

DuPont™ Hytrel® HTR8068

THERMOPLASTIC POLYESTER ELASTOMER

Product Information

Common features of Hytrel® thermoplastic polyester elastomer include mechanical and physical properties such as exceptional toughness and resilience, high resistance to creep, impact and flex fatigue, flexibility at low temperatures and good retention of properties at elevated temperatures. In addition, it resists many industrial chemicals, oils and solvents. Special grades include heat stabilised, flame retardant, food contact compliant, blow molding and extrusion grades. Concentrates offered include black pigments, UV protection additives, heat stabilisers, and flame retardants.

Hytrel® thermoplastic polyester elastomer is plasticiser free.

The good melt stability of Hytrel® thermoplastic polyester elastomer normally enables the recycling of properly handled production waste. If recycling is not possible, DuPont recommends, as the preferred option, incineration with energy recovery (-24 kJ/g of base polymer) in appropriately equipped installations.

For disposal, local regulations have to be observed.

Hytrel® thermoplastic polyester elastomer typically is used in demanding applications in the automotive, fluid power, electrical/electronic, consumer goods, appliance and power tool, sporting goods, furniture, industrial and off-road transportation/equipment industry.

Hytrel® HTR8068 is a medium modulus flame retardant and antidrip Hytrel® resin that meets the requirement of UL94 V-0. It has nominal durometer hardness of 44D.

General information	Value	Unit	Test Standard
Resin Identification	TPC-ET-FR(17)	-	ISO 1043
Part Marking Code	TPC-ET-FR(17)	-	ISO 11469
Rheological properties	Value	Unit	Test Standard
Melt volume-flow rate	3.6	cm ³ /10min	ISO 1133
Temperature	190	°C	ISO 1133
Load	2.16	kg	ISO 1133
Melt mass-flow rate	4	g/10min	ISO 1133
Melt mass-flow rate, Temperature	190	°C	ISO 1133
Melt mass-flow rate, Load	2.16	kg	ISO 1133
Molding shrinkage, parallel	1.1	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
Mechanical properties (TPE)	Value	Unit	Test Standard
Tensile Modulus	140	MPa	ISO 527-1/-2
Stress at 10% strain	5.9	MPa	ISO 527-1/-2
Stress at 50% strain	7.3	MPa	ISO 527-1/-2
Stress at break	13	MPa	ISO 527-1/-2
Strain at break	>300	%	ISO 527-1/-2
Nominal strain at break	340	%	ISO 527-1/-2
Tear strength, parallel	70	kN/m	ISO 34-1
Tear strength, normal	70	kN/m	ISO 34-1
Shore D hardness, max	44	-	ISO 7619-1
Shore D hardness, 15s	38	-	ISO 7619-1
Mechanical properties	Value	Unit	Test Standard
Flexural Modulus	155	MPa	ISO 178
Charpy notched impact strength			ISO 179/1eA
73°F	40	kJ/m ²	
-22°F	7	kJ/m ²	
-40°F	5	kJ/m ²	
Brittleness temperature	-48	°C	ISO 974
Thermal properties	Value	Unit	Test Standard
Melting temperature, 18°F/min	170	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
260 psi	41	°C	
65 psi	46	°C	

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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Vicat softening temperature, 90°F, 2 lbf	107	°C	ISO 306
Coeff. of linear therm. expansion, parallel	150	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	170	E-6/K	ISO 11359-1/-2
Eff. thermal diffusivity	5.44E-8	m ² /s	-
RTI, electrical			UL 746B
60mil	50	°C	
120mil	50	°C	
RTI, impact			UL 746B
60mil	50	°C	
120mil	50	°C	
RTI, strength			UL 746B
60mil	50	°C	
120mil	50	°C	
Flammability	Value	Unit	Test Standard
Burning Behav. at 60mil nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes	-	UL 94
Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3	mm	IEC 60695-11-10
UL recognition	yes	-	UL 94
Oxygen index	26	%	ISO 4589-1/-2
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<100	mm/min	ISO 3795 (FMVSS 302)
Electrical properties	Value	Unit	Test Standard
Relative permittivity, 100Hz	6.8	-	IEC 60250
CTI, 23°C, 3.0mm	425	PLC	UL 746A
Electric Strength, 2000 V/s, in oil, 23°C, 2mm	20	kV/mm	IEC 60243-1
High Amperage Arc Ignition Resistance, 60 mil	200	arcs	UL 746A
Other properties	Value	Unit	Test Standard
Density	1430	kg/m ³	ISO 1183
Density of melt	1300	kg/m ³	-
Water Absorption, Immersion 24h	1.9	%	Sim. to ISO 62
Injection	Value	Unit	Test Standard
Drying Recommended	yes	-	-
Drying Temperature	100	°C	-
Drying Time, Dehumidified Dryer	2 - 3	h	-
Processing Moisture Content	≤0.08	%	-
Melt Temperature Optimum	200	°C	-
Min. melt temperature	190	°C	-
Max. melt temperature	210	°C	-
Mold Temperature Optimum	40	°C	-
Min. mold temperature	30	°C	-
Max. mold temperature	40	°C	-

