

Bayblend® RW85 XF

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

(PC+ABS)-Blend; suitable for use in electrical and electronic devices; Easy flow; injection molding grade

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Good Flow
Uses	• Electrical/Electronic Applications
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding
ISO Designation	• PC+ABS

Properties ¹

Physical	Nominal Value	Unit	Test Method
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)	349000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	7110	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	6380	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	> 50	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/A
-22°F	9.0	ft·lb/in ²	
73°F	20	ft·lb/in ²	
Unnotched Izod Impact Strength			ISO 180
-22°F	85	ft·lb/in ²	
73°F	No Break		
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	255	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	214	°F	ISO 75-2/A
Vicat Softening Temperature	262	°F	ISO 306/B120

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	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	464 to 536	°F
Mold Temperature	140 to 212	°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: 270°C

