Bayblend® T65 XF RE

(PC+ABS)

Covestro Deutschland AG

Partially bio-circular grade.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	18	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Yield strain	4.4	%	ISO 527
Stress at Break	47	MPa	ISO 527
Strain at Break	>50	%	ISO 527
Notched Impact Strength (Charpy), +23°C	50	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	36	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	2350	MPa	ISO 178
Flexural strength	84	MPa	ISO 178
Notched Impact Strength (Izod), 23°C	48	kJ/m²	ISO 180/1A
Notched Impact Strength (Izod)	35	kJ/m²	ISO 180/1A
Temperature	-30	°C	-
Impact Strength (Izod), 23°C	no break	kJ/m²	ISO 180/1U

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	102	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	122	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	118	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	80	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	85	E-6/K	ISO 11359-1/-2
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-
UL recognition	yes	-	-
Oxygen index	24	%	ISO 4589-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Volume Resistivity	1E14	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E16	Ohm	IEC 62631-3-2
Electric Strength	35	kV/mm	IEC 60243-1
Comparative tracking index	250	-	IEC 60112
Relative permittivity, 100Hz	3.1	-	IEC 60250
Relative permittivity, 1MHz	3	-	IEC 60250
Dissipation Factor, 100Hz	30	E-4	IEC 60250
Dissipation Factor, 1MHz	85	E-4	IEC 60250

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	1130	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	95 - 110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	220 - 230	°C	-
Zone 2	225 - 235	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	255 - 265	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing
Injection Molding

Certifications
Contains renewable resources, ISCC Plus

Disclaimer

Liability Exclusion
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