

Keyflex® TO 1065A

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description
General Purpose, Soft Touch
Application
Automotive Interior

General Information			
Features	General Purpose		
	Soft		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	30	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 23°C, Injection Molded)	62 to 68		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 23°C, 2.00 mm, Injection Molded)	4.41	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	300	%	ASTM D638
Elastomers	Nominal Value	Unit	Test Method
Tear Strength ³ (23°C)	29.4	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 6.40 mm, Injection Molded	No Break		
23°C, 6.40 mm, Injection Molded	No Break		
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	< -60.0	°C	ASTM D746
Injection	Nominal Value	Unit	
Drying Temperature	60.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Rear Temperature	180 to 200	°C	
Middle Temperature	180 to 200	°C	
Front Temperature	200 to 230	°C	
Nozzle Temperature	200 to 240	°C	

Processing (Melt) Temp	200 to 240	°C
Mold Temperature	40.0 to 60.0	°C
Back Pressure	29.4 to 58.8	MPa
Screw Speed	30 to 60	rpm

NOTE		
1.	200 mm/min	
2.	200 mm/min	
3.	50 mm/min	

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