

Keyflex® BT 3047D

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	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	23	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	44		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 2.00 mm)	28.4	MPa	ASTM D638
Tensile Elongation ² (Break, 2.00 mm)	600	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	137	MPa	ASTM D790
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	215	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI) ⁴	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	215 to 235	°C	
Middle Temperature	220 to 240	°C	
Front Temperature	225 to 245	°C	

Nozzle Temperature	225 to 245	°C
Processing (Melt) Temp	215 to 245	°C
Mold Temperature	30.0 to 50.0	°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.	225 to 245	°C
Cylinder Zone 3 Temp.	225 to 245	°C
Cylinder Zone 4 Temp.	225 to 245	°C
Adapter Temperature	225 to 245	°C
Melt Temperature	215 to 245	°C
Die Temperature	215 to 235	°C

NOTE

1. 50 mm/min
2. 50 mm/min
3. 15 mm/min
4. Solution A

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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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