

Technical Data Sheet

Schulblend(ABS/PA)M/MK7101 GF20 NAT

Acrylonitrile Butadiene Styrene + PA

Product Description

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

Processing Method Injection Molding**Filler/Reinforcement** Glass Fiber, 20%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (250 °C/5.0 kg)	4.5	cm ³ /10 min	ISO 1133
Density, (Method A)	1.21	g/cm ³	ISO 1183
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	3.1	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	86.0	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	5200	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	9.0	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	56	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	55	kJ/m ²	ISO 179
Hardness			
Ball Indentation Hardness, (H 358/30)	97.0	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	157	°C	ISO 306
(A (10N), 50 °C/h)	213	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	202	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	153	°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	FMVSS 302
(2.00 mm)	<100	mm/min	ISO 3795

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
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	40 to 80	°C