Bayblend® T65 XF

(PC+ABS)

Covestro Deutschland AG

- (PC ABS)-Blend
- Vicat/B 120 temperature = 120 °C
- improved flow compared with T65

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	18	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Yield strain	4.4	%	ISO 527
Notched Impact Strength (Charpy), +23°C	50	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	36	kJ/m²	ISO 179/1eA

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	102	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	122	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	118	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	80	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	85	E-6/K	ISO 11359-1/-2
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-
Oxygen index	24	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation Factor, 100Hz	30	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	85	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	>1E15	Ohm	IEC 62631-3-2
Electric Strength	35	kV/mm	IEC 60243-1
Comparative tracking index	250	-	IEC 60112

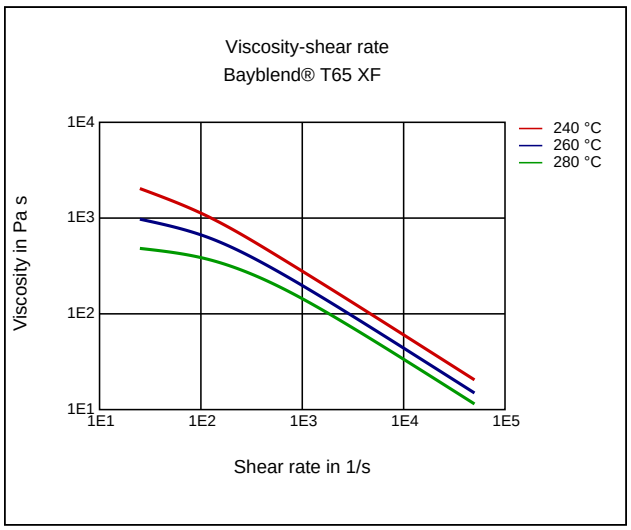
Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.7	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1130	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	240	mm/s	ISO 294

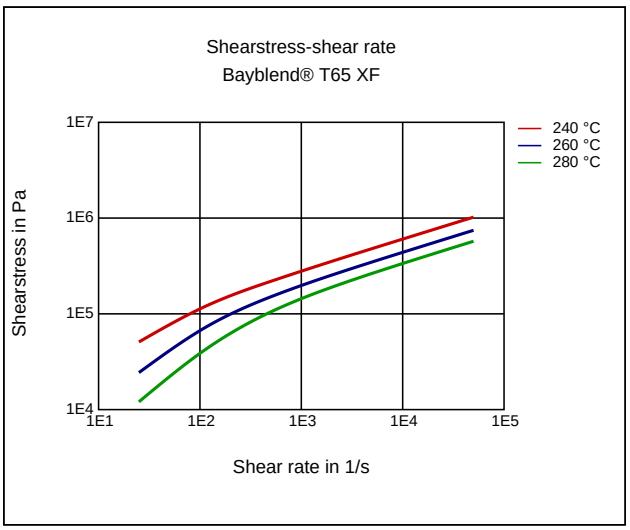
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	70 - 100	°C	-

Diagrams

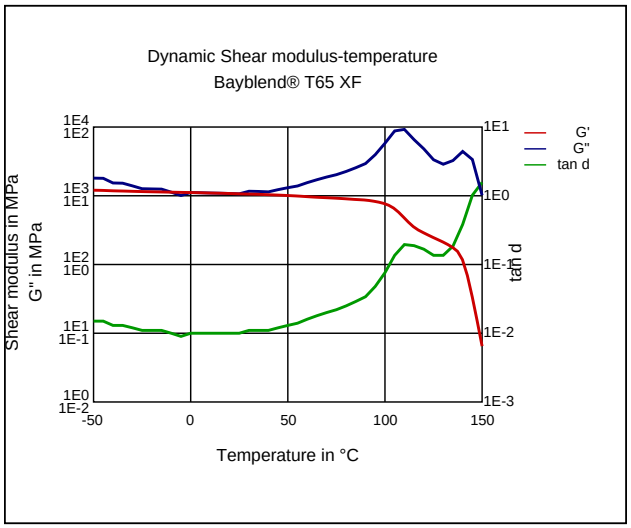
Viscosity-shear rate



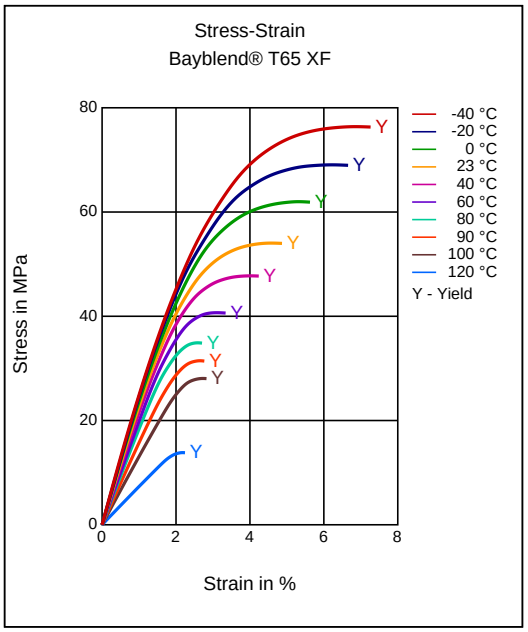
Shearstress-shear rate



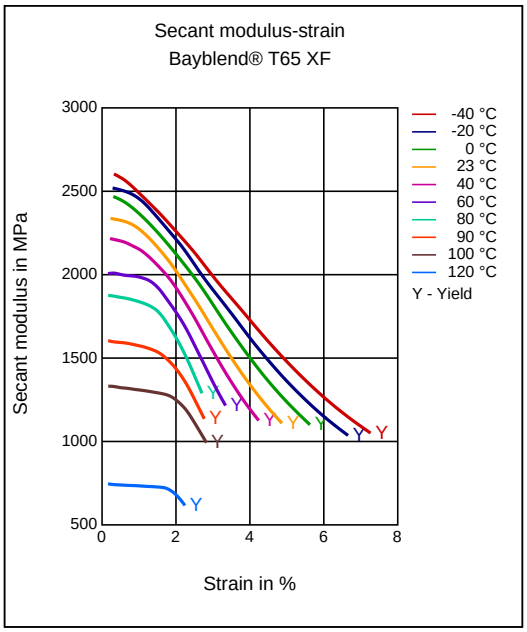
Dynamic Shear modulus-temperature



Stress-strain



Secant modulus-strain



Characteristics

Processing
Injection Molding

Additives
Release agent

Delivery form
Pellets

Injection Molding

PREPROCESSING
Max. Water content: 0.02 %
Drying temperature: 100 - 110 °C
(depending on the grade 10°C below the Vicat VST/B120 temperature, but not higher as the recommended values).
Drying time:
Circulating air drying oven (50 % fresh air) 4-8 h
Fresh air dryer (high speed dryer) 2-4 h
Dry air dryer 2-4 h

PROCESSING
Melt temperature: 240-280 °C
Mold temperature: 70-100 °C

Use open nozzle.

Disclaimer

Important: irrespective of product type or designation, ALBIS does not recommend or support the use of any products it supplies which fall into the following medical, pharmaceutical or diagnostic application categories:

- risk class III applications according to EU directive 93/42/EEC
- any bodily implant application for greater than 30 days
- any critical component in any medical device that supports or sustains human life.

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