

**KEYFLEX BT 1033D**

TPC

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	25	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Break	23.5	MPa	ASTM D 638
Elongation at Break	800	%	ASTM D 638
Shore A Hardness	85	-	ASTM D 2240
Shore D Hardness	31	-	ASTM D 2240
Izod Impact notched, 1/4 in	N	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	N	J/m	ASTM D 256
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melting Temperature	185	°C	ASTM D 3418

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Comparative tracking index	600	-	IEC 60112

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.7	%	ASTM D 570
Density	1090	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	185 - 225	°C	-
Mold temperature	10 - 35	°C	-
Zone 1	185 - 205	°C	-
Zone 2	195 - 215	°C	-
Zone 3	200 - 220	°C	-
Nozzle temperature	200 - 220	°C	-

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	185 - 225	°C	-
Zone 1	185 - 205	°C	-
Zone 2	195 - 215	°C	-
Zone 3	195 - 215	°C	-
Zone 4	200 - 220	°C	-
Nozzle temperature	190 - 210	°C	-

**Characteristics****Processing**

Injection Molding, Other Extrusion

**Applications**

Automotive, General Purpose

**Features**

Soft Feel

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America