

Multilon® TN-7504

TEIJIN LIMITED - Polycarbonate + ABS

General Information

Product Description

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

General

Properties	• Flame Retardant	• Halogen Free	• Thermally Insulating
Uses	• Business Equipment	• Electrical Housing	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.22	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	%	
Water Absorption (24 hr, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2900	MPa	ISO 527-1/1
Tensile Stress (Yield, 23°C)	62.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	42.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	3.0	%	ISO 527-2/50
Tensile Strain (Break, 23°C)	50	%	ISO 527-2/50
Flexural Modulus ² (23°C)	2900	MPa	ISO 178
Flexural Stress ² (23°C)	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	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	91.0	°C	
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	80.0	°C	
Vicat Softening Temperature	94.0	°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+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm		V-0	
2.0 mm		5VB	

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	40 to 60	°C	

Notes

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