description**

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

| | |
|---|---|
| **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) | 15 | 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 |
| Tensile Strain at Break, (Type 1A, 5 mm/min) | 120 | % | ISO 527-2 |
| Flexural Modulus, (2.0 mm/min) | 1300 | MPa | ISO 178 |
| Tensile Strain at Yield, (Type 1A, 50 mm/min) | 4.0 | % | ISO 527-2 |
| Tensile Modulus, (1 mm/min, Type 1A) | 1700 | MPa | ISO 527-1 |
| Flexural Stress | | | |
| (2.0 mm/min, 3.5%) | 37.0 | MPa | ISO 178 |
| (2.0 mm/min, 7.0%) | 46.0 | MPa | ISO 178 |
| **Impact** | | | |
| Charpy Impact Strength - Notched | | | |
| (23 °C, Type 1, Edgewise, Notch A) | 80 | kJ/m² | ISO 179 |
| (-30 °C, Type 1, Edgewise, Notch A) | 18 | 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 |
| **Hardness** | | | |
| Ball Indentation Hardness, (H 358/30) | 91.0 | MPa | ISO 2039-1 |
| **Thermal** | | | |
| Vicat Softening Temperature | | | |
| (B (50N), 50 °C/h) | 140 | °C | ISO 306 |
| (A (10N), 50 °C/h) | 200 | °C | ISO 306 |
| Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise) | 95.0 | °C | ISO 75-2/B |
| Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise) | 68.0 | °C | ISO 75-2/A |
| **Electrical** | | | |

| | | | |
|---|---|---|---|
| Volume Resistivity | >1.0E+13 | ohm*m | IEC 62631-3-1 |
| Surface Resistivity | >1.0E+15 | ohm | IEC 60093 |
| **Flammable** | | | |
| Burning Rate | | | |
| (2.00 mm) | <100 | mm/min | ISO 3795 |
| (2.00 mm) | <100 | 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 |