

Keyflex® BT 1035D

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	1.11	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)	0.40 to 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	88		
Shore D	33		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 2.00 mm)	19.6	MPa	ASTM D638
Tensile Elongation ² (Break, 2.00 mm)	750	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm	No Break		
23°C, 6.40 mm	No Break		
Thermal	Nominal Value	Unit	Test Method
Peak Melting Temperature	165	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI) ³	600	V	UL 746
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	170 to 190	°C
Middle Temperature	180 to 200	°C
Front Temperature	190 to 210	°C
Nozzle Temperature	190 to 210	°C
Processing (Melt) Temp	165 to 205	°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.	170 to 190	°C
Cylinder Zone 2 Temp.	180 to 200	°C
Cylinder Zone 3 Temp.	180 to 200	°C
Cylinder Zone 4 Temp.	180 to 200	°C
Adapter Temperature	180 to 200	°C
Melt Temperature	165 to 205	°C
Die Temperature	180 to 200	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	Solution A	

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