Technical Data Sheet

SCHULABLEND® (PC/ABS) M/MB 6302

Polycarbonate + ABS
Engineering Plastics

Product Description
High heat resistant PC/ABS blend, available with and without UV stabilization.

General		
Features	• Good Flow	• High Heat Resistance
UL File Number	• E86615	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• ABS+PC	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.16 g/cm³	1.16 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	20 cm³/10min	20 cm³/10min	ISO 1133
Molding Shrinkage - Across Flow	0.40 to 0.60 %	0.40 to 0.60 %	ISO 294-4
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	319000 psi	2200 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	7980 psi	55.0 MPa	ISO 527-2/1A/50
Tensile Strain			
Yield	5.0 %	5.0 %	ISO 527-2/1A/50
Break	80 %	80 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			
-22°F (-30°C)	20 ft·lb/in²	43 kJ/m²	ISO 179
73°F (23°C)	24 ft·lb/in²	50 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Ball Indentation Hardness (H 358/30)	13100 psi	90.0 MPa	ISO 2039-1
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	266 °F	130 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	230 °F	110 °C	ISO 75-2/A
Vicat Softening Temperature			
--	284 °F	140 °C	ISO 306/A50
--	266 °F	130 °C	ISO 306/B50
Ball Pressure Test (266°F (130°C))	Pass	Pass	IEC 60695-10-2
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

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	1.6 in/min	40 mm/min	ISO 3795
0.0787 in (2.00 mm)	1.6 in/min	40 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.08 in (2.0 mm)	1200 °F	650 °C	

Additional Information

1.) Not for use in food contact applications
2.) Not for use in medical or pharmaceutical applications

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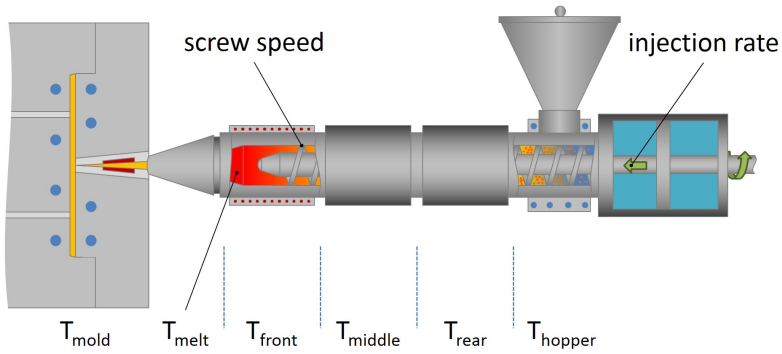

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	212 °F	100 °C
Drying Time	4.0 hr	4.0 hr
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	158 to 212 °F	70 to 100 °C

Notes

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