

Bayblend® 2953

Covestro - Polycarbonates - Polycarbonate + ABS

General Information
Product Description

(PC+ABS)-Blend; Vicat/B 120 temperature = 113°C; for electroplating applications

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Platable		
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• DELPHI DX300107	• FORD WSA-M4D785-A1	• GM GMW15581P-ABS+PC-T7
	• FORD WSA-M4D785-A1	Color: Natural	• STELLANTIS MS-DB-195
	• FORD WSA-M4D785-A1	• FORD WSB-M4D813-A	CPN3448 Color: Gray
	Color: Gray	• GM GMP.ABS+PC.012	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.11	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	14	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	305000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	6380	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	6820	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	3.6	%	ISO 527-2/50
Nominal Tensile Strain at Break (73°F)	> 50	%	ISO 527-2/50
Flexural Modulus ² (73°F)	319000	psi	ISO 178
Flexural Stress ² (3.5% Strain, 73°F)	9430	psi	ISO 178
Flexural Strain at Flexural Strength ³ (73°F)	5.6	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/A
-22°F	17	ft·lb/in ²	
73°F	22	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	230	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	194	°F	ISO 75-2/A
Vicat Softening Temperature			
--	235	°F	ISO 306/B120
--	226	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
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	446 to 464	°F
Middle Temperature	455 to 473	°F
Front Temperature	464 to 518	°F
Nozzle Temperature	509 to 527	°F
Processing (Melt) Temp	500 to 536	°F



Mold Temperature	158 to 194 °F
Back Pressure	725 to 2180 psi
Vent Depth	9.8E-4 to 3.0E-3 in

Injection Notes

Standard Melt Temperature: 270°C
Peripheral Screw Speed: 0.05 - 0.2 m/s
Hold Pressure (% of Injection Pressure): 50 - 75%

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.079 in/min

³ 2 mm/min

