

**Product Texts**

- (PC ABS)-Blend
- flame retardant
- high heat resistance
- Vicat/B 120 temperature = 136 °C
- ball indentation temperature >= 125 °C
- UL recognition 94 V-0 at 1.5 mm
- suitable as supporting material for energized parts

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	19	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2400	MPa	ISO 527
<sup>[C]</sup> Yield stress	63	MPa	ISO 527
<sup>[C]</sup> Yield strain	5	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	114	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	126	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	134	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	68	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	68	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
<sup>[C]</sup> Burning Behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2.0	mm	-
<sup>[C]</sup> Oxygen index	30	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	3.2	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	20	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	85	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<sup>[C]</sup> Electric strength	35	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	350	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.5	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	0.2	%	Sim. to ISO 62
<sup>[C]</sup> Density	1190	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	260	°C	ISO 294

**Bayblend® FR1514**

(PC+ABS) FR(40)

Covestro Deutschland AG

Injection Molding, mold temperature	<b>80</b>	°C	ISO 294
Injection Molding, injection velocity	<b>240</b>	mm/s	ISO 294

[C]: CAMPUS

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

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Flame retardant, Heat stabilized or stable to heat

**Delivery form**

Pellets

**Regional Availability**

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

**Additives**

Release agent

**Other text information****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.