

Hytrel® 7246

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® 7246 is a high modulus grade with nominal hardness of 72D. It contains non-discoloring stabilizer. It can be processed by many conventional thermoplastic processing techniques like injection molding and extrusion.

The 72 Shore D hardness is based on a legacy method and is still used for grade identification purposes.

Typical applications:

Tubing, wire and cable jackets, gears and sprockets, oil field parts.

Product information

Resin Identification	TPC-ET	ISO 1043
Part Marking Code	>TPC-ET<	ISO 11469
ISO designation	ISO 20029-TPC-ET,,GLN,70-22-075	

Rheological properties

Melt volume-flow rate	12 cm ³ /10min	ISO 1133
Melt mass-flow rate	13 g/10min	ISO 1133
Temperature	240 °C	
Load	2.16 kg	
Melt mass-flow rate, Temperature	240 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage, parallel	1.6 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.6 %	ISO 294-4, 2577



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Typical mechanical properties

Tensile Modulus	550 MPa	ISO 527-1/-2
Yield stress	27 MPa	ISO 527-1/-2
Yield strain	23 %	ISO 527-1/-2
Stress at 5% strain	14 MPa	ISO 527-1/-2
Stress at 10% strain	23 MPa	ISO 527-1/-2
Stress at 50% strain	24 MPa	ISO 527-1/-2
Stress at break	50 MPa	ISO 527-1/-2
Nominal strain at break	530 %	ISO 527-1/-2
Strain at break	>300 %	ISO 527-1/-2
Flexural Modulus	550 MPa	ISO 178
Shear Modulus	280 MPa	ISO 6721
Tensile creep modulus, 1h	360 MPa	ISO 899-1
Tensile creep modulus, 1000h	310 MPa	ISO 899-1
Charpy notched impact strength, 23°C	36 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	8 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -40°C	7 kJ/m ²	ISO 179/1eA
Tensile notched impact strength, 23°C	300 kJ/m ²	ISO 8256/1
Izod notched impact strength, 23°C	38 kJ/m ²	ISO 180/1A
Izod notched impact strength, -40°C	7 kJ/m ²	ISO 180/1A
Poisson's ratio	0.47	
Brittleness temperature	-97 °C	ISO 974
Shore D hardness, 15s	64	ISO 48-4 / ISO 868
Shore D hardness, max	68	ISO 868
Tear strength, parallel	180 kN/m	ISO 34-1
Tear strength, normal	170 kN/m	ISO 34-1
Abrasion resistance	100 mm ³	ISO 4649

Thermal properties

Melting temperature, 10°C/min	218 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	25 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	50 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	100 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	140 °C	ISO 306
Vicat softening temperature, 50°C/h 10N	200 °C	ISO 306
Coeff. of linear therm. expansion, parallel, -40-23°C	120 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel	180 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	130 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	170 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.15 W/(m K)	Internal
Eff. thermal diffusivity	8E-8 m ² /s	Internal
Spec. heat capacity of melt	2150 J/(kg K)	Internal
RTI, electrical, 1.5mm	85 °C	UL 746B
RTI, impact, 1.5mm	85 °C	UL 746B



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RTI, strength, 1.5mm	75 °C	UL 746B
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Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	UL 94
Thickness tested	1.5 mm	UL 94
UL recognition	yes	UL 94
Oxygen index	23 %	ISO 4589-1/-2
FMVSS Class	SE/B	ISO 3795 (FMVSS 302)

Electrical properties

Relative permittivity, 100Hz	4	IEC 62631-2-1
Relative permittivity, 1MHz	3.5	IEC 62631-2-1
Dissipation factor, 100Hz	160 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	300 E-4	IEC 62631-2-1
Volume resistivity	2E10 Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15 Ohm	IEC 62631-3-2
Electric strength	20 kV/mm	IEC 60243-1
Comparative tracking index	600	IEC 60112

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.6 %	Sim. to ISO 62
Water absorption, Immersion 24h	0.3 %	Sim. to ISO 62
Density	1260 kg/m³	ISO 1183
Density of melt	1110 kg/m³	Internal

VDA Properties

Light stability delta I	-3	DIN 53236
Light stability delta a	-0.1	DIN 53236
Light stability delta b	15	DIN 53236
Light stability delta E	16	DIN 53236
Emission of organic compounds	300 µgC/g	VDA 277

Injection

Drying Recommended	yes	
Drying Temperature	110 °C	
Drying Time, Dehumidified Dryer	2 - 3 h	
Processing Moisture Content	≤0.08 %	
Melt Temperature Optimum	245 °C	Internal
Min. melt temperature	240 °C	
Max. melt temperature	260 °C	
Mold Temperature Optimum	45 °C	
Min. mould temperature	45 °C	

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Max. mould temperature	55 °C
Hold pressure range	≤70 MPa

