

Bayblend® FR3311 TV

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

(PC+ABS)-Blend; 15% glass fibre reinforced; flame retardant; easy flowing; Vicat/B 120 temperature = 96°C; UL recognition 94 V-1 at 1.2 mm and V-0 at 1.5 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 • Good Flow
RoHS Compliance	• RoHS Compliant
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) (240°C/5.0 kg)	26	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	798000	psi	ISO 527-1/1
Tensile Stress (Break, 73°F)	13600	psi	ISO 527-2/5
Tensile Strain (Break, 73°F)	3.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	3.3	ft·lb/in ²	ISO 180/A
Unnotched Izod Impact Strength (73°F)	14	ft·lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	198	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	189	°F	ISO 75-2/A
Vicat Softening Temperature	205	°F	ISO 306/B120
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
Relative Permittivity			IEC 60250
73°F, 100 Hz	3.20		
73°F, 1 MHz	3.10		
Dissipation Factor			IEC 60250
73°F, 100 Hz	5.0E-3		
73°F, 1 MHz	7.0E-3		
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.05 in	V-1		
0.06 in	V-0		
0.08 in, BK	5VB		
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity ² (500°F)	115	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 176 °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 1000s-1

