

Multilon® T-2763B

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

PC/ABS polymer alloy, Automotive series

General

Properties	• Ultra Low Gloss		
Uses	• Automotive Exterior Parts	• Automotive Instrument Panel	• Automotive Interior Parts
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	6.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.50 to 0.70	%	
Flow : 4.00 mm	0.50 to 0.70	%	
Water Absorption (24 hr, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	48.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	80	%	ISO 527-2/50
Flexural Modulus ² (23°C)	2500	MPa	ISO 178
Flexural Stress ² (23°C)	73.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	15	kJ/m ²	
23°C	50	kJ/m ²	
Hardness	Nominal Value	Unit	Test Method
Pencil Hardness	2B to B		JIS K5600
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed	125	°C	
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	102	°C	
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	8.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	110	°C

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Injection	Nominal Value	Unit
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	240 to 270	°C
Mold Temperature	50 to 70	°C

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² 2.0 mm/min