

Multilon® T-3615Q

TEIJIN LIMITED - Polycarbonate + ABS

Monday, January 18, 2021

General Information

Product Description

PC/ABS polymer alloy

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Permanent Antistatic		
Uses	• Electrical Parts	• General Purpose	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13	g/cm ³	JIS K7112
Density	1.13	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Molding Shrinkage - Across Flow	0.50 to 0.70	%	ASTM D955
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 Modulus	1760	MPa	ISO 527-2/1
Tensile Strength (Yield)	49.0	MPa	ASTM D638
Tensile Stress (Yield)	45.0	MPa	ISO 527-2/50
Tensile Strength (Break)	50.0	MPa	ASTM D638
Tensile Stress (Break)	50.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	3.0	%	ISO 527-2/50
Tensile Elongation (Break)	130	%	ASTM D638
Tensile Strain (Break)	120	%	ISO 527-2/50
Flexural Modulus	1960	MPa	ASTM D790
Flexural Modulus ²	1800	MPa	ISO 178
Flexural Strength	71.0	MPa	ASTM D790
Flexural Stress ²	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	80	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	No Break		ISO 179
Notched Izod Impact			ASTM D256
3.20 mm	830	J/m	
6.40 mm	640	J/m	

Disclaimer:

- The numerical values described in the data sheet are typical numerical values produced with a standard test method, and they do not guarantee the product's performance in a particular application.
- The flammability as described in the data sheet is an evaluation that resulted from a small-scale test, and it cannot be applied as it is to evaluate the actual risk of fire.
- Please contact us if you wish to use the product in medical equipment, food containers and packaging, and toys.
- If you wish to use various additives (antibacterial agents, stabilizers and flame retardants) or coloring agents with this resin, please consult with Teijin Ltd. beforehand. However, please note that Teijin Ltd. does not offer any kind of guarantee or bear any responsibility with regards to using this resin in any of these applications.
- The contents of the data sheet may change without notice.
- For other details, please see the Material Safety Data Sheet (MSDS) before use.
- Please contact the Resin & Plastic Processing Business Unit of Teijin Ltd. for detailed data.
- The raw materials used in our products may be subject to regulations depending on the type of system that exists to manage chemical substances in places to which our products are delivered. In addition, a separate application may need to be filed depending on the brand. There are also cases where imports of our products are not approved. If you are an importer or exporter and intend to import or export our products to new destinations, please make sure you contact us for details of regulatory compliance in those destinations.

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Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	107	°C	ISO 75-2/B
Deflection Temperature Under Load 1.8 MPa, Unannealed	103	°C	JIS K7207
Heat Deflection Temperature (1.8 MPa, Unannealed)	93.0	°C	ISO 75-2/A
Vicat Softening Temperature	109	°C	ISO 306/B50
CLTE - Flow	8.0E-5	cm/cm/°C	ASTM D696
CLTE - Flow	8.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	8.0E-5	cm/cm/°C	ASTM D696
CLTE - Transverse	8.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+10 to 1.0E+11	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	4.0 to 8.0	hr
Processing (Melt) Temp	230 to 260	°C
Mold Temperature	50 to 70	°C

Notes

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

² 2.0 mm/min

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