

**Bayblend® T88 GF-20 HI**

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

Rubber modified (PC+SAN) blend; 20% glass fiber filled; Vicat/B 120 temperature = 134 °C; tensile modulus = 6000 MPa; optimized heat ageing- and UV-stability; very good flow; for demanding applications in the automotive interior

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Features	• Good Flow
Uses	• Automotive Applications • Automotive Interior Parts
ISO Designation	• PC+SAN-I-GF20

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.29	g/cm <sup>3</sup>	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	9.0	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage <sup>2</sup>			ISO 294-4
Across Flow : 500°F, 0.0787 in	0.40	%	
Flow : 500°F, 0.0787 in	0.40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	870000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	14500	psi	ISO 527-2/5
Tensile Stress (Break, 73°F)	14500	psi	ISO 527-2/5
Tensile Strain (Yield, 73°F)	2.9	%	ISO 527-2/5
Tensile Strain (Break, 73°F)	3.0	%	ISO 527-2/5
Flexural Modulus <sup>3</sup> (73°F)	798000	psi	ISO 178
Flexural Stress <sup>3</sup> (3.5% Strain, 73°F)	21000	psi	ISO 178
Flexural Strain at Flexural Strength <sup>4</sup>	4.0	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	4.8	ft·lb/in <sup>2</sup>	
73°F	6.2	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	24	ft·lb/in <sup>2</sup>	
73°F	20	ft·lb/in <sup>2</sup>	
Notched Izod Impact Strength			ISO 180/A
-22°F	4.3	ft·lb/in <sup>2</sup>	
73°F	5.7	ft·lb/in <sup>2</sup>	
Unnotched Izod Impact Strength			ISO 180
-22°F	21	ft·lb/in <sup>2</sup>	
73°F	19	ft·lb/in <sup>2</sup>	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	18100	psi	ISO 2039-1
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	279	°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)	1.7E-5 in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	4.7E-5 in/in/°F	ISO 11359-2
<b>Fill Analysis</b>	<b>Nominal Value Unit</b>	<b>Test Method</b>
Melt Viscosity <sup>5</sup> (500°F)	250 Pa·s	ISO 11443-A

### Processing Information

<b>Injection</b>	<b>Nominal Value Unit</b>
Drying Temperature - Dry Air Dryer	212 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  
Standard Melt Temperature: 270°C  
Hold Pressure (% of Injection Pressure): 50 - 75%

### Notes

- <sup>1</sup> Typical properties: these are not to be construed as specifications.
- <sup>2</sup> 60x60x2mm, MT 80°C
- <sup>3</sup> 0.079 in/min
- <sup>4</sup> 2.0 mm/min
- <sup>5</sup> 1000s<sup>-1</sup>

