

## Technical Data Sheet

**Schulblend M/MA 6401 U NAT**

Polycarbonate + ASA

**Product Description**

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

|                          |   |
|--------------------------|---|
| <b>Processing Method</b> | Injection Molding   |
| <b>Attribute</b>         | Good Impact Resistance; Good Weather Resistance; High Heat Resistance |
| <b>Resin ID</b>          | 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           |