

Multilon® TN-7400B

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 Flow • 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	1.21	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.40 to 0.60	%	
Flow : 4.00 mm	0.40 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	63.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	30	%	ISO 527-2/50
Flexural Modulus ² (23°C)	3200	MPa	ISO 178
Flexural Stress ² (23°C)	96.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	78.0	°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 (1.5 mm)	85.0	°C	UL 746B
RTI Imp (1.5 mm)	85.0	°C	UL 746B
RTI Str (1.5 mm)	85.0	°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
0.70 mm		V-2	
1.0 mm		V-1	
1.2 mm		V-0	
		5VB	

Multilon® TN-7400B
TEIJIN LIMITED - Polycarbonate + ABS

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 60	°C

Notes

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