

DEXFLEX® 1066

Thermoplastic Polyolefin Elastomer

LyondellBasell Advanced Polyolefins USA, Inc.

Product Description

DEXFLEX® 1066 is a thermoplastic olefinic elastomer (TPO) designed for automotive exterior applications that require excellent low-temperature toughness and durable paintability into large injection molded parts.

Applications:

Air dams and other components that must meet exacting dimensional tolerances.

General

Features	• Durable	• Low Temperature Toughness	• Paintable
Uses	• Automotive Applications	• Automotive Exterior Parts	
Processing Method	• Injection Molding		

Physical	Nominal Value	Unit	Test Method
Density	0.910	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	7.0	g/10 min	ISO 1133
Molding Shrinkage	1.0 to 1.4	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress ² (Yield, 4.00 mm)	17.0	MPa	ISO 527-2/50
Flexural Modulus ³ (4.00 mm)	600	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Instrumented Dart Impact ⁴ (23°C)	19.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
CLTE - Flow (-30 to 80°C)	0.000090	cm/cm/°C	ASTM E228

Injection	Nominal Value	Unit
Rear Temperature	193 to 227	°C
Middle Temperature	193 to 227	°C
Front Temperature	193 to 227	°C
Nozzle Temperature	193 to 227	°C
Processing (Melt) Temp	210 to 232	°C
Mold Temperature	18.3 to 48.9	°C
Injection Pressure	3.45 to 10.3	MPa
Injection Rate	Moderate	
Back Pressure	0.345 to 2.07	MPa
Screw Speed	50 to 100	rpm
Clamp Tonnage	2.8 to 4.1	kN/cm ²
Cushion	6.35 to 12.7	mm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 150x10x4 mm specimen

³ 2.0 mm/min

⁴ 2.20 m/sec