Bayblend® T65 XF

Covestro - Polycarbonates - *Polycarbonate + ABS*

General Information

Product Description			
(PC+ABS)-Blend; Vicat/B 120 temperature = 120°C; improved flow compared with T65			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Flow		
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• FORD WSS-M4D684-B1 • FORD WSS-M4D924-B1 • GM GMW15581P-ABS+PC-T2	• GM GMW15581P-ABS+PC-T2 Color: 901510 Black • GM GMW15581P-ABS+PC-T5 • GM GMW15581P-ABS+PC-T5 Color: 901510 Black	• GM QK 000195 Type B Color: 901510 Black • GM QK 002412 Color: 901510 Black
ISO Designation	• PC+ABS		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.13	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	18	cm³/10min	ISO 1133
Molding Shrinkage [2]			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)	0.70	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	341000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	7830	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	6820	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	4.4	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	> 50	%	ISO 527-2/50
Flexural Modulus [3] (73°F)	341000	psi	ISO 178
Flexural Stress [3]			ISO 178
3.5% Strain, 73°F	10600	psi	
73°F	12200	psi	
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	17	ft·lb/in²	
73°F	24	ft·lb/in²	
Notched Izod Impact Strength			ISO 180/A
-22°F	17	ft·lb/in²	
73°F	23	ft·lb/in²	
Unnotched Izod Impact Strength			ISO 180
-22°F	No Break		
73°F	No Break		
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	252	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	216	°F	ISO 75-2/A

Vicat Softening Temperature			
--	248	°F	ISO 306/B120
--	244	°F	ISO 306/B50
CLTE - Flow (73 to 131°F)	4.4E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	4.7E-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
Relative Permittivity			IEC 60250
73°F, 100 Hz	3.10		
73°F, 1 MHz	3.00		
Dissipation Factor			IEC 60250
73°F, 100 Hz	3.0E-3		
73°F, 1 MHz	8.5E-3		
Comparative Tracking Index (Solution A)	250	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index [4]	24	%	ISO 4589-2
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Melt Viscosity [5] (500°F)	200	Pa·s	ISO 11443-A

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature - Dry Air Dryer	203 to 230	°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	158 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
Standard Melt Temperature: 260°C
Hold Pressure (% of Injection Pressure): 50 - 75%

Notes

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

[2] 150x105x3mm,, MT 80°C

[3] 0.079 in/min

[4] Procedure A

[5] 1000s-1