

Keyflex® BT 1163D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

General Purpose, Medium Modulus

Application

Cable & Wire Jackets, Hose & Tubing

General Information			
Features	General Purpose		
Uses	Cable Jacketing		
	Hose		
	Tubing		
	Wire & Cable Applications		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm, Injection Molded)	1.1 to 1.5	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 23°C, Injection Molded)	57		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield, 23°C, 2.00 mm, Injection Molded	16.7	MPa	
Break, 23°C, 2.00 mm, Injection Molded	37.3	MPa	
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	700	%	ASTM D638
Flexural Modulus ³ (23°C, 6.40 mm, Injection Molded)	216	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ⁴ (23°C)	160	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm, Injection Molded	98	J/m	
23°C, 6.40 mm, Injection Molded	No Break		

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm, Injection Molded)	110	°C	ASTM D648
Peak Melting Temperature	208	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	> 1.0E+13	ohms·cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	26	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	600	V	IEC 60112
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	210 to 230	°C	
Middle Temperature	220 to 240	°C	
Front Temperature	225 to 245	°C	
Nozzle Temperature	225 to 245	°C	
Processing (Melt) Temp	210 to 240	°C	
Mold Temperature	20.0 to 40.0	°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.	210 to 230	°C	
Cylinder Zone 2 Temp.	215 to 235	°C	
Cylinder Zone 3 Temp.	225 to 245	°C	
Cylinder Zone 4 Temp.	225 to 245	°C	
Adapter Temperature	225 to 245	°C	
Melt Temperature	210 to 240	°C	
Die Temperature	215 to 255	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	50 mm/min		

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