Bayblend® W90 XG

Covestro - Polycarbonates - *Polycarbonate + ASA*

General Information

Product Description			
PC+ASA-Blend; Vicat/B 120 temperature = 115°C; UV-stabilized; very good surface finish			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• UV Stabilizer		
Features	• Good Surface Finish	• UV Stabilized	
RoHS Compliance	• RoHS Compliant		
ISO Designation	• PC + ASA		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.14	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	34	cm³/10min	ISO 1133
Molding Shrinkage [2]			ISO 294-4
Across Flow : 0.0787 in	0.50 to 0.70	%	
Flow : 0.0787 in	0.50 to 0.70	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	410000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9430	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	7250	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	4.0	%	ISO 527-2/50
Tensile Strain (Break, 73°F)	50	%	ISO 527-2/50
Flexural Modulus [3] (73°F)	• 412000 psi • 14500		ISO 178
Flexural Stress [3] (3.5% Strain, 73°F)	12300	psi	ISO 178
Flexural Strain at Flexural Strength [4] (73°F)	5.0	%	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength			ISO 180/A
-22°F	3.3	ft·lb/in²	
73°F	6.7	ft·lb/in²	
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-22°F	14.8	ft·lb	
73°F	33.2	ft·lb	
Multi-Axial Instrumented Impact Peak Force			ISO 6603-2
-22°F	955	lbf	
73°F	1080	lbf	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	234	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	199	°F	ISO 75-2/A
Vicat Softening Temperature			
--	239	°F	ISO 306/B120
--	235	°F	ISO 306/B50
CLTE - Flow (73 to 131°F)	3.9E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.9E-5	in/in/°F	ISO 11359-2

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	%
Suggested Shot Size	30 to 70	%
Rear Temperature	428 to 446	°F
Middle Temperature	437 to 455	°F
Front Temperature	446 to 464	°F
Nozzle Temperature	491 to 509	°F
Processing (Melt) Temp	464 to 518	°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: 260°C

Notes

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

[2] 60x60x2mm

[3] 0.079 in/min

[4] 2.0 mm/min