

# Keyflex® TO 1088AV

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
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	100	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 23°C, Injection Molded)	85 to 91		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (Break, 23°C, 2.00 mm, Injection Molded)	8.34	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break, 23°C, 2.00 mm, Injection Molded)	300	%	ASTM D638
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	120 to 220	°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	

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