

Technical Data Sheet

Schulblend M/MA 6401 U BLK72765



Polycarbonate + ASA

Product Description

PC-ASA blend with increased impact strength, heat resistance and weather resistance. Also available without UV stabilization.

| | |
|--------------------------|---|
| Processing Method | Injection Molding |
| Attribute | Good Impact Resistance; Good Weather Resistance; High Heat Resistance |
| Resin ID | PC+ASA UV |

| Typical Properties | Nominal Value | Units | Test Method |
|---|---------------|-------------------------|-------------|
| Physical | | | |
| Melt Volume Flow Rate, (260 °C/5.0 kg) | 28 | cm ³ /10 min | ISO 1133 |
| Density, (Method A) | 1.20 | g/cm ³ | ISO 1183 |
| Mechanical | | | |
| Tensile Stress at Yield, (Type 1A, 50 mm/min) | 58.0 | MPa | ISO 527-2 |
| Nominal Tensile Strain at Break, (50 mm/min, Type 1A) | 60 | % | ISO 527-2 |
| Flexural Modulus, (2.0 mm/min) | 2400 | MPa | ISO 178 |
| Tensile Strain at Yield, (Type 1A, 50 mm/min) | 5.5 | % | ISO 527-2 |
| Tensile Stress at Break, (Type 1A, 50 mm/min) | 48.0 | MPa | ISO 527-2 |
| Tensile Modulus, (1 mm/min, Type 1A) | 2300 | MPa | ISO 527-1 |
| Flexural Stress, (2.0 mm/min, 6.2%) | 90.0 | MPa | ISO 178 |
| Impact | | | |
| Charpy Impact Strength - Notched | | | |
| (23 °C, Type 1, Edgewise, Notch A) | 62 | kJ/m ² | ISO 179 |
| (-30 °C, Type 1, Edgewise, Notch A) | 15 | kJ/m ² | ISO 179 |
| Charpy Impact Strength - Unnotched | | | |
| (23 °C, Type 1, Edgewise) | No Break | | ISO 179 |
| (-30 °C, Type 1, Edgewise) | No Break | | ISO 179 |
| Thermal | | | |
| Vicat Softening Temperature | | | |
| (B (50N), 50 °C/h) | 135 | °C | ISO 306 |
| (A (10N), 50 °C/h) | 140 | °C | ISO 306 |
| Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise) | 125 | °C | ISO 75-2/B |
| Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise) | 110 | °C | ISO 75-2/A |

| Injection Parameters | Nominal Value | Units |
|-----------------------------|----------------------|--------------|
| Drying Time | 4.0 to 6.0 | hr |
| Drying Temperature | 100 | °C |
| Suggested Max Moisture | 0.02 | % |
| Screw Speed | 0.4 | mm/sec |
| Processing (Melt) Temp | 260 to 290 | °C |
| Front Temperature | 290 | °C |
| Holding Pressure | 30.0 to 75.0 | MPa |
| Hopper Temperature | 70 | °C |
| Middle Temperature | 270 | °C |
| Rear Temperature | 250 | °C |
| Injection Rate | Fast | |
| Back Pressure | 5.00 to 15.0 | MPa |
| Mold Temperature | 60 to 90 | °C |
| Injection Pressure | 80.0 to 150 | MPa |
| Cushion | 2.00 to 5.00 | mm |