



Bayblend® T65 XF

(PC+ABS)-Blend; Vicat/B 120 temperature = 120°C; improved flow compared with T65

Physical Properties

MEASUREMENT	CONDITION	Value
Density (73°F)	ISO 1183	1.13 g/cm ³
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	ISO 1133	18 cm ³ /10min
Molding Shrinkage ³ Across Flow : 500°F, 0.118 in Flow : 500°F, 0.118 in	ISO 2577	0.50 to 0.70 % 0.50 to 0.70 %
Water Absorption Saturation, 73°F Equilibrium, 73°F, 50% RH	ISO 62	0.70 % 0.20 %

Features

- Good Flow

Colors

- White
- Gray
- Green

Mechanical Properties

MEASUREMENT	CONDITION	Value
Tensile Modulus (73°F)	ISO 527-1/1	341000 psi
Tensile Stress Yield, 73°F Break, 73°F	ISO 527-2/50	7830 psi 6820 psi
Tensile Strain Yield, 73°F Break, 73°F	ISO 527-2/50	4.4 % > 50 %
Flexural Modulus 4 (73°F)	ISO 178	341000 psi
Flexural Stress 4 3.5% Strain, 73°F 73°F	ISO 178	10600 psi 12200 psi

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Impact Properties

MEASUREMENT	CONDITION	Value
Charpy Notched Impact Strength -22°F 73°F	ISO 179/1eA	17 ft·lb/in ² 24 ft·lb/in ²
Notched Izod Impact Strength -22°F 73°F	ISO 180/A	17 ft·lb/in ² 23 ft·lb/in ²
Unnotched Izod Impact Strength -22°F 73°F	ISO 180	No Break No Break

Thermal Properties

MEASUREMENT	CONDITION	Value
Deflection Temperature Under Load 66 psi, Unannealed 264 psi, Unannealed	ISO 75-2/B ISO 75-2/A	252°F 216°F
Vicat Softening Temperature	ISO 306/B120 ISO 306/B50	248°F 244°F
CLTE Flow : 73 to 131°F Transverse : 73 to 131°F	ISO 11359-2	4.4E-5in/in/°F 4.7E-5in/in/°F

Electrical Properties

MEASUREMENT	CONDITION	Value
Surface Resistivity	IEC 60093	1.0E+16 ohms
Volume Resistivity (73°F)	IEC 60093	1.0E+16 ohms·cm
Electric Strength (73°F, 0.0394 in)	IEC 60243-1	890 V/mil
Relative Permittivity 73°F, 100 Hz 73°F, 1 MHz	IEC 60250	3.10 3.00
Dissipation Factor 73°F, 100 Hz 73°F, 1 MHz	IEC 60250	3.0E-3 8.5E-3
Comparative Tracking Index (Solution A)	IEC 60112	250 V

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Flammability Properties

MEASUREMENT	CONDITION	Value
Flame Rating (0.03 in)	UL 94	HB
Oxygen Index ⁵	ISO 4589-2	24 %

Fill Analysis

MEASUREMENT	CONDITION	Value
Melt Viscosity ⁶ (500°F)	ISO 11443-A	200 Pa·s

Injection Properties

MEASUREMENT	Value
Drying Temperature - Dry Air Dryer	203 to 230°F
Drying Time - Dry Air Dryer	4.0 hr
Suggested Max Moisture	< 0.020%
Suggested Shot Size	30 to 70%
Rear Temperature	428 to 446°F
Middle Temperature	437 to 455°F
Front Temperature	446 to 464°F
Nozzle Temperature	491 to 509°F
Processing (Melt) Temp	464 to 518°F
Mold Temperature	158 to 194°F
Back Pressure	725 to 2180psi
Vent Depth	9.8E-4 to 3.0E-3in
Peripheral Screw Speed	0.05 - 0.2 m/s
Standard Melt Temperature	260°C
Hold Pressure (% of Injection Pressure)	50 - 75%

³150x105x3mm,, MT 80°C

⁴0.079 in/min

⁵Procedure A

⁶1000s-1

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