

Multilon® TE-3033F

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

PC/ABS polymer alloy

General

Properties	• Lubricated	
Uses	• Business Equipment	• Electrical/Electronic Applications
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.17	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 Stress (Yield, 23°C)	55.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	45.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	80	%	ISO 527-2/50
Flexural Modulus ² (23°C)	2900	MPa	ISO 178
Flexural Stress ² (23°C)	82.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	25	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	98.0	°C	
RTI Elec (1.2 mm)	60.0	°C	UL 746B
RTI Imp (1.2 mm)	60.0	°C	UL 746B
RTI Str (1.2 mm)	60.0	°C	UL 746B
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.2 mm, Black)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	50 to 80	°C

Notes

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

² 2.0 mm/min