

Technical Data Sheet

Schulablend M/MA 6401 U NAT



Polycarbonate + ASA

Product Description

PC-ASA blend with increased impact strength, heat resistance and weather resistance. Also available without UV stabilization.

Regulatory Status

For regulatory compliance information, see *Schulablend M/MA 6401 U NAT* [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Commercial: Active
Availability	Africa-Middle East; Asia-Pacific; Europe; Latin America; North America
Processing Method	Injection Molding
Attribute	Good Impact Resistance; Good Weather Resistance; High Heat Resistance
Resin ID	PC+ASA UV

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/5.0 kg)	28	cm ³ /10 min	ISO 1133
Density, (Method A)	1.20	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	58.0	MPa	ISO 527-2
Nominal Tensile Strain at Break, (50 mm/min, Type 1A)	60	%	ISO 527-2
Flexural Modulus, (2.0 mm/min)	2400	MPa	ISO 178
Tensile Strain at Yield, (Type 1A, 50 mm/min)	5.5	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 50 mm/min)	48.0	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2300	MPa	ISO 527-1
Flexural Stress, (2.0 mm/min, 6.2%)	90.0	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	62	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	15	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	135	°C	ISO 306
(A (10N), 50 °C/h)	140	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	125	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	110	°C	ISO 75-2/A



Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	100	°C
Suggested Max Moisture	0.02	%
Screw Speed	0.4	mm/sec
Processing (Melt) Temp	260 to 290	°C
Front Temperature	290	°C
Holding Pressure	30.0 to 75.0	MPa
Hopper Temperature	70	°C
Middle Temperature	270	°C
Rear Temperature	250	°C
Injection Rate	Fast	
Back Pressure	5.00 to 15.0	MPa
Mold Temperature	60 to 90	°C
Injection Pressure	80.0 to 150	MPa
Cushion	2.00 to 5.00	mm

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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