

Keyflex® BT 1028D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description

General Purpose, Low Modulus

Application

Automotive Interior, Soft Touch Grips

General Information	
UL YellowCard	E67171-100689589
Features	General Purpose
Uses	Automotive Interior Parts
	Flexible Grips
Processing Method	Extrusion
	Injection Molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	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, Injection Molded)	0.40 to 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.80	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 23°C, Injection Molded	75		
Shore D, 23°C, Injection Molded	25		

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 2.00 mm)	19.6	MPa	ASTM D638
Tensile Elongation ² (Break, 2.00 mm)	900	%	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	155	°C	ASTM D3418

Electrical	Nominal Value	Unit	Test Method
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	170 to 190	°C
Middle Temperature	180 to 200	°C
Front Temperature	190 to 210	°C
Nozzle Temperature	190 to 210	°C
Processing (Melt) Temp	160 to 200	°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.	160 to 180	°C
Cylinder Zone 2 Temp.	170 to 190	°C
Cylinder Zone 3 Temp.	180 to 200	°C
Cylinder Zone 4 Temp.	180 to 200	°C
Adapter Temperature	180 to 200	°C
Melt Temperature	160 to 200	°C
Die Temperature	170 to 210	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	

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