



Bayblend® T80 XG

(PC+ABS)

Covestro Deutschland AG

- (PC ABS)-Blend
- Vicat/B 120 temperature = 130 °C
- excellent flow
- optimized surface quality for metallization (steam treatment)

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	27	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2500	MPa	ISO 527
Yield stress	62	MPa	ISO 527
Yield strain	4.7	%	ISO 527

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	108	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	127	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	128	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	72	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	72	E-6/K	ISO 11359-1/-2
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	45	kV/mm	IEC 60243-1
Comparative tracking index	175	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.7	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1140	kg/m³	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
Injection Molding, injection velocity	240	mm/s	ISO 294

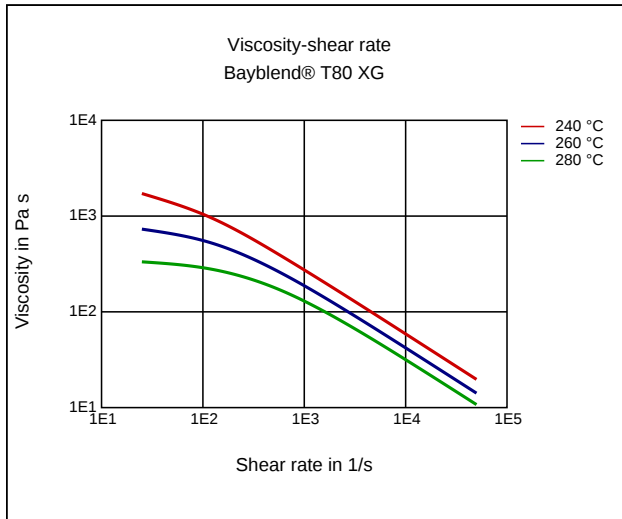
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	70 - 100	°C	-

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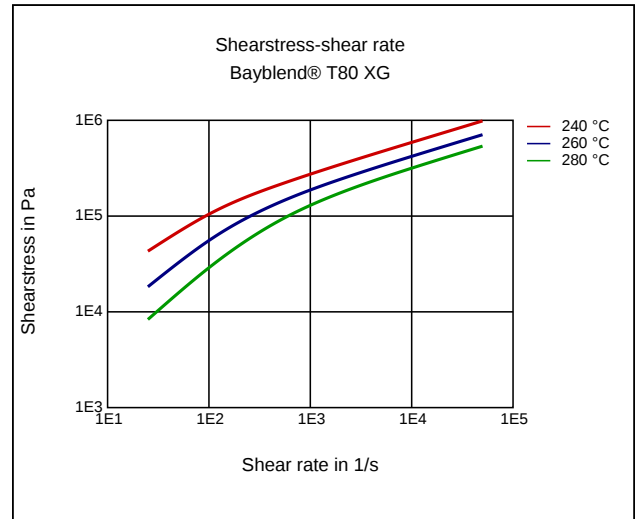
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Diagrams

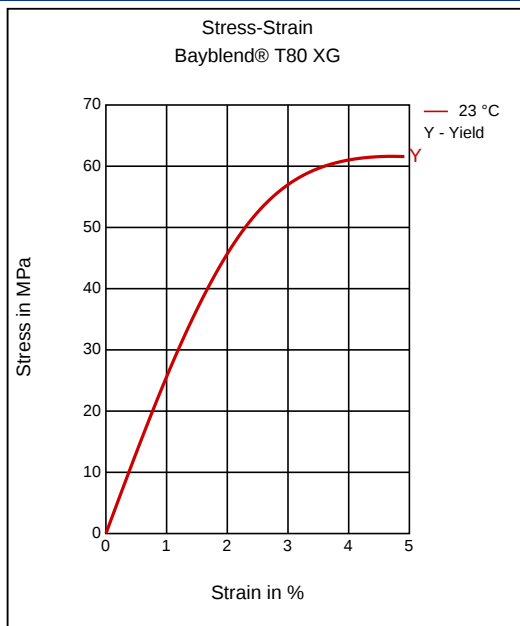
Viscosity-shear rate



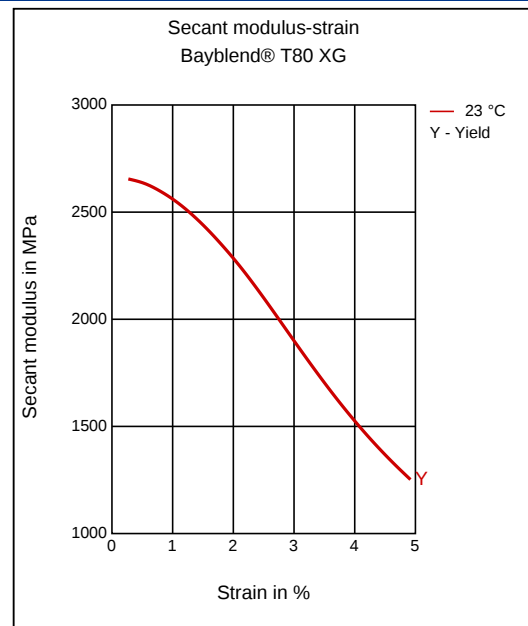
Shearstress-shear rate



Stress-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Release agent

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).

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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.
