

Keyflex® BT 1030D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

General Purpose, Low Modulus

Application

Automotive Interior, Soft Touch Grips

General Information			
Features	General Purpose		
Uses	Automotive Interior Parts		
	Flexible Grips		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm, Injection Molded)	0.40 to 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.80	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 23°C, Injection Molded	80		
Shore D, 23°C, Injection Molded	28		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 23°C, 2.00 mm, Injection Molded)	21.6	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	850	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm, Injection Molded	No Break		
23°C, 6.40 mm, Injection Molded	No Break		
Thermal	Nominal Value	Unit	Test Method
Peak Melting Temperature	165	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method

Flame Rating (3.20 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80.0 to 90.0	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	< 0.010	%
Rear Temperature	175 to 195	°C
Middle Temperature	185 to 205	°C
Front Temperature	195 to 215	°C
Nozzle Temperature	195 to 215	°C
Processing (Melt) Temp	170 to 210	°C
Mold Temperature	10.0 to 35.0	°C
Extrusion	Nominal Value	Unit
Drying Temperature	80.0 to 90.0	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	< 0.010	%
Cylinder Zone 1 Temp.	165 to 185	°C
Cylinder Zone 2 Temp.	175 to 195	°C
Cylinder Zone 3 Temp.	185 to 205	°C
Cylinder Zone 4 Temp.	185 to 205	°C
Adapter Temperature	185 to 205	°C
Melt Temperature	170 to 210	°C
Die Temperature	175 to 215	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	

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