

SCHULABLEND® (ABS/PA) M/MK 6501

Acrylonitrile Butadiene Styrene + PA

A. Schulman Europe

Message:

ABS/PA6 blend, standard injection molding grade

General Information				
Features		Impact resistance, high		
		Good chemical resistance		
UL File Number		E86615		
Processing Method		Injection molding		
Resin ID (ISO 1043)		ABS-PA		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.08	--	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	11.0	--	cm ³ /10min	ISO 1133
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	85.0	--	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1700	900	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	39.0	27.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.4	21	%	ISO 527-2/1A/50
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	22	--	kJ/m ²	ISO 179/1eA
23°C	80	91	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	--		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	87.0	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	66.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature				
--	204	--	°C	ISO 306/A50
--	120	--	°C	ISO 306/B50

Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
1.5 mm	HB	--		IEC 60695-11-10, -20
3.0 mm	HB	--		IEC 60695-11-10, -20
Glow Wire Flammability Index				IEC 60695-2-12
1.5 mm	650	--	°C	IEC 60695-2-12
3.0 mm	650	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	4.0		hr	
Suggested Max Moisture	0.040 - 0.10		%	
Processing (Melt) Temp	230 - 270		°C	
Mold Temperature	40 - 80		°C	

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