

Multilon® T-3615Q

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

PC/ABS polymer alloy

General

Properties	• Permanent Antistatic
Uses	• Electrical Parts • General Purpose
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.50 to 0.70	%	
Flow : 4.00 mm	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1760	MPa	ISO 527-1/1
Tensile Stress (Yield, 23°C)	45.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	3.0	%	ISO 527-2/50
Tensile Strain (Break, 23°C)	120	%	ISO 527-2/50
Flexural Modulus ² (23°C)	1800	MPa	ISO 178
Flexural Stress ² (23°C)	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	80	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed	107	°C	
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	93.0	°C	
Vicat Softening Temperature	109	°C	ISO 306/B50
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	8.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (1.5 mm)	60.0	°C	UL 746B
RTI Imp (1.5 mm)	60.0	°C	UL 746B
RTI Str (1.5 mm)	60.0	°C	UL 746B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+10 to 1.0E+11	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	HB		UL 94

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	230 to 260	°C
Mold Temperature	50 to 70	°C

Notes

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

² 2.0 mm/min