

Multilon® DN-7725D

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	1.38	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 Stress (Break, 23°C)	68.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.0	%	ISO 527-2/5
Flexural Modulus ² (23°C)	6800	MPa	ISO 178
Flexural Stress ² (23°C)	118	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	110	°C	
CLTE - Flow	3.8E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	4.5E-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
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