

Multilon® TN-3725BA

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

PC/ABS polymer alloy, Mineral filler reinforced, Non-halogen type flame resistant series

General

Filler / Reinforcement	• Mineral		
Properties	• Flame Retardant	• Halogen Free	• High Rigidity
Uses	• Business Equipment	• Office Automation Equipment	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.35 to 0.55	%	
Flow : 4.00 mm	0.35 to 0.55	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	65.0	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	40.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	10	%	ISO 527-2/5
Flexural Modulus ² (23°C)	4700	MPa	ISO 178
Flexural Stress ² (23°C)	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	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/A
1.8 MPa, Unannealed	91.0	°C	
CLTE - Flow	5.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	5.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (1.0 mm)	100	°C	UL 746B
RTI Imp (1.0 mm)	100	°C	UL 746B
RTI Str (1.0 mm)	100	°C	UL 746B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.8 mm	V-1		
1.0 mm	V-0		
1.5 mm	5VB		

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Processing Information		
Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	50 to 70	°C

Notes

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