Celanese
The chemistry inside innovation™

Hytrel® 6356BKB

THERMOPLASTIC POLYESTER ELASTOMER

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, we recommend, 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® 6356BKB is a medium modulus grade with nominal hardness of 63D. It is a cube blend of Hytrel® 6356 and Hytrel® 40CB. It contains non-discoloring stabilizer. It can be processed by many conventional thermoplastic processing techniques like injection molding and extrusion.

Typical applications:

Hose and tubing, mandrels, wire and cable, film, profiles, seals, gears, sprockets, fuel tanks, containers with good permeation resistance to gases and liquids.

Rheological properties

Melt volume-flow rate	8.5	cm^3/10min	ISO 1133
Melt mass-flow rate	9	g/10min	ISO 1133
Temperature	230	°C	
Load	2.16	kg	
Melt mass-flow rate, Temperature	230	°C	
Melt mass-flow rate, Load	2.16	kg	

Typical mechanical properties

Tensile Modulus	280	MPa	ISO 527-1/-2
Stress at break	43	MPa	ISO 527-1/-2
Strain at break	>300	%	ISO 527-1/-2
Flexural Modulus	290	MPa	ISO 178
Charpy notched impact strength, 23 °C	120[P]	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30 °C	25	kJ/m^2	ISO 179/1eA
Poisson's ratio	0.48		
Shore D hardness, max	63		ISO 868

[P]: Partial Break

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Thermal properties

Melting temperature, 10°C/min	210	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	-5	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	45	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	80	°C	ISO 75-1/-2

Other properties

Density	1220	kg/m³	ISO 1183

Injection

Drying Recommended	yes		
Drying Temperature	100	°C	
Drying Time, Dehumidified Dryer	2 - 3	h	
Processing Moisture Content	≤0.08	%	
Melt Temperature Optimum	240	°C	Internal
Min. melt temperature	235	°C	
Max. melt temperature	260	°C	
Mold Temperature Optimum	45	°C	
Min. mould temperature	45	°C	
Max. mould temperature	55	°C	
Hold pressure range	≤70	MPa	

Extrusion

Drying Temperature	90 - 110	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.06	%
Melt Temperature Optimum	230	°C
Melt Temperature Range	225 - 240	°C

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

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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
- ✔ 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

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- ✔ Phenol solution (5% by mass), 23°C
- ✘ Coolant Glysantin G48, 1:1 in water, 125°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).