Characteristics			
Processing	<ul style="list-style-type: none"> • Injection Molding • Film Extrusion • Profile Extrusion 	<ul style="list-style-type: none"> • Sheet Extrusion • Other Extrusion • Coating 	<ul style="list-style-type: none"> • Casting • Thermoforming
Delivery form	<ul style="list-style-type: none"> • Pellets 		
Special characteristics	<ul style="list-style-type: none"> • Light stabilized or stable to light 		
Regional Availability	<ul style="list-style-type: none"> • North America • Europe 	<ul style="list-style-type: none"> • Asia Pacific • South and Central America 	<ul style="list-style-type: none"> • Near East/Africa • Global

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Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass) (23 °C)
- ✓ Citric Acid solution (10% by mass) (23 °C)
- ✓ Lactic Acid (10% by mass) (23 °C)
- ✗ Hydrochloric Acid (36% by mass) (23 °C)
- ✗ Nitric Acid (40% by mass) (23 °C)
- ✗ Sulfuric Acid (38% by mass) (23 °C)
- ✓ Sulfuric Acid (5% by mass) (23 °C)
- ✗ Chromic Acid solution (40% by mass) (23 °C)

Bases

- ✓ Sodium Hydroxide solution (35% by mass) (23 °C)
- ✓ Sodium Hydroxide solution (1% by mass) (23 °C)
- ✓ Ammonium Hydroxide solution (10% by mass) (23 °C)

Alcohols

- ✓ Isopropyl alcohol (23 °C)
- ✓ Methanol (23 °C)
- ✓ Ethanol (23 °C)

Hydrocarbons

- ✓ n-Hexane (23 °C)
- ✓ Toluene (23 °C)
- ✓ iso-Octane (23 °C)

Ketones

- ✗ Acetone (23 °C)

Ethers

- ✗ Diethyl ether (23 °C)

Mineral oils

- ✓ SAE 10W40 multigrade motor oil (23 °C)
- ✗ SAE 10W40 multigrade motor oil (130 °C)
- ✗ SAE 80/90 hypoid-gear oil (130 °C)
- ✓ Insulating Oil (23 °C)

Standard Fuels

- ✗ ISO 1817 Liquid 1 - E5 (60 °C)
- ✗ ISO 1817 Liquid 2 - M15E4 (60 °C)
- ✗ ISO 1817 Liquid 3 - M3E7 (60 °C)
- ✗ ISO 1817 Liquid 4 - M15 (60 °C)
- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C) (23 °C)
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23 °C)

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- ✓ Diesel fuel (pref. ISO 1817 Liquid F) (23°C)
- ✓ Diesel fuel (pref. ISO 1817 Liquid F) (90°C)
- ✗ Diesel fuel (pref. ISO 1817 Liquid F) (>90°C)

Salt solutions

- ✓ Sodium Chloride solution (10% by mass) (23°C)
- ✗ Sodium Hypochlorite solution (10% by mass) (23°C)
- ✓ Sodium Carbonate solution (20% by mass) (23°C)
- ✓ Sodium Carbonate solution (2% by mass) (23°C)
- ✓ Zinc Chloride solution (50% by mass) (23°C)

Other

- ✓ Ethyl Acetate (23°C)
- ✗ Hydrogen peroxide (23°C)
- ✗ DOT No. 4 Brake fluid (130°C)
- ✗ Ethylene Glycol (50% by mass) in water (108°C)
- ✓ 1% nonylphenoxy-polyethyleneoxy ethanol in water (23°C)
- ✓ 50% Oleic acid + 50% Olive Oil (23°C)
- ✓ Water (23°C)
- ✗ Water (90°C)
- ✓ Phenol solution (5% by mass) (23°C)

Symbols used:

- ✓ possibly resistant

Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).

- ✗ not recommended - see explanation

Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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