

## Technical Data Sheet

**Schulblend M/MA 6401 U GRY61085**

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
<b>Physical</b>			
Melt Volume Flow Rate, (260 °C/5.0 kg)	28	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.20	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
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
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	62	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	15	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
<b>Thermal</b>			
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

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
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