Technical Data Sheet

Schulablend M/MK 7102 GF20 BLK70400

Acrylonitrile Butadiene Styrene + PA

Product Description

20% glass fibre reinforced ABS/PA blend. (Former name: SCHULABLEND M/MK GF20 K1752)

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 20%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (250 °C/5.0 kg)	3.0	cm³/10 min	ISO 1133
Density, (Method A)	1.20	g/cm³	ISO 1183
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	3.0	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	77.0	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	5000	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	9.0	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	5.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	40	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	34	kJ/m²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	150	°C	ISO 306
(A (10N), 50 °C/h)	213	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	179	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	130	°C	ISO 75-2/A
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302
UL Information			
Flammability Classification, (1.5 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	4	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	40 to 80	°C