Extrusion

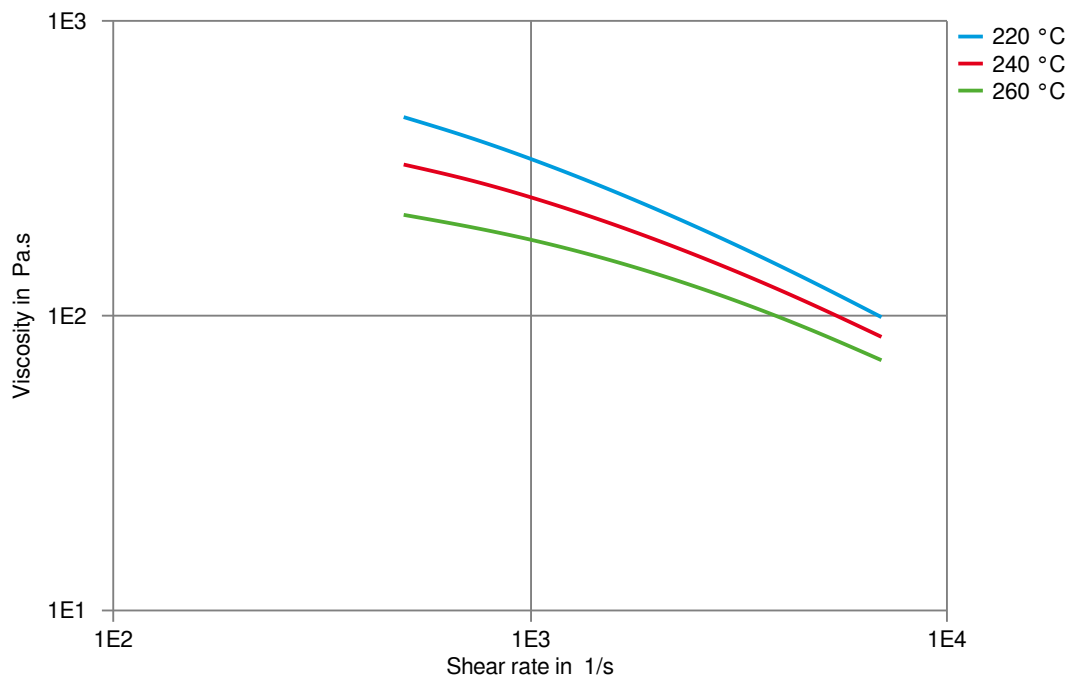
Drying Temperature	100 - 120 °C
Drying Time, Dehumidified Dryer	2 - 3 h
Processing Moisture Content	≤0.06 %
Melt Temperature Optimum	235 °C
Melt Temperature Range	225 - 245 °C



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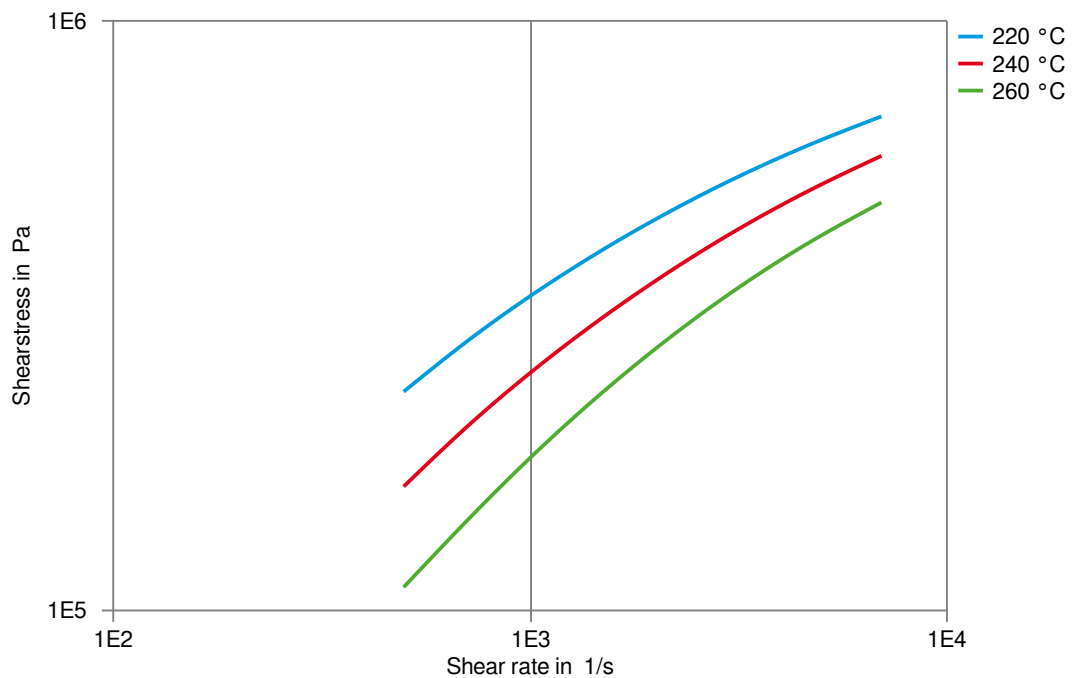
Viscosity-shear rate



