

Keyflex® BT 5035D

Thermoplastic Copolyester Elastomer

LG Chem Ltd.

Message:

Description
Low Modulus, Black Color
Application
Automotive Body Plug, Fastener

General Information			
Uses	Automotive Applications		
	Fasteners		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm, Injection Molded)	1.0 to 1.4	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 23°C, Injection Molded	88		
Shore D, 23°C, Injection Molded	36		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 23°C, 2.00 mm, Injection Molded)	24.5	MPa	ASTM D638
Tensile Elongation ² (Break, 23°C, 2.00 mm, Injection Molded)	1000	%	ASTM D638
Flexural Modulus ³ (23°C, 6.40 mm, Injection Molded)	49.0	MPa	ASTM D790
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
Peak Melting Temperature	208	°C	ASTM D3418
Electrical	Nominal Value	Unit	Test Method
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	210 to 230	°C
Middle Temperature	215 to 235	°C
Front Temperature	220 to 240	°C
Nozzle Temperature	220 to 240	°C
Processing (Melt) Temp	210 to 230	°C
Mold Temperature	10.0 to 35.0	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	15 mm/min	

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