

Bayblend® 2953

Standard grades / Non reinforced

(PC+ABS)-Blend; Vicat/B 120 temperature = 113°C; for electroplating applications

ISO Shortname

PC+ABS

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	260 °C/ 5 kg	cm³/10 min	ISO 1133	14
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2100
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	44
C Yield strain	50 mm/min	%	ISO 527-1,-2	3.6
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Stress at break	50 mm/min	MPa	ISO 527-1,-2	47
Flexural modulus	2 mm/min	MPa	ISO 178	2200
Flexural strain at flexural strength	2 mm/min	%	ISO 178	5.6
Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	65
Izod notched impact strength	23 °C	kJ/m²	ISO 180-A	46
Izod notched impact strength	-30 °C	kJ/m²	ISO 180-A	35
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	90
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	110
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	108
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	113
Other properties (23 °C)				
C Density		kg/m³	ISO 1183-1	1110
Recommended Processing and Drying Conditions				
Melt Temperatures		°C	-	260 - 280
Standard Melt Temperature		°C	-	270
Barrel Temperatures - Rear		°C	-	230 - 240
Barrel Temperatures - Middle		°C	-	235 - 245
Barrel Temperatures - Front		°C	-	240 - 270
Barrel Temperatures - Nozzle		°C	-	265 - 275
Mold Temperatures		°C	-	70 - 90
Hold Pressure (% of injection pressure)		%	-	50 - 75
Plastic Back Pressure (specific)		bar	-	50 - 150
Peripheral Screw Speed		m/s	-	0.05 - 0.2
Shot-to-Cylinder Size		%	-	30 - 70
Dry Air Drying Temperature		°C	-	80
Dry Air Drying Time		h	-	4
Moisture Content max. (%)		%	-	<= 0,02
Vent Depth		mm	-	0.025 - 0.075

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

Impact properties: N = non-break, P = partial break, C = complete break

