

Keyflex® BT 1045D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

General Purpose, Medium Modulus

Application

Antenna Cover, 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	1.14	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)	0.60 to 1.0	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 23°C, Injection Molded	95		
Shore D, 23°C, Injection Molded	42		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 2.00 mm)	29.4	MPa	ASTM D638
Tensile Elongation ² (Break, 2.00 mm)	800	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	78.5	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ⁴ (23°C)	104	kN/m	ASTM D624
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
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm, Injection Molded)	65.0	°C	ASTM D648
Peak Melting Temperature	180	°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	180 to 200	°C	
Middle Temperature	190 to 210	°C	
Front Temperature	200 to 220	°C	
Nozzle Temperature	200 to 220	°C	
Processing (Melt) Temp	180 to 220	°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.	180 to 200	°C	
Cylinder Zone 2 Temp.	190 to 210	°C	
Cylinder Zone 3 Temp.	200 to 220	°C	
Cylinder Zone 4 Temp.	200 to 220	°C	
Adapter Temperature	200 to 220	°C	
Melt Temperature	180 to 220	°C	
Die Temperature	190 to 230	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	50 mm/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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