

Bayblend® FR3311 TV

FR grades / 15 % Glass fiber reinforced

(PC+ABS)-Blend; 15% glass fibre reinforced; flame retardant; easy flowing; Vicat/B 120 temperature = 96 °C; UL recognition 94 V-1 at 1.2 mm and V-0 at 1.5 mm

ISO Shortname

PC+ABS-GF15-FR(40)

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	240 °C/ 5 kg	cm³/10 min	ISO 1133	26
C Melt viscosity	1000 s ⁻¹ / 260 °C	Pa·s	b.o. ISO 11443-A	115
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	5500
C Stress at break	5 mm/min	MPa	ISO 527-1,-2	94
C Strain at break	5 mm/min	%	ISO 527-1,-2	3
C Izod impact strength		kJ/m²	ISO 180-U	30
C Izod notched impact strength	23 °C	kJ/m²	ISO 180-A	7
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	87
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	92
C Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	96
C Burning behavior UL 94 (1.5 mm) [UL recognition]		Class	UL 94	V-0
C Burning behavior UL 94 [UL recognition]	1.2 mm	Class	UL 94	V-1
C Burning behavior UL 94-5V	2.0 mm	Class	UL 94	5VB (BK)
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.2
C Relative permittivity	1 MHz	-	IEC 60250	3.1
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	50
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	70
C Volume resistivity		Ohm·m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
Other properties (23 °C)				
C Density		kg/m³	ISO 1183-1	1280
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	240
C Injection molding-Mold temperature		°C	ISO 294	80
C Injection molding-Injection velocity		mm/s	ISO 294	240

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Property	Test Condition	Unit	Standard	typical Value
Recommended Processing and Drying Conditions				
Melt Temperatures		°C	-	240 - 270
Standard Melt Temperature		°C	-	260
Barrel Temperatures - Rear		°C	-	220 - 230
Barrel Temperatures - Middle		°C	-	225 - 235
Barrel Temperatures - Front		°C	-	230 - 240
Barrel Temperatures - Nozzle		°C	-	255 - 265
Mold Temperatures		°C	-	60 - 80
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