



Bayblend® T50 PG

(ABS+PC)

Covestro Deutschland AG

- formerly Bayblend® TP2350
- ABS+PC-Blend
- Vicat/B 120 temperature = 113°C
- for electroplating applications

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	12	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	1900	MPa	ISO 527
Yield stress	47	MPa	ISO 527
Yield strain	4.3	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	50	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	50	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	3500	N	ISO 6603-2
Puncture - maximum force, -30°C	4400	N	ISO 6603-2
Puncture energy, +23°C	40	J	ISO 6603-2
Puncture energy, -30°C	45	J	ISO 6603-2
Notched Impact Strength (Izod), 23°C	45	kJ/m ²	ISO 180/1A
Notched Impact Strength (Izod)	45	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)	93	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	114	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	111	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	90	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	90	E-6/K	ISO 11359-1/-2

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	2.5	-	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	110	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	300	-	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	1100	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

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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

Special Characteristics

Platable