

Multilon® T-2854

PC/ABS

Suitable for metal plating applications

Property	Unit	Test Method	Measurement Condition	T-2854
Melt Volume Flow rate	cm ³ /10min	ISO 1133	250°C/5kg	12
Density	kg/m ³	ISO 1183	-	1110
Tensile Modulus	MPa	ISO 527-1 ISO 527-2	1mm/min	-
Tensile Stress at Yield			50 mm/min	51
Tensile Stress at Break				52
Tensile Strain at Yield				-
Tensile Strain at Break			%	110
Flexural Modulus	MPa	ISO 178	2 mm/min	2150
Flexural Strength				77
Charpy Impact Strength	kJ/m ²	ISO 179	Unnotched (23°C)	NB
			Notched (23°C)	118
			Notched (-30°C)	61
Load-Deflection Temperature	°C	ISO 75-1 ISO 75-2	1.8 MPa	97
			0.45 MPa	121
Vicat Softening Temperature	°C	ISO 306	50°C/h 50N	-
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
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.