

# DESOX™ DSC411GM4

Polybutylene Terephthalate

DESCO Co., Ltd.

## Message:

Descriptions: DESOX™ DSC411GM4 is one of the brands which made by PBT(Poly Butylene Terephthalate) Glass Fiber & Mineral Filler 20% reinforced goods. It provides good electric property and good mechanical strength.

Applications: DESOX™ DSC411GM4 is one of the most-used resin requested for electric property and good mechanical property.

General Information			
Filler / Reinforcement	Glass \Mineral		
Features	Good electrical performance		
	Good strength		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.47	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.50 - 1.1	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	123		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	98.1	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	6370	MPa	ASTM D790
Flexural Strength	157	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	220	°C	ASTM D648
1.8 MPa, not annealed	210	°C	ASTM D648
Melting Temperature	222	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	23	kV/mm	ASTM D149
Arc Resistance	75.0	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 140	°C	
Drying Time	2.0 - 5.0	hr	
Suggested Max Moisture	< 0.20	%	
Rear Temperature	230 - 245	°C	

Middle Temperature	240 - 250	°C
Front Temperature	240 - 260	°C
Nozzle Temperature	240 - 260	°C
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	50.0 - 100	°C

#### Injection instructions

Speed: 40 to 70%Pressure 1st: 30 to 60%Pressure 2nd: 30 to 60Holding Pressure: 10 to 20%

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#### Recommended distributors for this material

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