

**Bayblend® W85 XF**

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

PC+ASA-Blend; Vicat/B 120 temperature = 132°C; improved weather resistance; excellent low temperature ductility; excellent low temperature ductility; good heat resistance

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Features	• Ductile • Good Weather Resistance • Medium Heat Resistance
RoHS Compliance	• RoHS Compliant
Processing Method	• Injection Molding
ISO Designation	• PC+ASA

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

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.16	g/cm <sup>3</sup>	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	27	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage <sup>2</sup>			ISO 2577
Across Flow : 500°F, 0.118 in	0.55 to 0.75	%	
Flow : 500°F, 0.118 in	0.55 to 0.75	%	
Water Absorption (Saturation, 73°F)	0.50	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	355000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	9140	psi	ISO 527-2/50
Tensile Stress (Break, 73°F)	8990	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	5.0	%	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
-4°F	7.1	ft·lb/in <sup>2</sup>	
73°F	21	ft·lb/in <sup>2</sup>	
Unnotched Izod Impact Strength			ISO 180
-22°F	No Break		
73°F	No Break		
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	261	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	228	°F	ISO 75-2/A
Vicat Softening Temperature			
--	270	°F	ISO 306/B120
--	266	°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
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	3.10	
73°F, 1 MHz	2.80	
Dissipation Factor		IEC 60250
73°F, 100 Hz	2.5E-3	
73°F, 1 MHz	0.011	
Comparative Tracking Index (Solution A)	225 V	IEC 60112
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>
Flame Rating (0.03 in)	HB	UL 94
Oxygen Index <sup>3</sup>	25 %	ISO 4589-2
<b>Fill Analysis</b>	<b>Nominal Value</b>	<b>Unit</b>
Melt Viscosity <sup>4</sup> (500°F)	225 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	< 0.010	%
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

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

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 150x105x3mm., MT 80°C

<sup>3</sup> Procedure A

<sup>4</sup> 1000s-1

