

Bayblend® FR3060 EV

Covestro - Polycarbonates - Polycarbonate + ABS

General Information
Product Description

(PC+ABS)-Blend; 15% glass fibre reinforced; flame retardant; Vicat/B 120 temperature = 100 °C; UL recognition 94 V-0 at 1.5 mm and 5VA at 2 mm

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant
ISO Designation	• PC+ABS-GF15 FR(40)

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.28	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	23	cm ³ /10min	ISO 1133
Molding Shrinkage ²			ISO 2577
Across Flow : 464°F, 0.118 in	0.30 to 0.50	%	
Flow : 464°F, 0.118 in	0.20 to 0.40	%	
Water Absorption (Saturation, 73°F)	0.40	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	769000	psi	ISO 527-1/1
Tensile Stress (Break, 73°F)	13800	psi	ISO 527-2/5
Tensile Strain (Break, 73°F)	3.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact Strength (73°F)	14	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	198	°F	ISO 75-2/A
Vicat Softening Temperature	212	°F	ISO 306/B120
CLTE - Flow (73 to 131°F)	2.2E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.9E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Volume Resistivity (73°F)	1.0E+16	ohms·cm	IEC 60093
Electric Strength (73°F, 0.0394 in)	890	V/mil	IEC 60243-1
Comparative Tracking Index (Solution A)	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.08 in	5VA		
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity ³ (500°F)	185	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

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

Notes

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

² 150x105x3mm MT 80°C

³ 1000s-1

