

# Multilon® DN-7720HX

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 <sup>1</sup>

| Physical                              | Nominal Value | Unit              | Test Method     |
|---------------------------------------|---------------|-------------------|-----------------|
| Density                               | 1.34          | g/cm <sup>3</sup> | 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 Stress (Yield, 23°C)          | 72.0          | MPa               | ISO 527-2/5     |
| Tensile Stress (Break, 23°C)          | 70.0          | MPa               | ISO 527-2/5     |
| Tensile Strain (Break, 23°C)          | 4.0           | %                 | ISO 527-2/5     |
| Flexural Modulus <sup>2</sup> (23°C)  | 6200          | MPa               | ISO 178         |
| Flexural Stress <sup>2</sup> (23°C)   | 115           | MPa               | ISO 178         |
| Impact                                | Nominal Value | Unit              | Test Method     |
| Charpy Notched Impact Strength (23°C) | 4.0           | kJ/m <sup>2</sup> | ISO 179         |
| Thermal                               | Nominal Value | Unit              | Test Method     |
| Deflection Temperature Under Load     |               |                   | ISO 75-2/A      |
| 1.8 MPa, Unannealed                   | 118           | °C                |                 |
| CLTE - Flow                           | 3.8E-5        | cm/cm/°C          | ISO 11359-2     |
| CLTE - Transverse                     | 4.8E-5        | cm/cm/°C          | ISO 11359-2     |
| RTI Elec (0.70 mm)                    | 60.0          | °C                | UL 746B         |
| RTI Imp (0.70 mm)                     | 60.0          | °C                | UL 746B         |
| RTI Str (0.70 mm)                     | 60.0          | °C                | UL 746B         |
| Flammability                          | Nominal Value | Unit              | Test Method     |
| Flame Rating                          |               |                   | UL 94           |
| 0.70 mm, Black                        | V-2           |                   |                 |
| 1.5 mm, Black                         | V-1           |                   |                 |
| 2.0 mm, Black                         | V-0           |                   |                 |
|                                       | 5VB           |                   |                 |

## Processing Information

| Injection          | Nominal Value | Unit |
|--------------------|---------------|------|
| Drying Temperature | 110           | °C   |

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

Notes

- <sup>1</sup> Typical properties: these are not to be construed as specifications.
- <sup>2</sup> 2.0 mm/min