

**Bayblend® FR1514**

Covestro - Polycarbonates - Polycarbonate + ABS

**General Information**
**Product Description**

(PC+ABS)-Blend; flame retardant; high heat resistance; Vicat/B 120 temperature = 136°C; ball indentation temperature &gt;= 125°C; UL recognition 94 V-0 at 1.5 mm; suitable as supporting material for energized parts

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Additive	• Flame Retardant		
Features	• Flame Retardant	• High Heat Resistance	
RoHS Compliance	• RoHS Compliant		
ISO Designation	• PC+ABS-FR(40)		

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.19	g/cm <sup>3</sup>	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	19	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage <sup>2</sup>			ISO 2577
Across Flow : 500°F, 0.118 in	0.50 to 0.70	%	
Flow : 500°F, 0.118 in	0.50 to 0.70	%	
Water Absorption (Saturation, 73°F)	0.50	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	348000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9140	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	8270	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	5.0	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	> 50	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/A
-22°F	7.1	ft·lb/in <sup>2</sup>	
73°F	21	ft·lb/in <sup>2</sup>	
Unnotched Izod Impact Strength (73°F)	No Break		ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	259	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	237	°F	ISO 75-2/A
Vicat Softening Temperature			
--	277	°F	ISO 306/B120
--	273	°F	ISO 306/B50
CLTE - Flow (73 to 131°F)	3.8E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.8E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	IEC 60093
Volume Resistivity (73°F)	1.0E+17	ohms·cm	IEC 60093
Electric Strength (73°F, 0.0394 in)	890	V/mil	IEC 60243-1
Relative Permittivity			IEC 60250
73°F, 100 Hz	3.20		
73°F, 1 MHz	3.10		



Dissipation Factor		IEC 60250
73°F, 100 Hz	2.0E-3	
73°F, 1 MHz	8.5E-3	
Comparative Tracking Index (Solution A)	350 V	IEC 60112
<b>Flammability</b>	<b>Nominal Value Unit</b>	<b>Test Method</b>
Flame Rating		UL 94
0.06 in	V-0	
0.08 in	5VB	
0.12 in	5VA	
Oxygen Index <sup>3</sup>	30 %	ISO 4589-2
<b>Fill Analysis</b>	<b>Nominal Value Unit</b>	<b>Test Method</b>
Melt Viscosity <sup>4</sup> (500°F)	450 Pa·s	ISO 11443-A

### Processing Information

<b>Injection</b>	<b>Nominal Value Unit</b>
Drying Temperature - Dry Air Dryer	176 °F
Drying Time - Dry Air Dryer	4.0 hr
Suggested Max Moisture	< 0.020 %
Suggested Shot Size	30 to 70 %
Rear Temperature	428 to 446 °F
Middle Temperature	437 to 455 °F
Front Temperature	446 to 464 °F
Nozzle Temperature	491 to 509 °F
Processing (Melt) Temp	464 to 536 °F
Mold Temperature	140 to 194 °F
Back Pressure	725 to 2180 psi
Vent Depth	9.8E-4 to 3.0E-3 in

### Injection Notes

Standard Melt Temperature: 260°C  
Peripheral Screw Speed: 0.05 - 0.2 m/s  
Hold Pressure (% of Injection Pressure): 50 - 75%

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 150x105x3mm,, MT 80°C

<sup>3</sup> Procedure A

<sup>4</sup> 1000s-1

