

SCHULABLEND® SCHULABLEND® M/MA

6301 U

Acrylonitrile Styrene Acrylate + PC
A. Schulman Europe

Message:
PC / ASA, UV stabilized, with good flow.

General Information			
Processing Method	Injection molding		
Resin ID (ISO 1043)	PC+ASA		
Physical	Nominal Value	Unit	Test Method
Density	1.15	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	30.0	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2000	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	51.0	MPa	ISO 527-2/1A/50
Fracture	45.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.8	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	100	%	ISO 527-2/1A/50
Flexural Modulus ¹	2500	MPa	ISO 178
Flexural Stress ²			ISO 178
3.5% strain	77.0	MPa	ISO 178
5.7% strain	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	50	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	120	°C	ISO 75-2/B
1.8 MPa, not annealed	95.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	138	°C	ISO 306/A50
--	126	°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 - 110	°C
Drying Time	4.0	hr
Suggested Max Moisture	< 0.020	%
Suggested Max Regrind	20	%
Processing (Melt) Temp	260 - 280	°C
Mold Temperature	70 - 100	°C

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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