

# SCHULABLEND® (ABS/PA) M/MK 6501

Acrylonitrile Butadiene Styrene + PA  
Engineering Plastics

## Product Description

ABS/PA6 blend, standard injection molding grade. (Former name: SCHULABLEND® M/MK)

## General

|                           |                                                                                                      |
|---------------------------|------------------------------------------------------------------------------------------------------|
| Features                  | <ul style="list-style-type: none"> <li>Chemical Resistant</li> <li>High Impact Resistance</li> </ul> |
| Automotive Specifications | <ul style="list-style-type: none"> <li>FORD WSS-M4D960-A Color: Black</li> </ul>                     |
| UL File Number            | <ul style="list-style-type: none"> <li>E86615</li> </ul>                                             |
| Processing Method         | <ul style="list-style-type: none"> <li>Injection Molding</li> </ul>                                  |
| Resin ID (ISO 1043)       | <ul style="list-style-type: none"> <li>ABS-PA</li> </ul>                                             |

| Physical                                   | Dry              | Conditioned     | Unit                 | Test Method     |
|--------------------------------------------|------------------|-----------------|----------------------|-----------------|
| Density                                    | 1.08             | --              | g/cm³                | ISO 1183/A      |
| Melt Volume-Flow Rate (MVR) (250°C/5.0 kg) | 11               | --              | cm³/10min            | ISO 1133        |
| Mechanical                                 | Dry              | Conditioned     | Unit                 | Test Method     |
| Tensile Modulus                            | 247000<br>(1700) | 131000<br>(900) | psi<br>(MPa)         | ISO 527-2/1A/1  |
| Tensile Stress (Yield)                     | 5660<br>(39.0)   | 3920<br>(27.0)  | psi<br>(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     |
| -22°F (-30°C)                              | 10<br>(22)       | --              | ft·lb/in²<br>(kJ/m²) |                 |
| 73°F (23°C)                                | 38<br>(80)       | 43<br>(91)      | ft·lb/in²<br>(kJ/m²) |                 |
| Charpy Unnotched Impact Strength           |                  |                 |                      | ISO 179/1eU     |
| -22°F (-30°C)                              | No Break         | --              |                      |                 |
| 73°F (23°C)                                | No Break         | No Break        |                      |                 |
| Hardness                                   | Dry              | Conditioned     | Unit                 | Test Method     |
| Ball Indentation Hardness (H 358/30)       | 12300<br>(85.0)  | --              | psi<br>(MPa)         | ISO 2039-1      |
| Thermal                                    | Dry              | Conditioned     | Unit                 | Test Method     |
| Heat Deflection Temperature                |                  |                 |                      |                 |
| 66 psi (0.45 MPa), Unannealed              | 189<br>(87.0)    | --              | °F<br>(°C)           | ISO 75-2/Bf     |
| 264 psi (1.8 MPa), Unannealed              | 151<br>(66.0)    | --              | °F<br>(°C)           | ISO 75-2/Af     |
| Vicat Softening Temperature                |                  |                 |                      |                 |
| --                                         | 399<br>(204)     | --              | °F<br>(°C)           | ISO 306/A50     |
| --                                         | 248<br>(120)     | --              | °F<br>(°C)           | ISO 306/B50     |



SCHULABLEND® (ABS/PA) M/MK 6501

Acrylonitrile Butadiene Styrene + PA  
Engineering Plastics

| Flammability                 | Dry           | Conditioned | Unit               | Test Method             |
|------------------------------|---------------|-------------|--------------------|-------------------------|
| Burning Rate                 |               |             |                    |                         |
| 0.0787 in (2.00 mm)          | 1.6<br>(40)   | --          | in/min<br>(mm/min) | ISO 3795                |
| 0.0787 in (2.00 mm)          | 1.6<br>(40)   | --          | in/min<br>(mm/min) | FMVSS 302               |
| Flammability Classification  |               |             |                    | IEC 60695-11-10,<br>-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<br>(650) | --          | °F<br>(°C)         |                         |
| 0.12 in (3.0 mm)             | 1200<br>(650) | --          | °F<br>(°C)         |                         |



SCHULABLEND® (ABS/PA) M/MK 6501

Acrylonitrile Butadiene Styrene + PA  
Engineering Plastics



| Injection              | Dry (English)  | Dry (SI)       |
|------------------------|----------------|----------------|
| Drying Temperature     | 176 °F         | 80 °C          |
| Drying Time            | 4.0 hr         | 4.0 hr         |
| Suggested Max Moisture | 0.04 to 0.10 % | 0.04 to 0.10 % |
| Suggested Max Regrind  | 20 %           | 20 %           |
| Processing (Melt) Temp | 446 to 518 °F  | 230 to 270 °C  |
| Mold Temperature       | 104 to 176 °F  | 40 to 80 °C    |

Notes

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

