

Bayblend® M850 XF RE (PC+ABS)

Covestro Deutschland AG

- (PC+ABS)-Blend
- easy flowing
- Vicat/B 120 temperature = 131 °C
- meet certain requirements of ISO Standard 10993-1
- for further information please contact plastics@covestro.com

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	25	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2500	MPa	ISO 527
Yield stress	62	MPa	ISO 527
Yield strain	4.9	%	ISO 527
Notched Impact Strength (Izod), 23 °C	48	kJ/m ²	ISO 180/1A
Notched Impact Strength (Izod)	15	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23 °C	no break	kJ/m ²	ISO 180/1U

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	109	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	127	°C	ISO 75-1/-2
Vicat softening temperature, 50 °C/h 50N	129	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	70	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	70	E-6/K	ISO 11359-1/-2
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	2.9	-	IEC 62631-2-1
Relative permittivity, 1MHz	2.9	-	IEC 62631-2-1
Dissipation Factor, 100Hz	30	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	90	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
Relative permittivity, 100Hz	2.9	-	IEC 60250
Relative permittivity, 1MHz	2.9	-	IEC 60250
Dissipation Factor, 100Hz	30	E-4	IEC 60250
Dissipation Factor, 1MHz	90	E-4	IEC 60250
Volume Resistivity	1E14	Ohm*m	IEC 60093
Surface Resistivity	1E17	Ohm	IEC 60093

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	1140	kg/m ³	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	95 - 110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	230 - 240	°C	-
Zone 2	235 - 245	°C	-
Zone 3	240 - 270	°C	-
Nozzle temperature	265 - 275	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Certifications

Contains renewable resources, Biocompatibility ISO 10993, ISCC Plus

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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