

Keyflex® BT 1068D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

General Purpose, High Modulus

Application

Injection Parts for Lesuire & Sports

General Information			
Features	General Purpose		
Uses	Sporting Goods		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	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)	1.4 to 1.8	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 23°C, Injection Molded)	64		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield, 23°C, 2.00 mm, Injection Molded	22.6	MPa	
Break, 23°C, 2.00 mm, Injection Molded	49.0	MPa	
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	600	%	ASTM D638
Flexural Modulus ³ (23°C, 6.40 mm, Injection Molded)	422	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ⁴ (23°C)	165	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm, Injection Molded	49	J/m	
23°C, 6.40 mm, Injection Molded	200	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm, Injection Molded)	120	°C	ASTM D648

Peak Melting Temperature	215	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	> 1.0E+12	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
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	215 to 235	°C	
Middle Temperature	225 to 245	°C	
Front Temperature	230 to 250	°C	
Nozzle Temperature	230 to 250	°C	
Processing (Melt) Temp	215 to 240	°C	
Mold Temperature	40.0 to 60.0	°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.	215 to 235	°C	
Cylinder Zone 2 Temp.	220 to 240	°C	
Cylinder Zone 3 Temp.	225 to 245	°C	
Cylinder Zone 4 Temp.	230 to 250	°C	
Adapter Temperature	230 to 250	°C	
Melt Temperature	215 to 240	°C	
Die Temperature	220 to 250	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	50 mm/min		

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