

Bayblend® T88 GF-30

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

Rubber modified (PC+SAN) blend; 31 % glass fiber filled; Vicat/B 120 temperature = 134°C; optimized heat ageing- and UV-stability; very good flow; tensile modulus = 10000 MPa; good heat resistance

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 31% Filler by Weight
Features	• Good Flow • High Heat Resistance • Heat Aging Resistant • UV Resistant
RoHS Compliance	• RoHS Compliant
ISO Designation	• PC+SAN-I-GF30

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.38	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	11	cm ³ /10min	ISO 1133
Molding Shrinkage ²			ISO 2577
Across Flow : 500°F, 0.118 in	0.30 to 0.50	%	
Flow : 500°F, 0.118 in	0.15 to 0.35	%	
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)	1.45E+6	psi	ISO 527-1/1
Tensile Stress (Break, 73°F)	19600	psi	ISO 527-2/5
Tensile Strain (Break, 73°F)	2.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/A
-22°F	5.2	ft·lb/in ²	
73°F	5.7	ft·lb/in ²	
Unnotched Izod Impact Strength			ISO 180
-22°F	19	ft·lb/in ²	
73°F	19	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	273	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	259	°F	ISO 75-2/A
Vicat Softening Temperature			
--	273	°F	ISO 306/B120
--	270	°F	ISO 306/B50
CLTE - Flow (73 to 131°F)	1.4E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.3E-5	in/in/°F	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	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	3.60		



73°F, 1 MHz	3.40	
Dissipation Factor		IEC 60250
73°F, 100 Hz	3.0E-3	
73°F, 1 MHz	8.5E-3	
Comparative Tracking Index (Solution A)	175 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)	250 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	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

Peripheral Screw Speed: 0.05 - 0.2 m/s
 Hold Pressure (% of Injection Pressure): 50 - 75%
 Standard Melt Temperature: 270°C

Notes

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

² 150x105x3mm., MT 80°C

³ 1000s-1

