

Bayblend® T85 X RE

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

(PC+ABS)-Blend; General Purpose Grade; Vicat/B 120 temperature = 131 °C; good injection molding processing behaviour (easy flowing); excellent long-term ageing behaviour under humid conditions and painting performance; improved chemical resistance; low VOC emissions and odour

Partially bio-circular grade / Attributed via mass balance (according to ISCC PLUS Standard).

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • General Purpose	• Good Flow • Low Emissions	• Low Odor
Uses	• General Purpose		
Agency Ratings	• ISCC PLUS		
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		
ISO Designation	• PC+ABS		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.14	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	18	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow : 500°F, 0.0787 in	0.55 to 0.75	%	
Flow : 500°F, 0.0787 in	0.55 to 0.75	%	
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)	334000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	8120	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	7980	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	4.9	%	ISO 527-2/50
Nominal Tensile Strain at Break (73°F)	100	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	22	ft·lb/in ²	
73°F	29	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	No Break		
73°F	No Break		
Notched Izod Impact Strength			ISO 180/A
-22°F	22	ft·lb/in ²	
73°F	27	ft·lb/in ²	
Unnotched Izod Impact Strength			ISO 180
-22°F	No Break		
73°F	No Break		
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-22°F	41.3	ft·lb	



73°F	35.4 ft·lb	
Multi-Axial Instrumented Impact Peak Force		ISO 6603-2
-22°F	1210 lbf	
73°F	1010 lbf	
Thermal	Nominal Value	Unit
Deflection Temperature Under Load (66 psi, Unannealed)	261	°F
Deflection Temperature Under Load (264 psi, Unannealed)	223	°F
Vicat Softening Temperature		
--	268	°F
--	264	°F
CLTE - Flow (73 to 131°F)	3.9E-5	in/in/°F
CLTE - Transverse (73 to 131°F)	3.9E-5	in/in/°F
Electrical	Nominal Value	Unit
Surface Resistivity	1.0E+16	ohms
Volume Resistivity (73°F)	1.0E+18	ohms·cm
Electric Strength (73°F, 0.0394 in)	1000	V/mil
Relative Permittivity		
73°F, 100 Hz	3.00	
73°F, 1 MHz	3.00	
Dissipation Factor		
73°F, 100 Hz	2.0E-3	
73°F, 1 MHz	9.0E-3	
Comparative Tracking Index (Solution A)	225	V
Flammability	Nominal Value	Unit
Flame Rating (0.03 in, Internal Test)	HB	
Fill Analysis	Nominal Value	Unit
Melt Viscosity (500°F, 1000 sec ⁻¹)	235	Pa·s

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	0.010	%
Processing (Melt) Temp	518 to 554	°F
Mold Temperature	158 to 194	°F
Injection Notes		
Standard Melt Temperature: 280°C		

Notes

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

