

DESOX™ DSC410I

Polybutylene Terephthalate

DESCO Co., Ltd.

Message:

Descriptions: DESOX™ DSC410I is one of the brands which made by PBT(Poly Butylene Terephthalate) unfilled resin. It provides good electric property and good mechanical strength.

Applications: DESOX™ DSC410I is one of the most-used resin requested for electric property and mechanical property such as automotive bezel etc.

General Information			
Features	Good electrical performance		
	Good strength		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.5 - 2.1	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	58.8	MPa	ASTM D638
Tensile Elongation (Break)	80	%	ASTM D638
Flexural Modulus	2750	MPa	ASTM D790
Flexural Strength	93.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	160	°C	ASTM D648
1.8 MPa, not annealed	65.0	°C	ASTM D648
Melting Temperature	222	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	15	kV/mm	ASTM D149
Arc Resistance	120	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 - 240	°C	

Middle Temperature	235 - 245	°C
Front Temperature	240 - 260	°C
Nozzle Temperature	240 - 260	°C
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	40.0 - 80.0	°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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