

Bayblend® FC85

(PC+ABS)

Covestro Deutschland AG

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	15	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	59	MPa	ISO 527
Yield strain	4.8	%	ISO 527
Stress at break	51	MPa	ISO 527
Strain at break	>50	%	ISO 527
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	60	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	48	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	56	kJ/m ²	ISO 180/1A
Izod notched impact strength	43	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Puncture energy, +23°C	50	J	ISO 6603-2
Puncture energy, -30°C	57	J	ISO 6603-2
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	270	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	108	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	128	°C	ISO 75-1/-2
Vicat softening temperature, B	130	°C	ISO 306
Coeff. of linear therm. expansion, parallel	75	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	75	E-6/K	ISO 11359-1/-2
Other properties			
Density	1150	kg/m ³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	260	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Processing Recommendation Injection Molding			
Pre-drying - Temperature	95 - 110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	270	°C	-
Mold temperature	60 - 100	°C	-
Feed temperature	230 - 240	°C	-
Zone 1	235 - 245	°C	-
Zone 2	240 - 270	°C	-
Nozzle temperature	265 - 275	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Certifications

Food contact

Regional Availability

North America, Europe, Asia Pacific, South and Central America,
Near East/Africa