



Bayblend® M750

(PC+ABS)

Covestro Deutschland AG

- (PC ABS)-Blend
- Vicat/B 120 temperature = 126 °C
- meet certain requirements of ISO Standard 10993-1
- for further information please contact plastics@covestro.com

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	11	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.9	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	47	MPa	ISO 527
Yield strain	4.8	%	ISO 527
Nominal strain at break	>50	%	ISO 527

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	104	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	127	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	85	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	85	E-6/K	ISO 11359-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3	-	IEC 62631-2-1
Relative permittivity, 1MHz	2.9	-	IEC 62631-2-1
Dissipation Factor, 100Hz	25	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	105	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	35	kV/mm	IEC 60243-1
Comparative tracking index	325	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.6	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1120	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	70 - 100	°C	-

Characteristics

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Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Sterilizable, Ethylene Oxide (EtO) Sterilization, Gamma irradiation sterilization

Certifications

Medical, Biocompatibility ISO 10993, US Pharmacopeia Class VI
Approved

Applications

Medical

Injection Molding

PREPROCESSING

Max. Water content: 0.02 %

Drying temperature: 100 - 110 °C

(depending on the grade 10 °C below the Vicat VST/B120 temperature, but not higher as the recommended values).

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-4 h

PROCESSING

Melt temperature: 240-280 °C

Mold temperature: 70-100 °C

Use open nozzle.
