

SCHULABLEND® M/MB 6301

Polycarbonate + ABS

A. Schulman Europe

Message:

ABS/PC-blend with higher impact and heat resistance

General Information			
Processing Method	Injection molding		
Resin ID (ISO 1043)	ABS+PC		
Physical	Nominal Value	Unit	Test Method
Density	1.15	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	16.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2260	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	55.0	MPa	ISO 527-2/1A/50
Fracture	40.0	MPa	ISO 527-2/1A/50
Tensile Strain			ISO 527-2/1A/50
Yield	5.2	%	ISO 527-2/1A/50
Fracture	40	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	17	kJ/m ²	ISO 179/1eA
-20°C	17	kJ/m ²	ISO 179/1eA
23°C	45	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
-20°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	127	°C	ISO 75-2/Bf
1.8 MPa, not annealed	105	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	140	°C	ISO 306/A50
--	129	°C	ISO 306/B50
Additional Information			

1.)

Not for use in food contact applications2.)

Not for use in medical or pharmaceutical applications

Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	4.0 - 6.0	hr
Suggested Max Regrind	20	%
Hopper Temperature	70	°C
Rear Temperature	230	°C
Middle Temperature	255	°C
Front Temperature	280	°C
Processing (Melt) Temp	260 - 270	°C
Mold Temperature	70 - 90	°C
Injection Pressure	100 - 150	MPa
Injection Rate	Fast	
Holding Pressure	30.0 - 75.0	MPa
Back Pressure	4.00 - 7.00	MPa
Cushion	2.00 - 5.00	mm
Screw Speed		mm/sec

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