

KEYFLEX BT 1245D

Injection Molding, TPC-ET

Description

Specialty, Medium Modulus, Black color

Application

Automotive Body Plug, Fastener, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.13
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	1.4 ~ 1.8
Melt Flow Rate	220 °C/2.16kg	ASTM D1238	g/10min	17
Water Absorption	23 °C, 24hrs	ASTM D570	%	0.6
Mechanical				
Tensile Strength, 2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	
@ Break	50mm/min		kg/cm ²	250
Tensile Elongation, 2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	1,000
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	60
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	1,000
Tear Strength @ Break	50mm/min	ASTM D624	kg/cm	
IZOD Impact Strength, 6.4mm (Notched)		ASTM D256		
	23 °C		kg·cm/cm	No break
	-40 °C		kg·cm/cm	No break
Shore Hardness	Shore D	ASTM D2240	-	40
Shore Hardness	Shore A	ASTM D2240	-	
Thermal				
Melt Temperature @ Peak		ASTM D3418	°C	205
Heat Deflection Temperature, 6.4mm (Unannealed)	4.6kg	ASTM D648	°C	80
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	600
Surface Resistivity		IEC 60093	Ohm	
Volume Resistivity	23 °C	ASTM D257	Ohm·m	
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	
Dielectric Constant (10 ⁶ Hz)	23 °C	ASTM D150	sec	

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 25-Jun-14

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

KEYFLEX BT 1245D

Injection Molding, TPC-ET

Description

Specialty, Medium Modulus, Black color

Application

Automotive Body Plug, Fastener, etc.

Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80 ~ 90	
Drying Time	hrs	3 ~ 4	
Maximum Moisture Content	%	0.01	
Melt Temperature	°C	205 ~ 235	
Cylinder Temperature	Rear	°C	205 ~ 225
	Middle	°C	210 ~ 230
	Front	°C	215 ~ 235
Nozzle Temperature	°C	215 ~ 235	
Mold Temperature	°C	10 ~ 35	
Back Pressure	kg/cm ²		
Screw Speed	rpm		

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C		
Drying Time	hrs		
Maximum Moisture Content	%		
Melt Temperature	°C		
Barrel Temperature	Zone 1	°C	
	Zone 2	°C	
	Zone 3	°C	
	Zone 4	°C	
Adapter Temperature	°C		
Die Temperature	°C		

Note) Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

Updated : 25-Jun-14

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.