

Bayblend® T95 MF

Covestro - Polycarbonates - Polycarbonate + ABS

General Information

Product Description

(PC+ABS)-Blend; 9 % mineral filled; Vicat/B 120 temperature = 142°C;; very good heat resistance; reduced coefficient of thermal expansion; tensile modulus = 3350 MPa

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Mineral, 9.0% Filler by Weight
Features	• High Heat Resistance • Low CLTE
RoHS Compliance	• RoHS Compliant
ISO Designation	• PC+ABS-TD9

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.24	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	18	cm ³ /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)	0.60	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	486000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9570	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	7540	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	4.6	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	> 50	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/A
-22°F	4.3	ft·lb/in ²	
73°F	4.3	ft·lb/in ²	
Unnotched Izod Impact Strength (73°F)	> 71	ft·lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	277	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	255	°F	ISO 75-2/A
Vicat Softening Temperature			
--	288	°F	ISO 306/B120
--	284	°F	ISO 306/B50
CLTE - Flow (73 to 131°F)	3.1E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.6E-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	3.20		
73°F, 1 MHz	3.00		



Dissipation Factor		IEC 60250
73°F, 100 Hz	1.5E-3	
73°F, 1 MHz	9.0E-3	
Comparative Tracking Index (Solution A)	200 V	IEC 60112
Flammability	Nominal Value Unit	Test Method
Flame Rating (0.03 in, Internal Test)	HB	UL 94
Fill Analysis	Nominal Value Unit	Test Method
Melt Viscosity ³ (500°F)	400 Pa·s	ISO 11443-A

Processing Information

	Nominal Value	Unit
Injection		
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	500 to 536	°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

Standard Melt Temperature: 270°C
Peripheral Screw Speed: 0.05 - 0.2 m/s
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 1000s-1

