

Bayblend® FR3042

 Covestro - Polycarbonates - *Polycarbonate + ABS*
General Information
Product Description

PC+ABS-FR(40)-Blend; flame retardant; for thin-wall applications; only black color (901510) available

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant
Uses	• Thin-walled Parts
RoHS Compliance	• RoHS Compliant
Appearance	• Black
ISO Designation	• PC+ABS-I FR(40)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (240°C/5.0 kg)	19	cm ³ /10min	ISO 1133
Molding Shrinkage ²			ISO 2577
Across Flow : 464°F, 0.118 in	0.50 to 0.70	%	
Flow : 464°F, 0.118 in	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	363000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9720	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	8410	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	4.0	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	> 50	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	14	ft·lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	221	°F	ISO 306/B120
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.030 in, BK)	V-0		UL 94
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (500°F, 1000 sec ⁻¹)	250	Pa·s	ISO 11443-A

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	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 518	°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

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

Notes

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

² 150x105x3 mm, 80°C MT

