

# DESOX™ DSC640M5

Polybutylene Terephthalate + PET

DESCO Co., Ltd.

## Message:

Descriptions: DESOX™ DSC640M5 is one PBT(Poly Butylene Terephthalate) and PET(Poly Etylene Terephthalate) alloy with Mineral Filler 25% reinforced goods. It provides good electric property and mechanical strength.

Applications: DESOX™ DSC640M5 is one of the most-used resin which request good electric property and mechanical property.

General Information			
Filler / Reinforcement	Mineral filler, 25% filler by weight		
Features	Good electrical performance		
	Good strength		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.53	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.50 - 1.2	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	53.9	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	5100	MPa	ASTM D790
Flexural Strength	93.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	200	°C	ASTM D648
1.8 MPa, not annealed	105	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	24	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	100 - 120	°C	
Drying Time	2.0 - 5.0	hr	
Suggested Max Moisture	< 0.20	%	
Rear Temperature	240 - 250	°C	
Middle Temperature	250 - 260	°C	

Front Temperature	260 - 270	°C
Nozzle Temperature	260 - 270	°C
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	60.0 - 90.0	°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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