

Keyflex® BT 1245D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description
Medium Modulus, Black color
Application
Automotive Body Plug, Fastener

General Information			
Uses	Automotive Applications		
	Fasteners		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	17	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)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 23°C, Injection Molded)	40		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 23°C, 2.00 mm, Injection Molded)	24.5	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	1000	%	ASTM D638
Flexural Modulus ³ (23°C, 6.40 mm, Injection Molded)	98.1	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	5.88	MPa	ASTM D790
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
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm, Injection Molded)	80.0	°C	ASTM D648
Peak Melting Temperature	205	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
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	205 to 225	°C
Middle Temperature	210 to 230	°C
Front Temperature	215 to 235	°C
Nozzle Temperature	215 to 235	°C
Processing (Melt) Temp	205 to 235	°C
Mold Temperature	10.0 to 35.0	°C

NOTE

- | | |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 15 mm/min |
| 4. | 15 mm/min |

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