

Multilon® DN-3720F

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

PC/ABS polymer alloy, Non-halogen type flame resistant series, Mineral filler reinforced

General

Filler / Reinforcement	• Mineral	
Properties	• Flame Retardant • Good Surface Finish	• Halogen Free • High Rigidity
Uses	• Business Equipment	• Industrial Applications
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.30 to 0.50	%	
Flow : 4.00 mm	0.20 to 0.40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6100	MPa	ISO 527-1/1
Tensile Stress (Break, 23°C)	60.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	5.0	%	ISO 527-2/5
Flexural Modulus ² (23°C)	5400	MPa	ISO 178
Flexural Stress ² (23°C)	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	60	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed	95.0	°C	
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	83.0	°C	
Vicat Softening Temperature	98.0	°C	ISO 306/B50
CLTE - Flow	3.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	7.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (1.0 mm)	60.0	°C	UL 746B
RTI Imp (1.0 mm)	60.0	°C	UL 746B
RTI Str (1.0 mm)	60.0	°C	UL 746B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.0 mm		V-1	
1.3 mm		V-0	
1.8 mm		5VB	

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	5.0 to 8.0	hr	
Processing (Melt) Temp	230 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