Celanese
The chemistry inside innovation™

Hytrel® HTR8908ECO-B 452 NC010 (PRELIMINARY)
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® HTR8908ECO-B 452 NC010 is a soft hardness halogen-free flame retardant thermoplastic elastomer with very good flammability performance. It can be processed by thermoplastic techniques such as injection molding and extrusion. Suitable for thin wall wire & cable extrusion applications. It is the natural colour alternative of Hytrel® HTR8908ECO-B NC010.

Hytrel® HTR8908ECO-B 452 NC010 belongs to the Hytrel® ECO-B family. The products of this family are partially produced using bio-feedstock derived from waste*. This results in reduced lifecycle greenhouse gas emissions and lower fossil resource use.

*certified bio-circular according to ISCC Plus mass balance approach.

Rheological properties

Melt mass-flow rate	5.2	g/10min	ISO 1133
Melt mass-flow rate, Temperature	200	°C	
Melt mass-flow rate, Load	2.16	kg	
Moulding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.3	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	50[1]	MPa	ISO 527-1/-2
Stress at 5% elongation	2.1[2]	MPa	ISO 527-1/-2 or ISO 37
Stress at 10% elongation	3[2]	MPa	ISO 527-1/-2 or ISO 37
Tensile stress at 50% elongation	5.3[2]	MPa	ISO 527-1/-2 or ISO 37
Tensile stress at break	12[2]	MPa	ISO 527-1/-2
Tensile strain at break	>300[2]	%	ISO 527-1/-2
Flexural modulus	56	MPa	ISO 178
Charpy notched impact strength, -30 °C	66	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40 °C	75	kJ/m²	ISO 179/1eA
Izod notched impact strength, -40 °C	62.0	kJ/m²	ISO 180/1A
Shore A hardness, 3s	91		ISO 48-4 / ISO 868
Shore A hardness, 15s	90		ISO 48-4 / ISO 868
Shore D hardness, 15s	28		ISO 48-4 / ISO 868
Shore D hardness, max	30		ISO 868
Tear strength, parallel	57	kN/m	ISO 34-1

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Tear strength, normal	59	kN/m	ISO 34-1

[1]: 1BA injected test bar, 1 mm/min speed
[2]: 1BA injected test bar, 200 mm/min speed

Thermal properties

Melting temperature, 10 °C/min	173	°C	ISO 11357-1/-3
Vicat softening temperature, 50 °C/h 10N	75	°C	ISO 306

Flammability

Burning Behav. at 1.5mm nom. thickn.	V-2[3]	class	IEC 60695-11-10
Thickness tested	1.6[3]	mm	IEC 60695-11-10
Burning Behav. at thickness h	V-1[3]	class	IEC 60695-11-10
Thickness tested	3.2[3]	mm	IEC 60695-11-10

[3]: Not UL certified

Physical/Other properties

Density	1120	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.08	%
Min. melt temperature	200	°C
Max. melt temperature	230	°C

Extrusion

Drying Temperature	70 - 90	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.06	%
Melt Temperature Range	200 - 235	°C

Characteristics

Processing	Injection Moulding, Extrusion, Extrusion - Wire and Cable, Other Extrusion, Calendering, Casting, Thermoforming
Delivery form	Pellets
Additives	Flame retardant, Non-halogenated/Red phosphorous free flame retardant
Special characteristics	Flame retardant, Heat stabilised or stable to heat, Colourable
Sustainability	Bio-Content

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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

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
- ✔ 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

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- ✗ Ethylene Glycol (50% by mass) in water, 108 °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).