

Keyflex® BT 1072D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

General Purpose, High Modulus

Application

Injection Parts for Lesuire & Sports

General Information			
UL YellowCard	E67171-463888	E248280-100040721	
Features	General Purpose		
Uses	Automotive Applications		
	Sporting Goods		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (240°C/2.16 kg)	26	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.5 to 1.9	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	67		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield, 2.00 mm	29.4	MPa	
Break, 2.00 mm	49.0	MPa	
Tensile Elongation ² (Break, 2.00 mm)	600	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	667	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ⁴	162	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm	34	J/m	
23°C, 6.40 mm	98	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	125	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+13	ohms·cm	ASTM D257

Dielectric Strength (1.00 mm)	26	kV/mm	ASTM D149
Comparative Tracking Index (CTI) ⁵	600	V	UL 746
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
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	230 to 250	°C	
Front Temperature	235 to 255	°C	
Nozzle Temperature	235 to 255	°C	
Processing (Melt) Temp	220 to 240	°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 240	°C	
Die Temperature	220 to 240	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	50 mm/min		
5.	Solution A		

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