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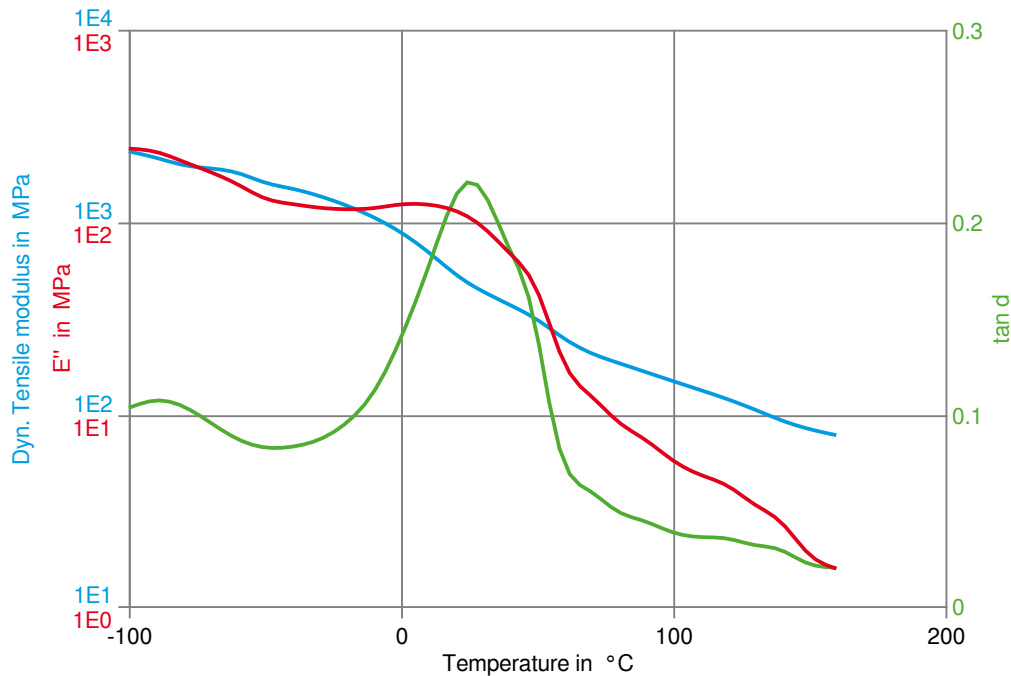
Shearstress-shear rate



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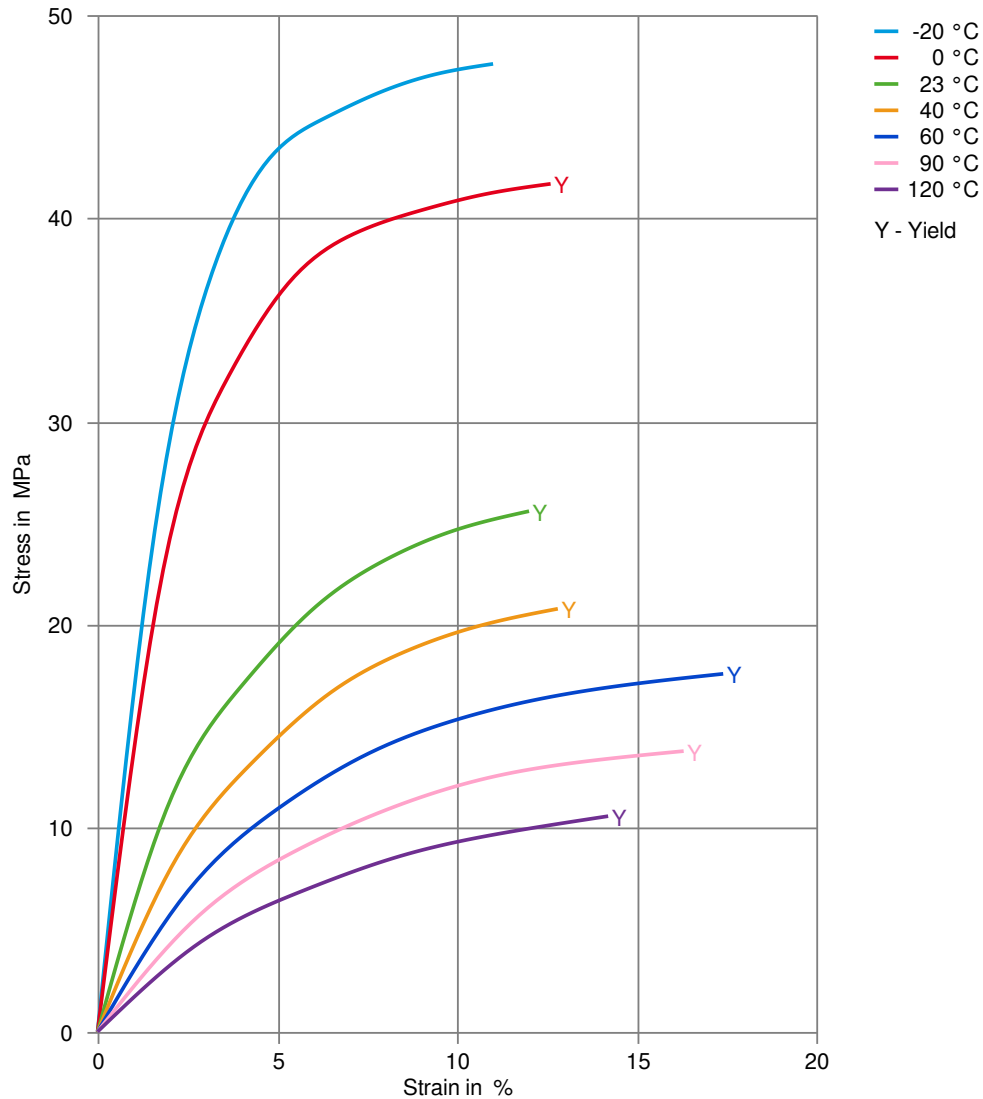
Dynamic Tensile modulus-temperature



