



Bayblend® T85 XF

Covestro - Polycarbonates - Polycarbonate + ABS

Thursday, January 23, 2025

General Information

Product Description

(PC+ABS)-Blend; Vicat/B 120 temperature = 130 °C; improved flow compared with T85

General

Material Status	• Commercial: Active		
Regional Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Good Flow		
RoHS Compliance	• RoHS Compliant		
Automotive Specifications	• FORD WSA-M4D688-A1 • FORD WSA-M4D688-A2 • FORD WSS-M4D585-B • FORD WSS-M4D585-C1	• GM GMP.ABS+PC.002 • GM GMW15581P-ABS+PC-T3 • GM GMW15581P-ABS+PC-T3 Color: 901510 Black • GM GMW15581P-ABS+PC-T6	• GM GMW15581P-ABS+PC-T6 Color: 901510 Black • GM QK 000188 Type B Color: 901510 Black • GM QK 002413 Color: 901510 Black
ISO Shortname	• PC+ABS		

ASTM & ISO Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density (73°F (23°C))	1.14 g/cm ³	1.14 g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	19 cm ³ /10min	19 cm ³ /10min	ISO 1133
Molding Shrinkage ²			ISO 2577
Across Flow : 500°F (260°C), 0.118 in (3.00 mm)	0.50 to 0.70 %	0.50 to 0.70 %	
Flow : 500°F (260°C), 0.118 in (3.00 mm)	0.50 to 0.70 %	0.50 to 0.70 %	
Water Absorption			ISO 62
Saturation, 73°F (23°C)	0.70 %	0.70 %	
Equilibrium, 73°F (23°C), 50% RH	0.20 %	0.20 %	
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus (73°F (23°C))	334000 psi	2300 MPa	ISO 527-1/1
Tensile Stress			ISO 527-2/50
Yield, 73°F (23°C)	7830 psi	54.0 MPa	
Break, 73°F (23°C)	7250 psi	50.0 MPa	
Tensile Strain			ISO 527-2/50
Yield, 73°F (23°C)	4.7 %	4.7 %	
Break, 73°F (23°C)	> 50 %	> 50 %	

Copyright ©, 2025 , Formerra, LLC. All the information in this literature is for general information purpose only. Formerra makes no representations, guarantees, or warranties of any kind with respect to the information contained in this literature, including its accuracy, completeness, reliability, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for pricing, property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Formerra makes no warranties or guarantees respecting suitability of either Formerra's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. FORMERRA MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature or any other provided literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner. Any action you take upon the information you find in this literature is strictly at your own risk. Formerra will not be liable for any losses and/or damages in connection with the use of this literature. By using this literature, you hereby consent to this disclaimer and agree to its terms.

Bayblend® T85 XF

Covestro - Polycarbonates - Polycarbonate + ABS

Impact	Typical Value (English)	Typical Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	18 ft·lb/in ²	37 kJ/m ²	
73°F (23°C)	24 ft·lb/in ²	50 kJ/m ²	
Notched Izod Impact Strength			ISO 180/A
-22°F (-30°C)	17 ft·lb/in ²	35 kJ/m ²	
73°F (23°C)	23 ft·lb/in ²	48 kJ/m ²	
Unnotched Izod Impact Strength			ISO 180
-22°F (-30°C)	No Break	No Break	
73°F (23°C)	No Break	No Break	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Unannealed	259 °F	126 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	225 °F	107 °C	ISO 75-2/A
Vicat Softening Temperature			
--	266 °F	130 °C	ISO 306/B120
--	262 °F	128 °C	ISO 306/B50
CLTE			ISO 11359-2
Flow : 73 to 131°F (23 to 55°C)	4.2E-5 in/in/°F	7.5E-5 cm/cm/°C	
Transverse : 73 to 131°F (23 to 55°C)	4.4E-5 in/in/°F	8.0E-5 cm/cm/°C	
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+16 ohms	1.0E+16 ohms	IEC 60093
Volume Resistivity (73°F (23°C))	1.0E+16 ohms·cm	1.0E+16 ohms·cm	IEC 60093
Electric Strength			IEC 60243-1
73°F (23°C), 0.0394 in (1.00 mm)	890 V/mil	35 kV/mm	
Relative Permittivity			IEC 60250
73°F (23°C), 100 Hz	3.10	3.10	
73°F (23°C), 1 MHz	3.00	3.00	
Dissipation Factor			IEC 60250
73°F (23°C), 100 Hz	2.0E-3	2.0E-3	
73°F (23°C), 1 MHz	8.5E-3	8.5E-3	
Comparative Tracking Index (Solution A)	225 V	225 V	IEC 60112
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.03 in (0.9 mm))	HB	HB	UL 94
Oxygen Index ³	24 %	24 %	ISO 4589-2
Fill Analysis	Typical Value (English)	Typical Value (SI)	Test Method
Melt Viscosity ⁴ (500°F (260°C))	250 Pa·s	250 Pa·s	ISO 11443-A

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature - Dry Air Dryer	203 to 230 °F	95 to 110 °C
Drying Time - Dry Air Dryer	4.0 hr	4.0 hr
Suggested Max Moisture	< 0.020 %	< 0.020 %
Suggested Shot Size	30 to 70 %	30 to 70 %
Rear Temperature	446 to 464 °F	230 to 240 °C

Copyright ©, 2025, Formerra, LLC. All the information in this literature is for general information purpose only. Formerra makes no representations, guarantees, or warranties of any kind with respect to the information contained in this literature, including its accuracy, completeness, reliability, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for pricing, property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Formerra makes no warranties or guarantees respecting suitability of either Formerra's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. FORMERRA MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature or any other provided literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner. Any action you take upon the information you find in this literature is strictly at your own risk. Formerra will not be liable for any losses and/or damages in connection with the use of this literature. By using this literature, you hereby consent to this disclaimer and agree to its terms.

Bayblend® T85 XF

Covestro - Polycarbonates - Polycarbonate + ABS

Injection	Typical Value (English)	Typical Value (SI)
Middle Temperature	455 to 473 °F	235 to 245 °C
Front Temperature	464 to 518 °F	240 to 270 °C
Nozzle Temperature	509 to 527 °F	265 to 275 °C
Processing (Melt) Temp	500 to 536 °F	260 to 280 °C
Mold Temperature	158 to 194 °F	70 to 90 °C
Back Pressure	725 to 2180 psi	5.00 to 15.0 MPa
Vent Depth	9.8E-4 to 3.0E-3 in	0.025 to 0.075 mm

Injection Notes

Peripheral Screw Speed: 0.05 - 0.2 m/s
Hold Pressure (% of Injection Pressure): 50 - 75%
Standard Melt Temperature: 270°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 150x105x3mm,, MT 80°C

³ Procedure A

⁴ 1000s-1

Copyright ©, 2025 , Formerra, LLC. All the information in this literature is for general information purpose only. Formerra makes no representations, guarantees, or warranties of any kind with respect to the information contained in this literature, including its accuracy, completeness, reliability, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for pricing, property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Formerra makes no warranties or guarantees respecting suitability of either Formerra's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. FORMERRA MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature or any other provided literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner. Any action you take upon the information you find in this literature is strictly at your own risk. Formerra will not be liable for any losses and/or damages in connection with the use of this literature. By using this literature, you hereby consent to this disclaimer and agree to its terms.