



Bayblend® FR3210 TV

(PC+ABS) FR(40)

Covestro Deutschland AG

- (PC ABS)-Blend
- flame retardant
- easy flowing
- Vicat/B 120 temperature = 93 °C
- improved surface quality
- UL recognition 94 V-0 at 1.2 mm

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	38	cm ³ /10min	ISO 1133
Temperature	240	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2700	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	3.5	%	ISO 527

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	76	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	85	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	91	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	75	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	75	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0	class	UL 94
Burning Behav. at thickness h	V-0	class	UL 94
Thickness tested	1.2	mm	-

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.5	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1180	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	240	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	240	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	75 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	70 - 100	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Special Characteristics

Flame retardant

Injection Molding

PREPROCESSING

Max. Water content: 0.02 %

Drying temperature: 75 - 100 °C

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(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.