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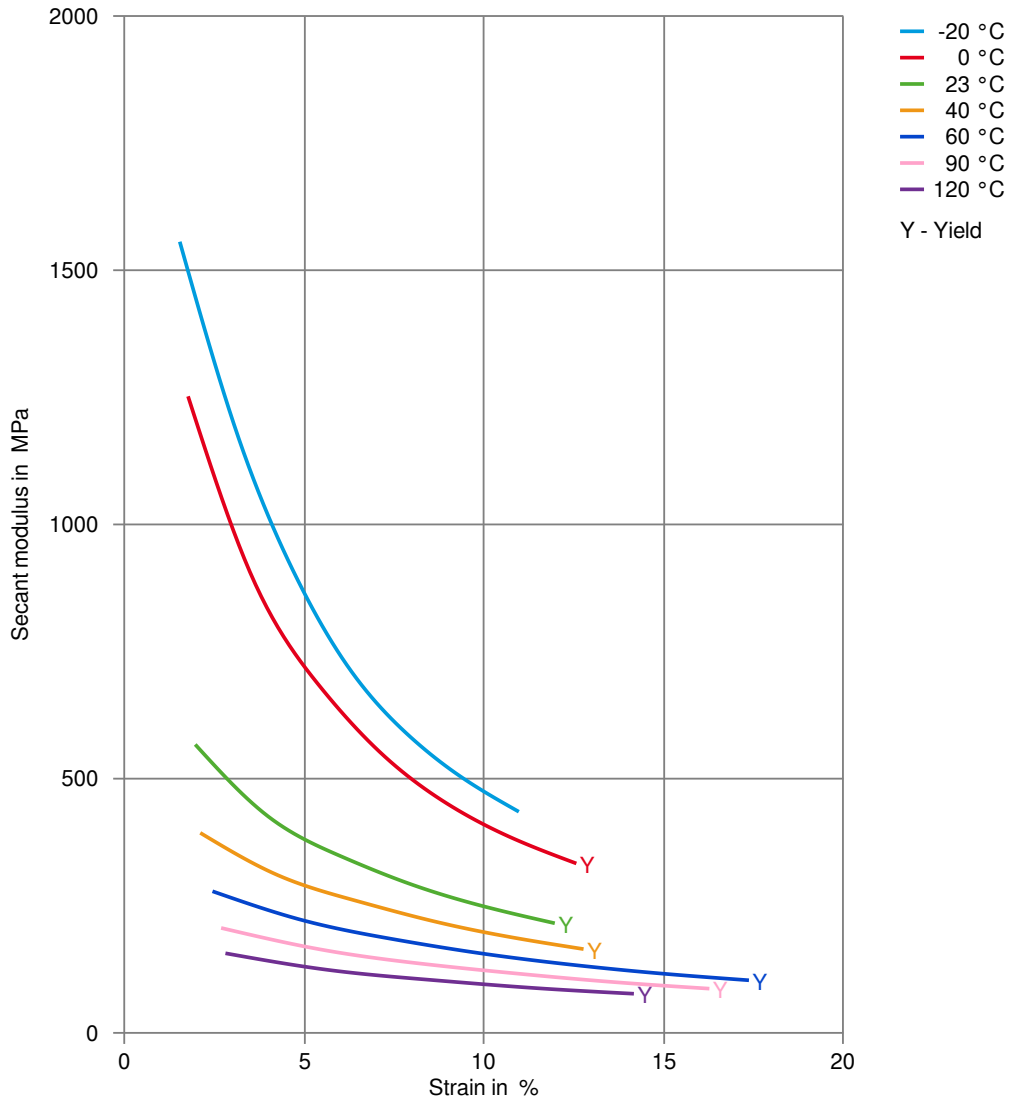
Stress-strain



