





KEYFLEX BT-1155D >TPEE<			IMDS ID: 10436116
roperties	Value	Unit	Standard
echanical properties			
Tensile Stress - 5% Strain	7.4	MPa	ISO 527-1/-2
The later results and the first transfer the	35. It A.	Merchanic for	aleta 1810. Mayor da
Tensile Stress - 50% Strain		MPa	ISO 527-1/-2
THE RESIDENCE OF THE PARTY OF T	· Van Sky		A GO - TAN
Tensile Strain(Break)	510	%	ISO 527-1/-2
and and repairs of the first of	18(0)	Water Control	ine 178
Hardness, Durometer 15s	52		ISO 868
andron Francisco Alexandro	ି ବିଲ୍ଲ		e de de la
Izod Impact, notched, 80*10*4, -40°C	27.0	kJ/m²	ISO 180/1A
while the engineering with	AND A	ring is	A TSO ISO/IA
Charpy Impact, notched, 80*10*4, -40°C	25	kJ/m"	ISO 179/1eA
opazy mja civija sejednalogilo side	No.	Maria Constant	Service Andrea
Tear Strength (Method B, unnicked)	184	kN/m	ISO 34
	,,,		
hermal properties Melt volume-flow rate	14	cm³/10min	ISO 1133
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A Control of Control o	68	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	ડાં)	176.	
More of considerations of the constant	THE RESERVE TO SERVE THE PARTY OF THE PARTY	10°C/min	ISO 11357-1/-3
Glass transition Temperature	-20		130 11337 17 0
we secondarioner the Government of	i i i i i i i i i i i i i i i i i i i		ISO 306
Vicat softening temperature (50°C/h 50N)	70	*C	150 306
lectrical properties			IEC 60093
Surface resistivity	>1E14	Ohm	
en omercialistikosa astat eta jarran artea eta eta eta eta eta eta eta eta eta		din la	Eognops (148
Relative permittivity (1MHz)	4.1		IEC 60250
the laws of the March March State of the Sta	17	Jan San Ma	E 1750 - 17
Dissipation factor (1MHz)	400	E-4	IEC 60250
i totsai atos leoloji (Denni Paul III) in ili	Mary Salay		(Es. 1945)
Electric strength, Short Time, 1mm	26	kV/mm	IEC 60243-1
organization after the printers	5,000		A DECOMP TO
Other properties			
Density	1190	kg/m³	ISO 1183
e dina va adja S andale Val ^e go da es	4.2		Compression of
Water absorption - Immersion 24h	0.6	%	Sim. to ISO 62
Marian and resumption increase his to	0.0		
	0.0		
	The second secon	%	ISO 2577, 294-4
Mold Shrinkage(normal)		AND RESIDENCE OF THE PARTY OF T	
Mold Shrinkage(normal) (y)oi: 3001 (Cap)(Cap)(Cap)(Cap)(Cap)(Cap)(Cap)(Cap)	1.5	AND RESIDENCE OF THE PARTY OF T	· ISO 2577, 294-4
Mold Shrinkage(normal)	1.5	AND RESIDENCE OF THE PARTY OF T	· ISO 2577, 294-4
Mold Shrinkage(normal) Wood Supply S	9.6 1.5	%	: ISO 2577, 294-4
Mold Shrinkage(normal) Mold authorise photocile Fest specimen production Injection Molding, melt temperature	230 230	%	ISO 2577, 294-4
Mold Shrinkage(normal) Mold Shrinkage(normal) Fest specimen production Injection Molding, melt temperature Mold temperature — optimum	1.5 230	% *C	ISO 2577, 294-4 ISO 294
Mold Shrinkage(normal) Mold authorise photocile Fest specimen production Injection Molding, melt temperature	230 230	% *C	ISO 2577, 294-4 ISO 294





Injection Molding Guideline

Preliminary Drying Temperature		Ĉ	100~120
Preliminary Drying Time			3 ~ 4
Cylinder Temperature	Rear	°	200 ~ 210
	Middle	r	210 ~ 220
	Front	°C	220 ~ 230

¹⁾ The above is a table of standard processing conditions and subject to change dependent upon shapes of injection molds.

Drying

If the resin has an excessively high moisture content, this can result in surface defects, i.e.silver streaks, and impaired properties of molded parts. To ensure optimum part performance and prevent surface defects, TEPP resins must be dried prior to processing, and moisture level maintained less than 0.1%. A dehumidifying hopper dryer is highly recommended.

The hopper dryer should be preheated to the suggested drying temperature before the pellets are loaded

Holdind Time/ Pressure

Volume shrinkage takes place when the molded part cools in the mold. Holding pressure serves to offset the volume shrinkage. Holding pressure should be maintained until the gate has "frozen". The required holding pressure time can be determined by checking the weight of the molded part.

■ Please contact EP team for any questions or requirements of detail information about LG EP prooducts.