



Bayblend® T85 XF RE25 CQ
(PC+ABS)

Covestro Deutschland AG

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Yield strain	4.7	%	ISO 527
Stress at Break	50	MPa	ISO 527
Strain at Break	>50	%	ISO 527
Notched Impact Strength (Charpy), +23°C	50	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	37	kJ/m²	ISO 179/1eA
Notched Impact Strength (Izod), 23°C	48	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	35	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	no break	kJ/m²	ISO 180/1U

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	107	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	126	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	128	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	75	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	80	E-6/K	ISO 11359-1/-2
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-
Oxygen index	24	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	20	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	85	E-4	IEC 62631-2-1
Volume Resistivity	1E14	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E16	Ohm	IEC 62631-3-2
Electric Strength	35	kV/mm	IEC 60243-1
Comparative tracking index	225	-	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	95 - 110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-

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Melt temperature	260 - 280	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	230 - 240	°C	-
Zone 2	235 - 245	°C	-
Zone 3	240 - 270	°C	-
Nozzle temperature	265 - 275	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Certifications

Contains renewable resources, ISCC Plus