

Bayblend® M750

Standard grades / Non reinforced

(PC+ABS)-Blend; Vicat/B 120 temperature = 126 °C; meet certain requirements of ISO Standard 10993-1; for further information please contact plastics@covestro.com

ISO Shortname

PC+ABS

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	260 °C/ 5 kg	cm ³ /10 min	ISO 1133	11
Melt viscosity	1000 s ⁻¹ / 260 °C	Pa·s	b.o. ISO 11443-A	265
C Molding shrinkage, parallel	60x60x2 mm/ 260 °C / MT 80 °C/ 500 bar	%	ISO 294-4	0.7 - 0.9
C Molding shrinkage, normal	60x60x2 mm/ 260 °C / MT 80 °C/ 500 bar	%	ISO 294-4	0.7 - 0.9
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	2000
C Yield stress	50 mm/min	MPa	ISO 527-1,-2	47
C Yield strain	50 mm/min	%	ISO 527-1,-2	4.8
C Nominal strain at break	50 mm/min	%	ISO 527-1,-2	> 50
Izod impact strength	23 °C	kJ/m ²	ISO 180-U	N
Izod notched impact strength	23 °C	kJ/m ²	ISO 180-A	45
Izod notched impact strength	-30 °C	kJ/m ²	ISO 180-A	35
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	104
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	127
Vicat softening temperature	50 N; 120 °C/h	°C	ISO 306	126
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.85
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0.85
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.0
C Relative permittivity	1 MHz	-	IEC 60250	2.9
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	25
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	105
C Volume resistivity		Ohm·m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
C Electrical strength	1 mm	kV/mm	IEC 60243-1	35
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	325
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.6
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.2
C Density		kg/m ³	ISO 1183-1	1120
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	260
C Injection molding-Mold temperature		°C	ISO 294	80

Bayblend® M750

Property	Test Condition	Unit	Standard	typical Value
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	-	95 - 110
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