

Panlite® MN-3709

TEIJIN LIMITED - Polycarbonate Alloy

General Information

Product Description

PC alloy grade, Non-halogen type flame resistant series

General

Properties	• Bromine Free	• Flame Retardant	• High Flow
Uses	• Battery Cases	• Electrical Parts	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	6.5	cm ³ /10min	ISO 1133
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)	0.22	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	66.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	64.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	90	%	ISO 527-2/50
Flexural Modulus ² (23°C)	2420	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)	57	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	96.0	°C	
CLTE - Flow	7.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	7.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (0.35 mm)	80.0	°C	UL 746B
RTI Imp (0.35 mm)	80.0	°C	UL 746B
RTI Str (0.35 mm)	80.0	°C	UL 746B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.35 mm	V-2		
0.70 mm	V-0		

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	100	°C
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	260 to 320	°C
Mold Temperature	60 to 80	°C

Notes

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

² 2.0 mm/min