

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	19	cm <sup>3</sup> /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	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Yield strain	4.7	%	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	>50	%	ISO 527
Charpy notched impact strength, +23°C	50	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	37	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	48	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	35	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	107	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	126	°C	ISO 75-1/-2
Vicat softening temperature, B	128	°C	ISO 306
Coeff. of linear therm. expansion, parallel	75	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	80	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Oxygen index	24	%	ISO 4589-1/-2

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	3	-	IEC 62631-2-1
Dissipation factor, 100Hz	20	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	85	E-4	IEC 62631-2-1
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	225	-	IEC 60112

Other properties	Value	Unit	Test Standard
Water absorption	0.7	%	Sim. to ISO 62
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1140	kg/m <sup>3</sup>	ISO 1183

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
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	-

**Bayblend® T85 XF RE25 CQ**

(PC+ABS)

Covestro Deutschland AG

Pre-drying - Time	<b>4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>260 - 280</b>	°C	-
Mold temperature	<b>70 - 90</b>	°C	-
Zone 1	<b>230 - 240</b>	°C	-
Zone 2	<b>235 - 245</b>	°C	-
Zone 3	<b>240 - 270</b>	°C	-
Nozzle temperature	<b>265 - 275</b>	°C	-
Back pressure	<b>5 - 15</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific, Near East/Africa

**Certifications**

Contains renewable resources, ISCC Plus