



Melinex[®]

polyester film

Melinex[®] ST506[™]

Product Description

Melinex[®] ST506[™] film is an optically clear, heat stabilised film, pre-treated on both surfaces to give enhanced adhesion to inks and lacquers, making it particularly suitable for graphics and circuitry layers of membrane touch switches. Melinex[®] ST506[™] film is a knurled film which is available in thicknesses of 125, 175 and 250 microns.

Our process of continual improvement in quality and specification now enable us to provide the following properties and benefits:

- * Heat stabilised to give excellent dimensional stability at temperatures up to 150°C.
- * Excellent adhesion to a wide range of solvent based inks, graphics inks and varnishes, silver conductive inks and dielectrics.
- * Excellent durability and toughness giving long lasting switches, particularly when compared with polycarbonate.
- * Greatly superior solvent resistance to that of polycarbonate, making Melinex[®] ST506[™] film particularly suitable for use in many industrial applications.

Food Contact Advice

Melinex[®] ST506[™] has not been assessed against Food Contact Legislation.

Disposal

Disposal of Mylar[®]/Melinex[®] does not present special disposal problems. Where waste occurs in a clean, uncontaminated form it can be recycled. In most circumstances, once Mylar[®]/Melinex[®] has been laminated, coated, printed or metallised, incineration with Energy Recovery is the most environmentally efficient recovery route. Mylar[®]/Melinex[®] can also be burned in an incinerator with normal refuse or can be buried as a relatively inert material in a landfill. The disposal method should comply with appropriate local and country regulations.

TYPICAL VALUES OF PROPERTIES

Property	Test Method	Unit	Value		
Thermal			All Thicknesses (µm)		
Melting point	BS2782	°C	255		
Coefficient of thermal expansion (between 20 and 50°C)		cm/cm deg C	19 x 10 ⁻⁶ (MD)		
Residual Shrinkage (after 30mins at 150°C)		%	MD* 0.10 TD** 0.03		
Optical			125µm	175µm	250µm
Haze	ASTM D 1003-78 (measured on Gardner Hazemeter)	%	1.0	1.5	1.7
Total Light Transmission	ASTM D1003	%	89	89	89
Gloss 60°	ASTM D523		150	150	150
Electrical			125µm	175µm	250µm
Dielectric strength	ASTM D149	Kv/mm	125		105
Dielectric Constant 50c/sec	ASTM D150		2.9		
Surface Resistivity	ASTM D257-83	ohm/□	10 ¹⁵		
Volume resistivity	ASTM D257	ohm m	10 ¹⁵		
General & Mechanical			125µm	175µm	250µm
Area yield		m ² /kg	5.7	4.0	2.9
Relative Density (at 23°C)	ASTM D 1505-79 (modified to Melinex test method)	kgf/mm ²	1.39		
Tensile strength at break	ASTM D 882	per 1% RH	>17.7	>14.1	
Flexural strength (MIT fold)	ASTM D2176	Cycles	125µm <20,000	175µm >15,000	250µm >10,000
Coefficient of friction (static)	ASTM D1894	--	<0.7		
Water vapour permeability 38°C/90% rh			4.0	2.9	0.86
Coefficient of hygroscopic expansion			8x10 ⁻⁶		
Elongation at break	ASTM D 882-83	%	MD 96	107	
F5 (force to elongate 5% of gauge length)	ASTM D 882 (50% strain rate)	kgf/mm ²	TD 126	125	
			10	9.9	
			10.2	10.2	

1 micron = 0.001 mm approx. 4 gauge, *MD = Machine Direction, **TD = Transverse Direction

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DuPont Teijin Films Contacts	
Continental Europe DuPont Teijin Films (Luxembourg) SA BP-1681 L-1016 Luxembourg Telephone +352 2616 4004 Fax +352 2616 5000	United Kingdom DuPont Teijin Films (UK) Ltd PO Box 2002 Middlesbrough England TS90 8JF Telephone +44 (0) 1642 572000 Fax +44 (0) 1642 572075
http://www.dupontteijinfilms.com	e-mail: europe.films@gbp.dupont.com e-mail: packaging.films@gbp.dupont.com

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'Caution: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Teijin Films Medical Caution Statement", H-50102-3-DTF and H-50103-3-DTF.

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