

SCHULABLEND[®] (ABS/PA) M/MK 6301 E

Acrylonitrile Butadiene Styrene + PA
Engineering Plastics

Product Description

PA/ABS high impact strength and chemical resistance, UV-stabilized for Extrusion applications. (Former name: M/MK E)

General

Features	• Chemical Resistant	• High Impact Resistance	• UV Resistant
UL File Number	• E86615		
Processing Method	• Extrusion		
Resin ID (ISO 1043)	• ABS-PA		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.05	--	g/cm ³	ISO 1183/A

Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	0.400	--	cm ³ /10min	ISO 1133
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Molding Shrinkage	0.80 to 1.2	--	%	ISO 294-4
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Mechanical	Dry	Conditioned	Unit	Test Method
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Tensile Modulus	236000 (1630)	167000 (1150)	psi (MPa)	ISO 527-2/1A/1
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Tensile Stress (Yield)	5510 (38.0)	4350 (30.0)	psi (MPa)	ISO 527-2/1A/50
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Tensile Strain				
Yield	4.0	12	%	ISO 527-2/1A/50

Break	85	90	%	ISO 527-2/1A/5
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Impact	Dry	Conditioned	Unit	Test Method
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Charpy Notched Impact Strength				ISO 179/1eA
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-22°F (-30°C)	7.6 (16)	--	ft·lb/in ² (kJ/m ²)	
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73°F (23°C)	21 (45)	29 (60)	ft·lb/in ² (kJ/m ²)	
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Charpy Unnotched Impact Strength				ISO 179/1eU
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-22°F (-30°C)	No Break	--		
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73°F (23°C)	No Break	No Break		
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Hardness	Dry	Conditioned	Unit	Test Method
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Ball Indentation Hardness (H 358/30)	12300 (85.0)	--	psi (MPa)	ISO 2039-1
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Thermal	Dry	Conditioned	Unit	Test Method
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Heat Deflection Temperature				
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66 psi (0.45 MPa), Unannealed	189 (87.0)	--	°F (°C)	ISO 75-2/Bf
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264 psi (1.8 MPa), Unannealed	162 (72.0)	--	°F (°C)	ISO 75-2/Af
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Vicat Softening Temperature				
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--	266 (130)	--	°F (°C)	ISO 306/A50
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--	207 (97.0)	--	°F (°C)	ISO 306/B50
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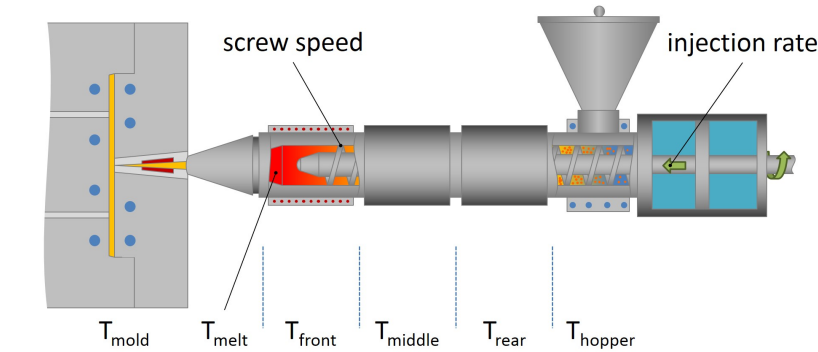
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Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	> 1.0E+12	ohms	IEC 62631-3-2
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·cm	IEC 62631-3-1
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 in (2.00 mm)	1.6 (40)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	1.6 (40)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in (1.5 mm)	1200 (650)	--	°F (°C)	
0.12 in (3.0 mm)	1200 (650)	--	°F (°C)	



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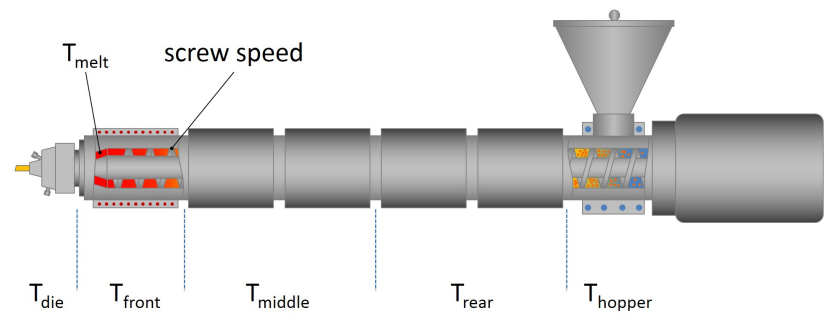


Injection	Dry (English)	Dry (SI)
Mold Temperature	104 to 176 °F	40 to 80 °C



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Extrusion	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 hr	4.0 hr
Melt Temperature	446 to 518 °F	230 to 270 °C

Notes

These are typical property values not to be construed as specification limits.

