

Multilon® T-2810R

TEIJIN LIMITED - Polycarbonate + ABS

General Information			
Product Description			
PC/ABS polymer alloy			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• High Flow	• High Heat Resistance	• Low Temperature Impact Resistance
Uses	• Automotive Instrument Panel		
Automotive Specifications	• DAIMLER DBL 5404.30	• FIAT 55231/01 105.450	• VOLKSWAGEN TL 522 31-B
Forms	• Pellets		
Processing Method	• Injection Molding		
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm³	ISO 1183
Melt Volume-Flow Rate (MVR)			ISO 1133
250°C/5.0 kg	17	cm³/10min	
260°C/5.0 kg	27	cm³/10min	
Molding Shrinkage ²			Internal Method
Across Flow : 4.00 mm	0.50 to 0.70	%	
Flow : 4.00 mm	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	55.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	3.0	%	ISO 527-2/50
Tensile Strain (Break, 23°C)	120	%	ISO 527-2/50
Flexural Modulus ³ (23°C)	2200	MPa	ISO 178
Flexural Stress ³ (23°C)	85.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	35	kJ/m²	
23°C	50	kJ/m²	
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	130	°C	ISO 75-2/B
Heat Deflection Temperature (1.8 MPa, Unannealed)	110	°C	ISO 75-2/A
Vicat Softening Temperature	128	°C	ISO 306/B50
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	8.0E-5	cm/cm/°C	ISO 11359-2

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Processing Information		
Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	4.0 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 Mold shrinkage of Multilon will vary depending on its application thickness.
- ³ 2.0 mm/min