

Multilon® T-2850R

PC/ABS

Suitable for Automotive applications

Property	Unit	Test Method	Measurement Condition	T-2850R
Melt Volume Flow Rate	cm ³ /10min	ISO 1133	260°C/5kg	29
Density	kg/m ³	ISO 1183	-	1110
Water Absorption Rate	%	ISO 62	In water 23°C 24h	0.2
Tensile Modulus	MPa	ISO 527-1 ISO 527-2	1mm/min	2100
Tensile Stress at Yield			50 mm/min	48
Tensile Stress at Break				50
Tensile Strain at Yield				3
Tensile Strain at Break			%	120
Flexural Modulus	MPa	ISO 178	2 mm/min	2000
Flexural Strength			75	
Charpy Impact Strength	kJ/m ²	ISO 179	Unnotched (23°C)	NB
			Notched (23°C)	65
			Notched (-30°C)	40
Load-Deflection Temperature	°C	ISO 75-1	1.8 MPa	95
		ISO 75-2	0.45 MPa	120
Vicat Softening Temperature	°C	ISO 306	50°C/h 50N	111
Molding Shrinkage	%	In-house Method	Parallel (4mmt)	0.5 - 0.7
			Vertical (4mmt)	0.5 - 0.7
Coefficient of Linear Expansion	x 10 ⁻⁵ /°C	ISO 11359-2	Parallel	8
			Vertical	8
Volume Resistivity	Ω·m	IEC 60093	-	> 1x10 ¹³
Surface Resistivity	Ω	IEC 60093	-	> 1x10 ¹⁵
Flammability	-	UL 94	-	-

* The values listed are specification values, not certified values.

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Recommended Predrying Conditions	
Type of Drying Machine	Hopper Dryer
Drying Temperature	110°C
Drying Duration	5 - 8 hours
Residual Moisture	≤ 0,02%
Remarks	For continuous molding, use a machine with a continuous molding capacity of 5 hours or more. If a dehumidifying type machine is used, more efficient drying will be performed.

Standard Injection Conditions*	
Shot Capacity	1.5 - 3 times that of the weight of molded product
Molding Temperature	230 - 270°C
Mold Temperature	50 - 80°C
Cylinder Temperature	250 - 280°C
Hot Runner Temperature	250 - 280°C
Peripheral Speed Screw	≤ 250mm/s
Injection Pressure	59 - 147MPa

*Please note that actual molding conditions may vary from above recommended conditions.

Disclaimer:

The above information is provided by Teijin Kasei Europe B.V. (TKE) in good faith.

TKE does not guarantee or warranty the results obtained based on the above information.

TKE does not bear responsibility when additives of any kind (e.g. anti-bacterial agent, coloring additives, stabilizers, flame retardants etc.) are added to this material during molding.

This material cannot be used for food containers or any food packaging applications.