



Melinex®

polyester film

Melinex® D406 - Provisional Data

Melinex® D406 is a clear film, two side pretreated film to promote adhesions to inks and lacquers. The film is suitable for applications where high transparency is important. Melinex® D406 is supplied as unknurled reels and is currently available in 36 and 50 microns. D406 is currently a development grade and actual properties are subject to change

TYPICAL VALUES OF PROPERTIES

Property	Test Method	Unit	Value
General Area Yield		m ² /kg	Thickness μm 36 50 19.8 14.3
Relative Density	ASTM D 1505-79 (modified to Melinex test method)		1.4
Mechanical Tensile strength at break	ASTM D 882-83 (23°C at 50% rh strain rate 50%/min)	kgf/mm ²	MD* TD** 19 28
Elongation at break	As above	%	155 85
Slip (coefficient of static friction)	ASTM D 1894-78 (modified to Melinex test method)		<1.0
F5		kgf/mm ²	11 11
Optical Haze	ASTM D 1003-78 (measured on Gardner Hazemeter)		Thickness μm 36 50 1.4% 1.6%
Thermal Upper melt temperature	ASTM E794-85	°C	255 - 260
Coefficient of thermal expansion (between 20 and 50°C)		1/K (cm/cm deg C)	19 x 10 ⁻⁶ (MD) 19 x 10 ⁻⁶ (TD)
Shrinkage (at 150°C)		%	1.0(MD) 0.7(TD)
Electrical Dielectric strength	IEC 243 (0.25 inch electrodes in dry air at 25°C)	Kv/mm	160
Surface resistivity	IEC 93 (500V dc at 20°C an 54% rh)	ohm/	>10 ¹³
Volume resistivity	IEC 93	ohm m	10 ¹⁵

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

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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-DTF.

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