Technical Data Sheet

Schulablend (ASA/PA) M/MW 6202 U

Acrylonitrile Styrene Acrylate + PA
LyondellBasell Industries
Engineering Plastics

Product Description			
ASA/PA6 blend with high UV stability and good heat resistance. (Former name: SCHULABLEND® M/MW UV)			
General			
Features	• Good Impact Resistance	• High Heat Resistance	• UV Resistant
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.12 g/cm³	1.12 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°c/5.0 Kg)	17 cm³/10min	17 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	290000 psi	2000 MPa	ISO 527-1/1A/1
Tensile Stress (Yield)	7980 psi	55.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0 %	4.0 %	ISO 527-2/1A/50
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength (73°f (23°c))	10 ft·lb/in²	21 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
73°f (23°c)	No Break	No Break	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/Bf
66 Psi (0.45 Mpa), Unannealed	219 °F	104 °C	
Vicat Softening Temperature	300 °F	149 °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)	1.2 in/min	30 mm/min	ISO 3795
0.0787 In (2.00 Mm)	1.2 in/min	30 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 In (1.6 Mm)	HB	HB	

Additional Information

The tradename "Schulablend" may be abbreviated "SBL" in documents or on labels.
1.) Not for use in food contact applications
2.) Not for use in medical or pharmaceutical applications

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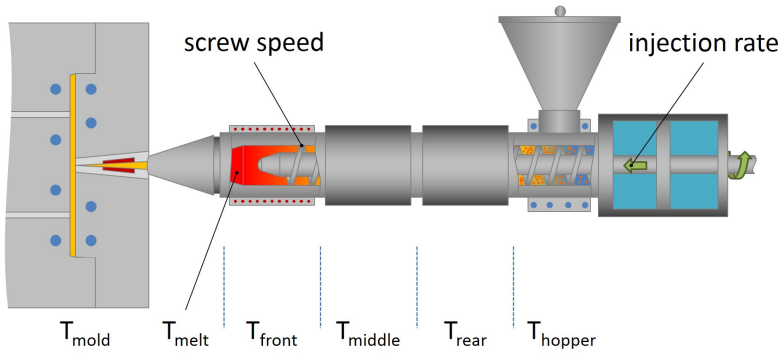

Injection	Nominal Value (English)	Nominal Value (SI)
Hopper Temperature	122 °F	50 °C
Rear Temperature	428 °F	220 °C
Middle Temperature	446 to 464 °F	230 to 240 °C
Front Temperature	482 °F	250 °C
Nozzle Temperature	500 °F	260 °C
Processing (Melt) Temp	446 to 500 °F	230 to 260 °C
Mold Temperature	86 to 176 °F	30 to 80 °C
Injection Pressure	14500 to 21800 psi	100 to 150 MPa
Injection Rate	Fast	Fast
Back Pressure	725 to 2180 psi	5.00 to 15.0 MPa
Cushion	0.0787 to 0.197 in	2.00 to 5.00 mm

Injection Notes

Material Preparation

- Predyring: As the Material is delivered in welded bags predrying is not necessary. Should moisture be introduced during storage, predrying at 70°C for about 4 hours is recommended.

Injection Molding Processing

- Injection Speed: High injection speeds produce good surface finish and weld line strengths. A slow start followed by a quick fill will avoid jetting.
- Injection Pressure: The good flow properties prevent build up of very high pressure. Typically 1000 - 1500 bar.
- Holding Pressure and Holding Time: Use the shortest time consistent with good ejection. Pressure should be approx. 30 - 60 % of Maximum injection pressure.
- Melt Cushion: Average (2 - 5 mm).
- Screw Speed: Slow as practicable. Maximum circumferential speed 0,6 m/s.
- Back Pressure: 50 - 150 bar. Too high pressure in the mould can result in combustion (diesel effect) leading to grey or black streaks.

Post Treatment

- Reprocessing: Using of regrind is possible, provide considerate first moulding. Depending of requirements, usual content of regrind is 10 to 20 %.
- Conditioning: unnecessary
- Shut Down: The material can normally be left in the cylinder. If in doubt purge with polyolefin.
- Finishing: The material is suitable for machining. Varnishing, printing, gluing and embossing can be carried out using commercially available products.

Notes

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