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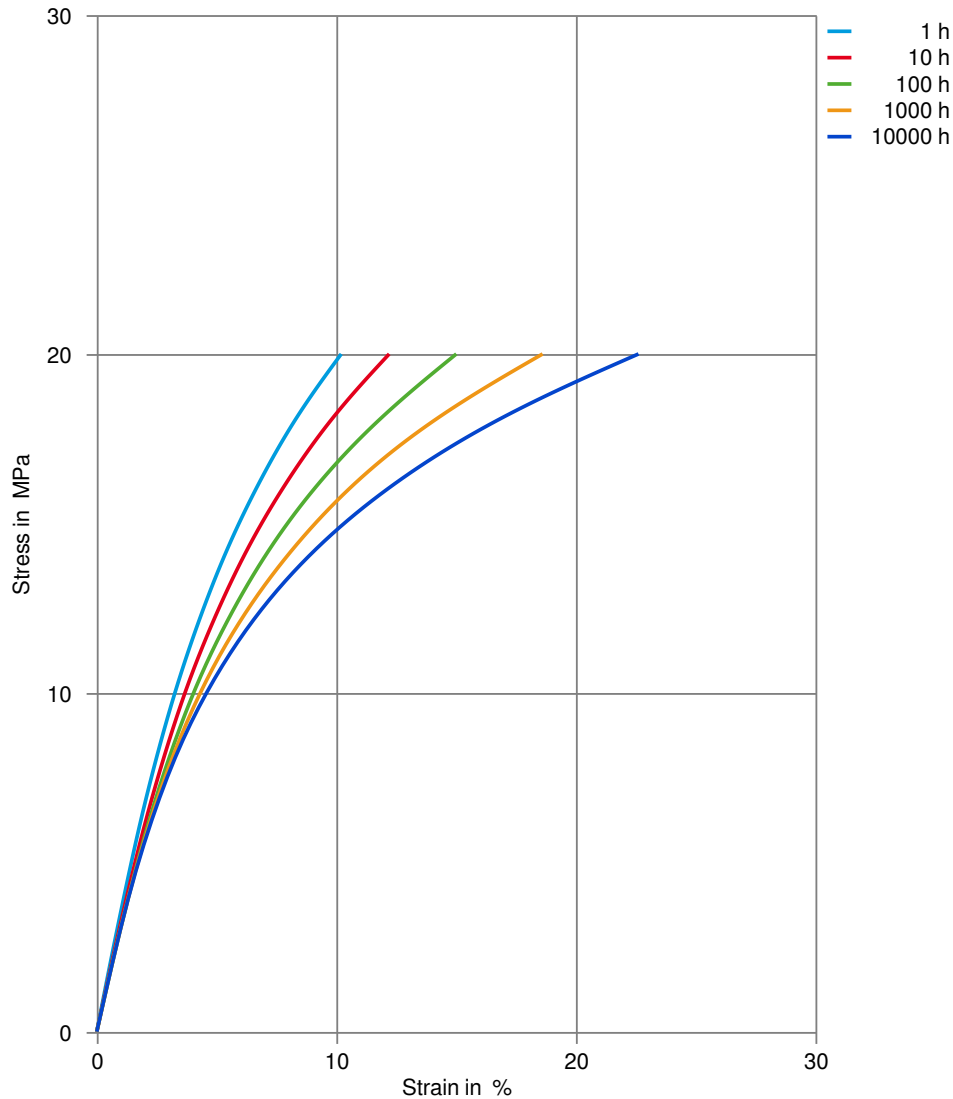
Secant modulus-strain



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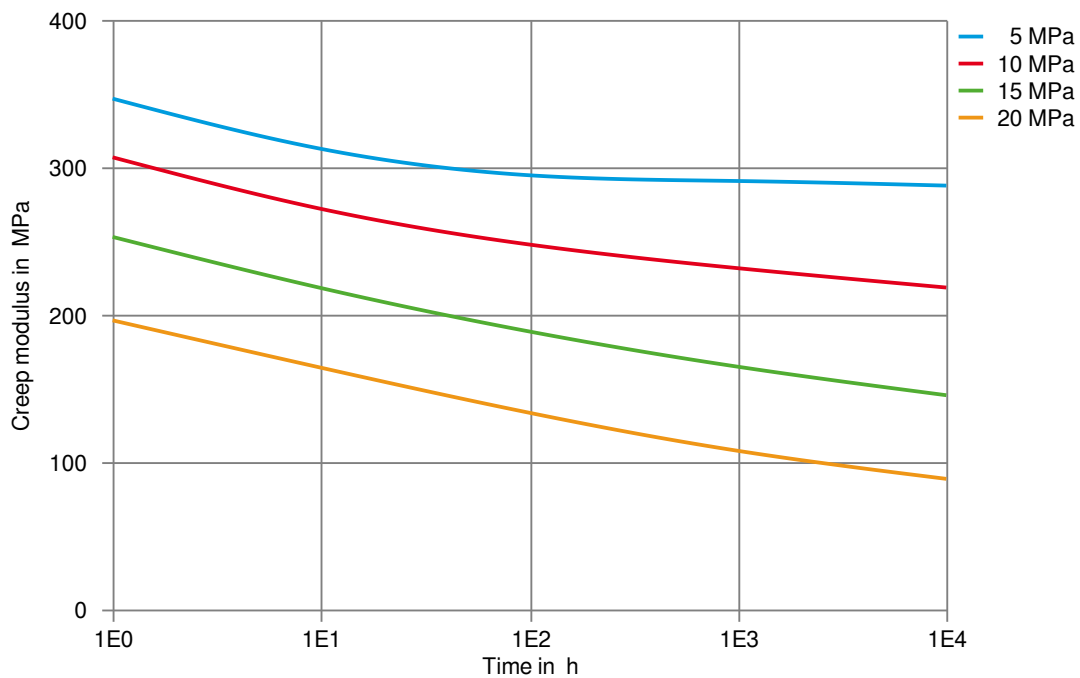
Stress-strain (isochronous) 23°C



