Technical Data Sheet

Schulablend M/MB 6305 SFBWM94635

Polycarbonate + ABS

Product Description

High flow and high heat resistant PC/ABS blend.Available with or without UV stabilization. (Former name: SCHULABLEND M/MB 6 SF)

Processing Method	Injection Molding
Attribute	Good Flow; High Heat Resistance
Resin ID	ABS+PC

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/5.0 kg)	27	cm³/10 min	ISO 1133
Density, (Method A)	1.16	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	55.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	6.0	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2200	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched, (23 °C, Type 1, Edgewise, Notch A)	55	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)	102	MPa	ISO 2039-1
Ball Pressure Test, (130 °C)	Pass		IEC 60695-10-2
Thermal			
Vicat Softening Temperature, (B (50N), 50 °C/h)	135	°C	ISO 306
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)	60	mm/min	FMVSS 302
(2.00 mm)	60	mm/min	ISO 3795
Glow Wire Flammability Index, (2.0 mm)	650	°C	IEC 60695-2-12
UL Information			

Flammability Classification		
(1.5 mm)	HB	IEC 60695-11-10, -20
(3.0 mm)	HB	IEC 60695-11-10, -20
UL File Number	E86615	

Injection Parameters	Nominal Value	Units
Drying Time	4	hr
Drying Temperature	100 to 110	°C
Processing (Melt) Temp	260 to 280	°C
Mold Temperature	70 to 100	°C