

Keyflex® BT 1047D

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	Outdoor Applications
	Sporting Goods
Forms	Pellets
Processing Method	Extrusion
	Injection Molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/2.16 kg)	23	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 to 1.2	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.60	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	45		ASTM D2240

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 2.00 mm)	24.5	MPa	ASTM D638
Tensile Elongation ² (Break, 2.00 mm)	800	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	108	MPa	ASTM D790

Elastomers	Nominal Value	Unit	Test Method
Tear Strength ⁴	103	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)	70.0	°C	ASTM D648
Peak Melting Temperature	190	°C	ASTM D3418

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 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	< 0.10	%	
Rear Temperature	190 to 210	°C	
Middle Temperature	200 to 220	°C	
Front Temperature	210 to 230	°C	
Nozzle Temperature	210 to 230	°C	
Processing (Melt) Temp	190 to 230	°C	
Mold Temperature	20.0 to 40.0	°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.	190 to 210	°C	
Cylinder Zone 2 Temp.	200 to 220	°C	
Cylinder Zone 3 Temp.	210 to 230	°C	
Cylinder Zone 4 Temp.	210 to 230	°C	
Adapter Temperature	210 to 230	°C	
Melt Temperature	190 to 230	°C	
Die Temperature	200 to 240	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	50 mm/min		

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