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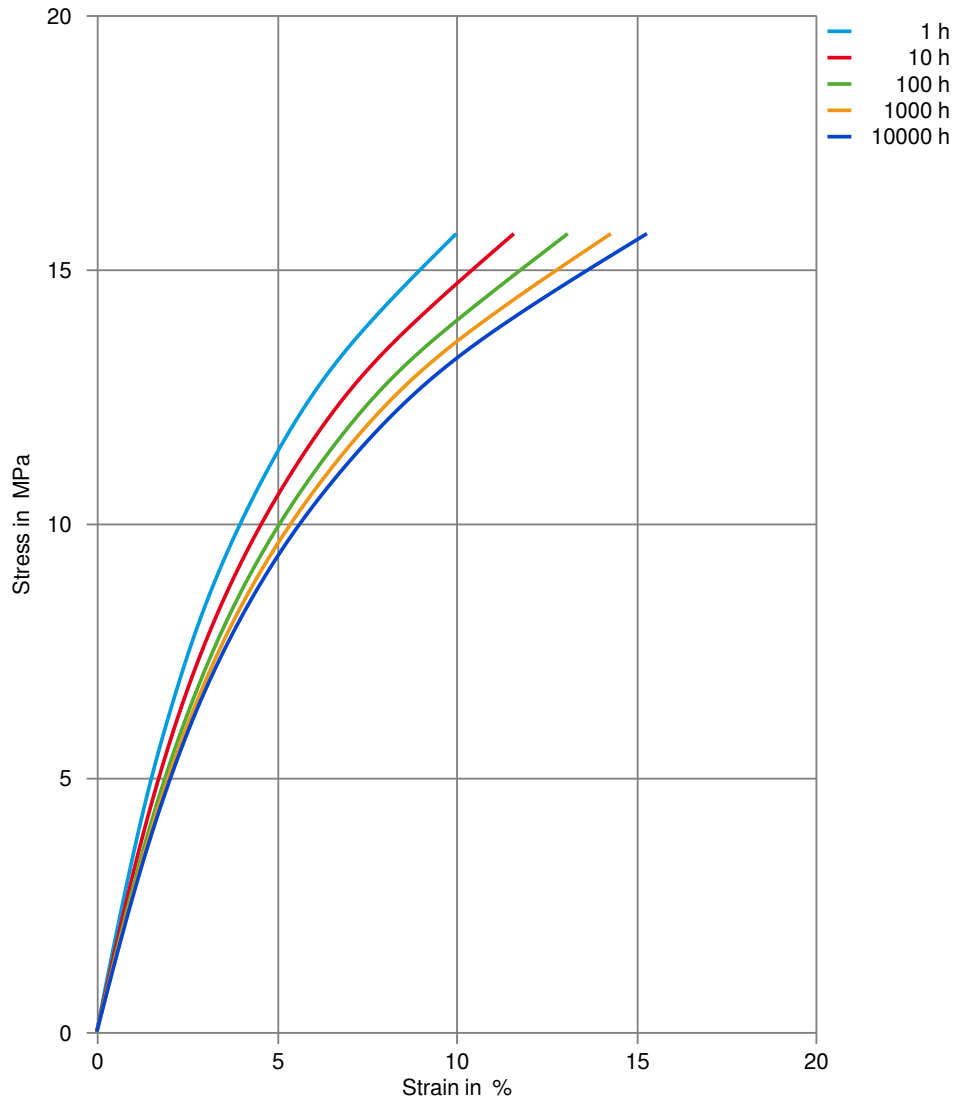
Creep modulus-time 23°C



