

Keyflex® BT 3055D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

Fast Molding, Medium Modulus

Application

Injection Parts for Lesuire & Sports

General Information			
Features	Fast Molding Cycle		
Uses	Sporting Goods		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 23°C, Injection Molded)	54		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 23°C, 2.00 mm, Injection Molded)	29.4	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	500	%	ASTM D638
Flexural Modulus ³ (23°C, 6.40 mm, Injection Molded)	265	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm, Injection Molded	88	J/m	
23°C, 6.40 mm, Injection Molded	No Break		
Thermal	Nominal Value	Unit	Test Method
Peak Melting Temperature	220	°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	220 to 240	°C	
Middle Temperature	225 to 245	°C	

Front Temperature	230 to 250	°C
Nozzle Temperature	230 to 250	°C
Processing (Melt) Temp	220 to 250	°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.	220 to 240	°C
Cylinder Zone 2 Temp.	230 to 250	°C
Cylinder Zone 3 Temp.	230 to 250	°C
Cylinder Zone 4 Temp.	230 to 250	°C
Adapter Temperature	230 to 250	°C
Melt Temperature	220 to 250	°C
Die Temperature	220 to 240	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	15 mm/min	

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