

Multilon® DE-1530D

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

PC/ABS polymer alloy, Mineral filler reinforced

General

Filler / Reinforcement	• Mineral	
Properties	• High Rigidity	• Wear Resistant
Uses	• Business Equipment	• Industrial Applications
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.20 to 0.40	%	
Flow : 4.00 mm	0.10 to 0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break, 23°C)	60.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Flexural Modulus ² (23°C)	7500	MPa	ISO 178
Flexural Stress ² (23°C)	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	105	°C	
CLTE - Flow	4.5E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	7.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (1.5 mm)	50.0	°C	UL 746B
RTI Imp (1.5 mm)	50.0	°C	UL 746B
RTI Str (1.5 mm)	50.0	°C	UL 746B
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm	V-1		
3.0 mm	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	240 to 280	°C
Mold Temperature	50 to 80	°C

Notes

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

² 2.0 mm/min