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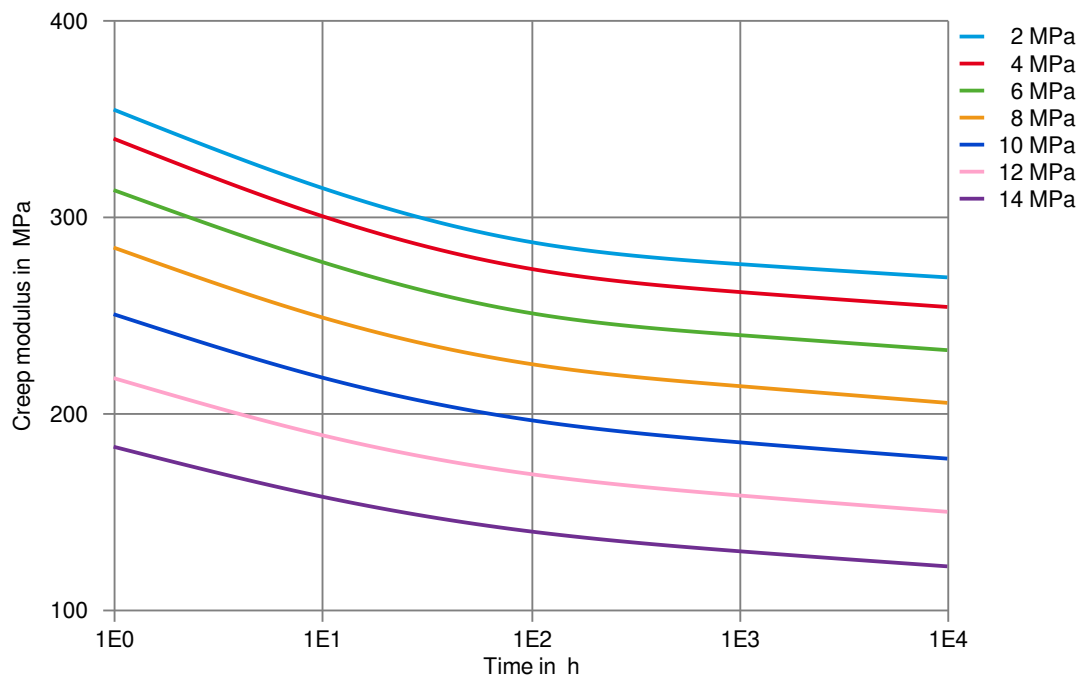
Stress-strain (isochronous) 40°C



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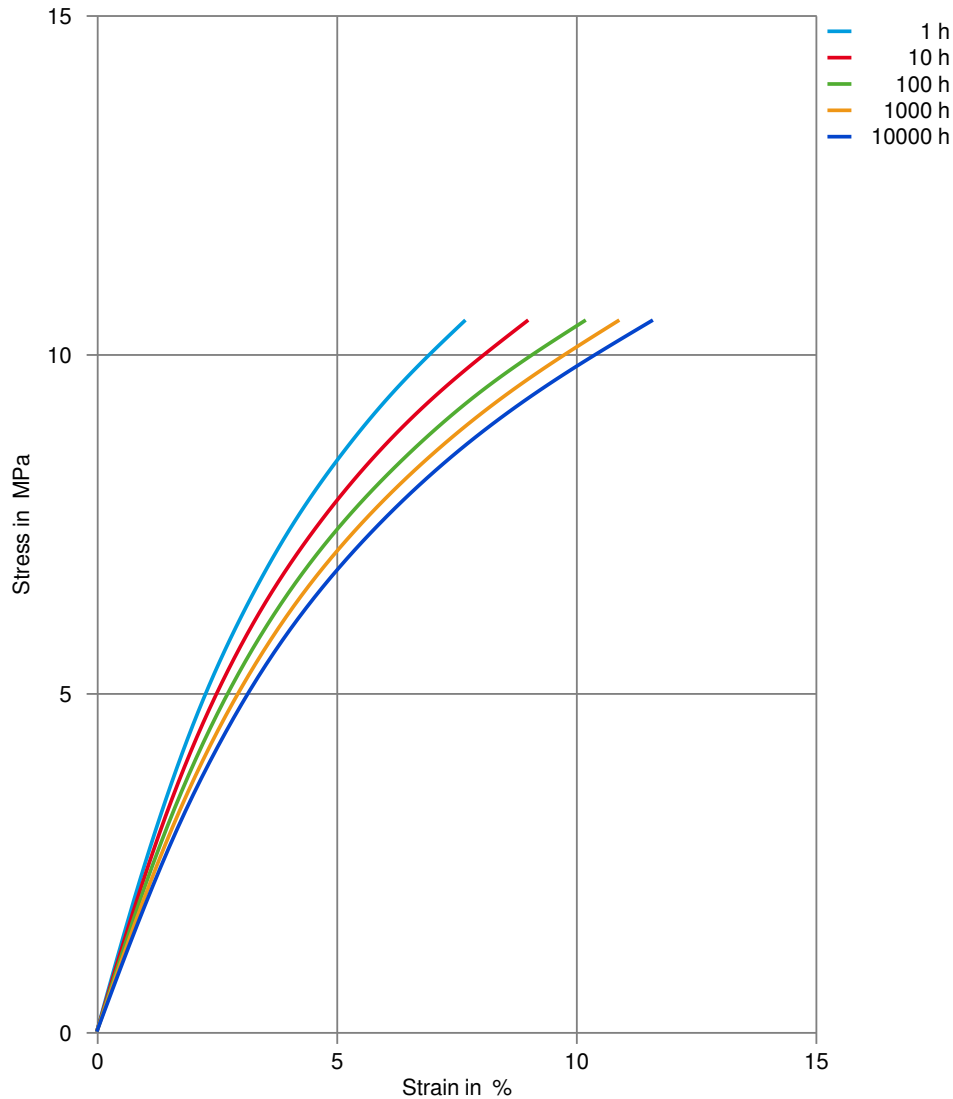
Creep modulus-time 40°C



