

Multilon® DN-7720D

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	• 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	1.35	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)	6500	MPa	ISO 527-1/1
Tensile Stress (Yield, 23°C)	74.0	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	70.0	MPa	ISO 527-2/5
Tensile Strain (Yield, 23°C)	2.0	%	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.0	%	ISO 527-2/5
Flexural Modulus ² (23°C)	6200	MPa	ISO 178
Flexural Stress ² (23°C)	115	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)	40	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed	122	°C	
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	110	°C	
Vicat Softening Temperature	124	°C	ISO 306/B50
CLTE - Flow	4.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	5.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (1.5 mm)	100	°C	UL 746B
RTI Imp (1.5 mm)	100	°C	UL 746B
RTI Str (1.5 mm)	100	°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
1.5 mm, Black		V-1	
2.0 mm, Black		5VB	

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature	110	°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