Technical Data Sheet

# *Schulablend* M/MW 6501 BLK 72875

Acrylonitrile Styrene Acrylate + PA

## Product Description

ASA/PA injection molding grade with excellent light stability, impact properties and with high heat resistance. Available with/without UV stabilization.

**Processing Method** Injection Molding

| Typical Properties | Nominal Value | Units | Test Method |
|---|---|---|---|
| **Physical** | | | |
| Melt Volume Flow Rate, (260 °C/5.0 kg) | 3.8 | cm³/10 min | ISO 1133 |
| Density, (Method A) | 1.09 | g/cm³ | ISO 1183 |
| **Mechanical** | | | |
| Tensile Stress at Yield | | | |
| (Type 1A, 50 mm/min) | 44.0 | MPa | ISO 527-2 |
| (Type 1A, 50 mm/min) - Conditioned | 34.0 | MPa | ISO 527-2 |
| Nominal Tensile Strain at Break | | | |
| (50 mm/min, Type 1A) - Conditioned | >200 | % | ISO 527-2 |
| (50 mm/min, Type 1A) | >100 | % | ISO 527-2 |
| Tensile Modulus | | | |
| (1 mm/min, Type 1A) | 1800 | MPa | ISO 527-1 |
| (1 mm/min, Type 1A) - Conditioned | 800 | MPa | ISO 527-1 |
| **Impact** | | | |
| Charpy Impact Strength - Notched | | | |
| (23 °C, Type 1, Edgewise, Notch A) | 100 | kJ/m² | ISO 179 |
| (-20 °C, Type 1, Edgewise, Notch A) | 15 | kJ/m² | ISO 179 |
| (-30 °C, Type 1, Edgewise, Notch A) | 10 | kJ/m² | ISO 179 |
| (23 °C, Type 1, Edgewise, Notch A) - Conditioned | 130 | kJ/m² | ISO 179 |
| Charpy Impact Strength - Unnotched | | | |
| (23 °C, Type 1, Edgewise) | No Break | | ISO 179 |
| (-20 °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 |
| **Hardness** | | | |
| Ball Indentation Hardness, (H 358/30) | 95.0 | MPa | ISO 2039-1 |
| **Thermal** | | | |
| Vicat Softening Temperature | | | |
| (B (50N), 50 °C/h) | 125 | °C | ISO 306 |
| (A (10N), 50 °C/h) | 208 | °C | ISO 306 |

| | | | |
|---|---|---|---|
| Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise) | 96.0 | °C | ISO 75-2/A |

| 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 |