

**Bayblend® FR3042**

(PC+ABS)

Covestro Deutschland AG

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	<b>19</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>240</b>	°C	-
Load	<b>5</b>	kg	-
Molding shrinkage, parallel	<b>0.6</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.6</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	<b>2500</b>	MPa	ISO 527
Yield stress	<b>67</b>	MPa	ISO 527
Yield strain	<b>4</b>	%	ISO 527
Stress at break	<b>58</b>	MPa	ISO 527
Strain at break	<b>&gt;50</b>	%	ISO 527
Izod notched impact strength, +23°C	<b>29</b>	kJ/m <sup>2</sup>	ISO 180/1A
<b>Thermal properties</b>			
<b>ISO Data</b>			
Vicat softening temperature, B	<b>105</b>	°C	ISO 306
Burning behav. at thickness h	<b>V-0</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8</b>	mm	-
<b>Other properties</b>			
Density	<b>1200</b>	kg/m <sup>3</sup>	ISO 1183
<b>Test specimen production</b>			
<b>ISO Data</b>			
Injection Molding, melt temperature	<b>240</b>	°C	ISO 294
Injection Molding, mold temperature	<b>80</b>	°C	ISO 294
Injection Molding, injection velocity	<b>240</b>	mm/s	ISO 294
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>240 - 270</b>	°C	-
Mold temperature	<b>60 - 90</b>	°C	-
Zone 1	<b>220 - 230</b>	°C	-
Zone 2	<b>225 - 235</b>	°C	-
Zone 3	<b>230 - 240</b>	°C	-
Nozzle temperature	<b>255 - 265</b>	°C	-
Back pressure	<b>5 - 15</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Black

**Special Characteristics**

Flame retardant

**Regional Availability**

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