

Bayblend® T65 HI (PC+ABS)

Covestro Deutschland AG

- (PC ABS)-Blend
- Vicat/B 120 temperature = 120 °C
- grade with improved low-temperature impact strength and chemical resistance for automotive parts
- also suitable for extrusion/extrusion blow molding and electroplating applications

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

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	48	MPa	ISO 527
Yield strain	4.5	%	ISO 527

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	99	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	120	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	118	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	90	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	95	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	3	-	IEC 62631-2-1
Relative permittivity, 1MHz	2.9	-	IEC 62631-2-1
Dissipation Factor, 100Hz	25	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	275	-	IEC 60112

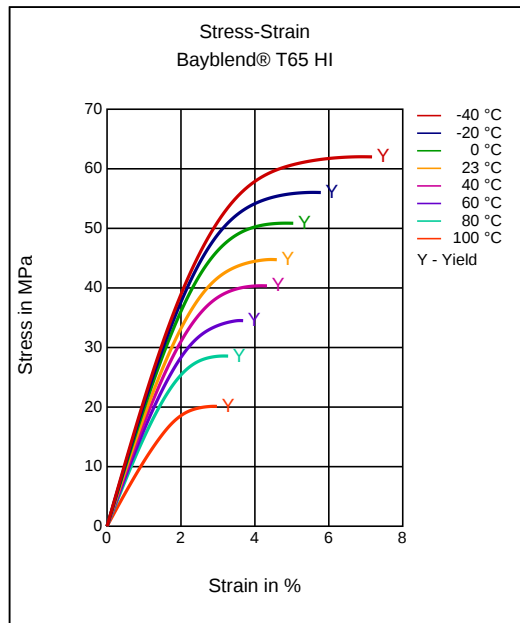
Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.7	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1110	kg/m³	ISO 1183

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

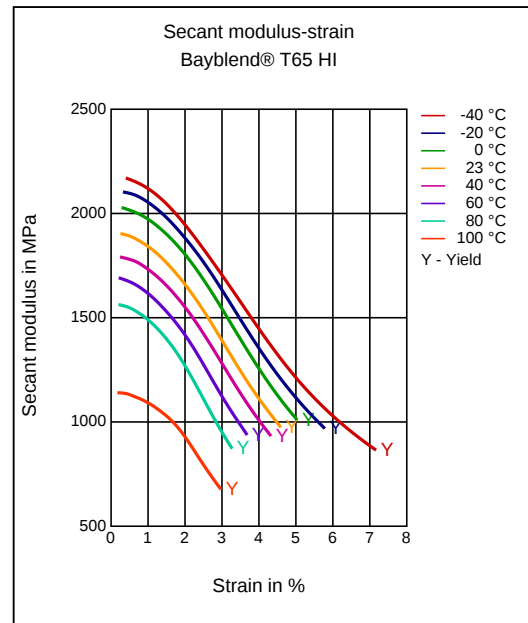
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	70 - 100	°C	-

Diagrams

Stress-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding, Profile Extrusion, Sheet Extrusion, Other Extrusion, Blow Molding, Thermoforming

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Platable

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

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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