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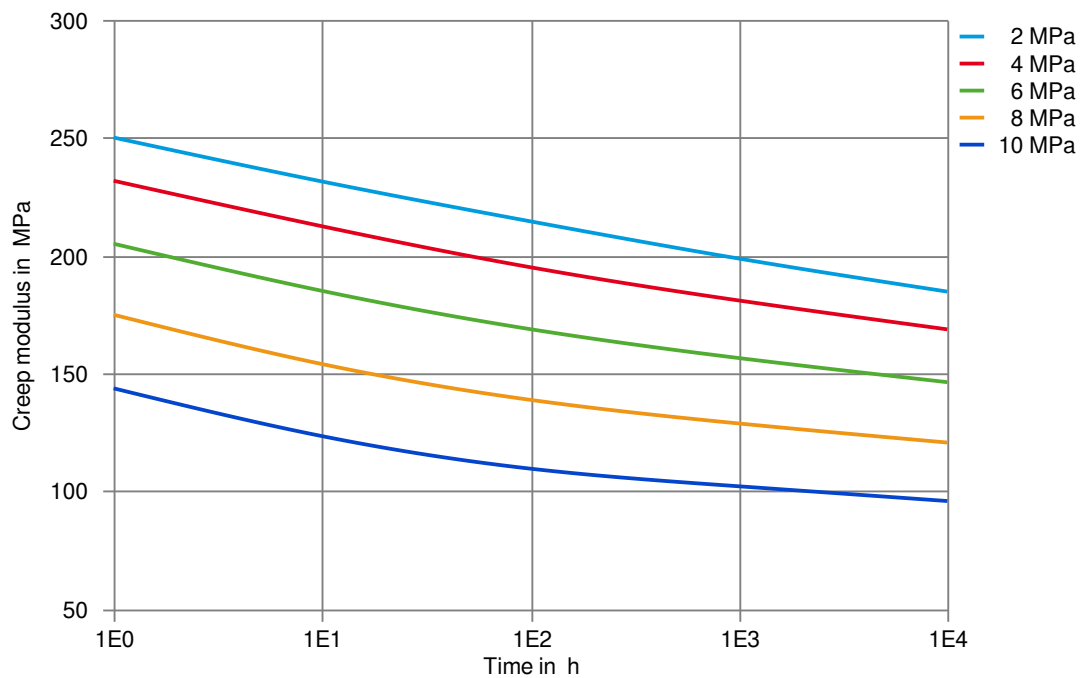
Stress-strain (isochronous) 80°C



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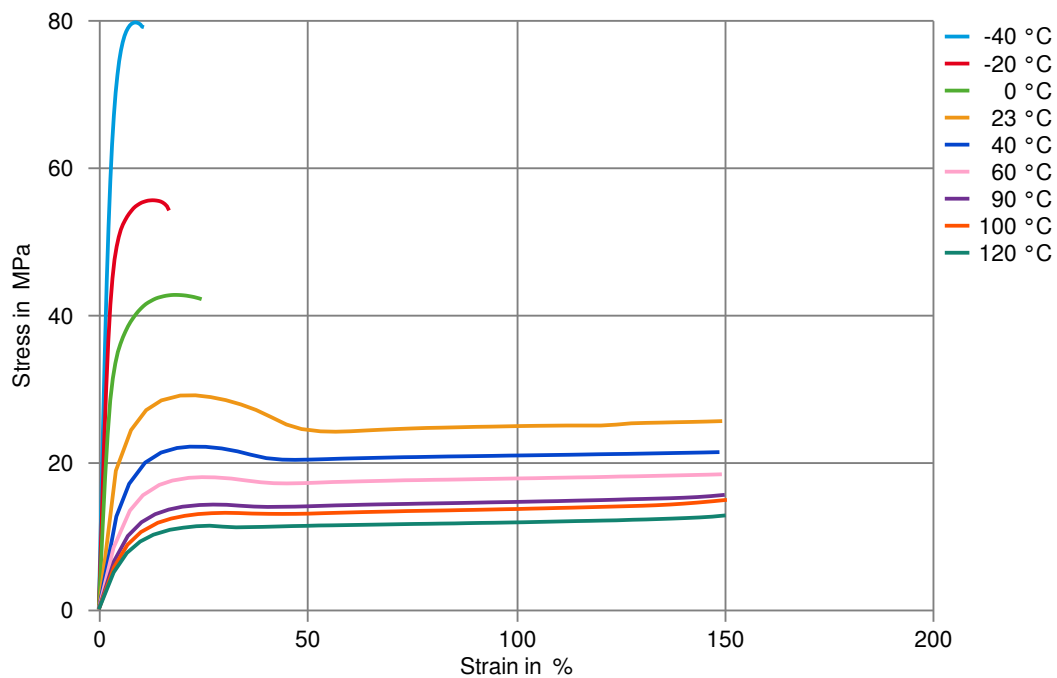
Creep modulus-time 80°C



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Stress-Strain (Flexible Materials)



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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
- ✗ Motor oil OS206 304 Ref.Eng.Oil, ISP, 135 °C
- ✗ Automatic hypoid-gear oil Shell Donax TX, 135 °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



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- ✓ 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
- ✗ DOT No. 4 Brake fluid, 120°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
- ✗ 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).

