



Multilon® TN-7280

TEIJIN LIMITED - Polycarbonate + ABS

General Information			
Product Description			
PC/ABS polymer alloy, Non-halogen type flame resistant series			
General			
Properties	• Flame Retardant	• Halogen Free	
Uses	• Business Equipment	• Office Automation Equipment	
Forms	• Pellets		
Processing Method	• Injection Molding		
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.18	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)	60.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	52.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	130	%	ISO 527-2/50
Flexural Modulus ² (23°C)	2640	MPa	ISO 178
Flexural Stress ² (23°C)	92.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	22	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	80.0	°C	
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	8.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (0.8 mm)	60.0	°C	UL 746B
RTI Imp (0.8 mm)	60.0	°C	UL 746B
RTI Str (0.8 mm)	60.0	°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-2	
1.0 mm		V-1	
1.5 mm	•	V-0	
	•	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