



# Melinex®

polyester film

MXTD205 Issue 4  
**Melinex® 506**

Melinex® 506 is a sparkling optically clear knurled film with an adhesion promoting pretreatment on both surfaces. It is normally used in the graphics industry where its excellent clarity and printing/coating adhesion are utilised. Melinex® 506 is available in thicknesses of 75, 100, 125, 175 and 250 micron.

### TYPICAL VALUES OF PROPERTIES

Property	Test Method	Unit	Value
<b>General</b>			<b>125µm 175µm 250µm</b>
Area Yield	--	m <sup>2</sup> /kg	5.7 4.0 2.9
Relative Density (at 23°C)	ASTM D 1505-79 (modified to Melinex test method)	--	1.4
<b>Mechanical</b>			MD* TD**
Tensile strength at break	ASTM D 882-83 (23°C at 50% RH Strain Rate 50% min)	kgf/mm <sup>2</sup>	17.5 17.5
F5 (force to elongate 5% of gauge length)	ASTM D 882	kgf/mm <sup>2</sup>	10 10
<b>Optical</b>			<b>125µm 175µm</b>
Haze	ASTM D1003-77 (Measured on Gardner Hazemeter)		0.5 0.5
<b>Thermal</b>			255 - 260
Upper Melt temperature	ASTM E794-85	°C	19 x 10 <sup>-6</sup> (MD)
Coefficient of thermal expansion (between 20 and 50°C)		(cm/cm deg C)	19 x 10 <sup>-6</sup> (TD)
Shrinkage (after 5mins at 190°C)		%	MD TD 1 0.3

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

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This information corresponds to our current knowledge on the subject. It is offered solely to provide possible suggestions for your own experimentations. It is not intended, however, to substitute for any testing you may need to conduct to determine for yourself the suitability of our products for your particular purposes. This information may be subject to revision as new knowledge and experience becomes available. Since we cannot anticipate all variations in actual end-use conditions, DuPont Teijin Films makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent right.



**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-DTF.

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