

Keyflex® BT 1033D

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	1.09	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	85		
Shore D	31		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 2.00 mm)	23.5	MPa	ASTM D638
Tensile Elongation ² (Break, 2.00 mm)	800	%	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	185	°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	185 to 205	°C
Middle Temperature	195 to 215	°C
Front Temperature	200 to 220	°C
Nozzle Temperature	200 to 220	°C
Processing (Melt) Temp	185 to 225	°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 220	°C
Cylinder Zone 2 Temp.	190 to 210	°C
Cylinder Zone 3 Temp.	190 to 210	°C
Cylinder Zone 4 Temp.	190 to 210	°C
Adapter Temperature	190 to 210	°C
Melt Temperature	185 to 225	°C
Die Temperature	190 to 210	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	Solution A	

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