



# Hytrel® G4074

## 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, 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® G4074 is a low modulus grade with nominal hardness of 40D. It contains discoloring stabilizer. It can be processed by many conventional thermoplastic processing techniques like injection molding and extrusion.

Typical applications:

Hose and tubing, hose jackets, wire and cable jackets, film and sheeting, moulded products. Not suited for light-colored finished products.

### Product information

Resin Identification	TPC-ET	ISO 1043
Part Marking Code	>TPC-ET<	ISO 11469

### Rheological properties

Melt volume-flow rate	5 cm <sup>3</sup> /10min	ISO 1133
Melt mass-flow rate	5.3 g/10min	ISO 1133
Temperature	190 °C	ISO 1133
Load	2.16 kg	ISO 1133
Melt mass-flow rate, Temperature	190 °C	ISO 1133
Melt mass-flow rate, Load	2.16 kg	ISO 1133
Moulding shrinkage, parallel	0.8 %	ISO 294-4, 2577
Moulding shrinkage, normal	0.8 %	ISO 294-4, 2577



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### Typical mechanical properties

Tensile Modulus	55 MPa	ISO 527-1/-2
Stress at 5% strain	2.5 MPa	ISO 527-1/-2
Stress at 10% strain	4.4 MPa	ISO 527-1/-2
Stress at 50% strain	8 MPa	ISO 527-1/-2
Stress at break	20 MPa	ISO 527-1/-2
Nominal strain at break	360 %	ISO 527-1/-2
Strain at break	250 %	ISO 527-1/-2
Flexural Modulus	65 MPa	ISO 178
Shear Modulus	16 MPa	ISO 6721
Tensile creep modulus, 1000h	35 MPa	ISO 899-1
Charpy impact strength, 23°C	N kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	N kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	N kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	N kJ/m <sup>2</sup>	ISO 179/1eA
Puncture - maximum force, -30°C	3000 N	ISO 6603-2
Puncture energy, -30°C	37 J	ISO 6603-2
Izod notched impact strength, 23°C	N kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -40°C	N kJ/m <sup>2</sup>	ISO 180/1A
Brittleness temperature	-60 °C	ISO 974
Shore D hardness, 15s	35 -	ISO 48-4
Shore D hardness, max	40 -	ISO 48-4
Tear strength, parallel	86 kN/m	ISO 34-1
Tear strength, normal	96 kN/m	ISO 34-1
Abrasion resistance	50 mm <sup>3</sup>	ISO 4649

### Thermal properties

Melting temperature, 10°C/min	170 °C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	-35 °C	ISO 11357-1/-2
Vicat softening temperature, 50°C/h 10N	115 °C	ISO 306
CLTE, Parallel, -40-23°C	220 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel	210 E-6/K	ISO 11359-1/-2
CLTE, Normal, -40-23°C	180 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	200 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.26 W/(m K)	
Eff. thermal diffusivity	5.44E-8 m <sup>2</sup> /s	
Spec. heat capacity of melt	2050 J/(kg K)	
RTI, electrical, 0.75mm	90 °C	UL 746B
RTI, electrical, 1.5mm	90 °C	UL 746B
RTI, electrical, 3mm	90 °C	UL 746B
RTI, impact, 0.75mm	50 °C	UL 746B
RTI, impact, 1.5mm	85 °C	UL 746B
RTI, impact, 3mm	85 °C	UL 746B
RTI, strength, 0.75mm	50 °C	UL 746B

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RTI, strength, 1.5mm	85 °C	UL 746B
RTI, strength, 3mm	85 °C	UL 746B

### Flammability

Burning Behav. at 1.5mm nom. thickn. Thickness tested	HB class 1.5 mm	IEC 60695-11-10 IEC 60695-11-10
UL recognition	yes -	UL 94
Burning Behav. at thickness h Thickness tested	HB class 3 mm	IEC 60695-11-10 IEC 60695-11-10
UL recognition	yes -	UL 94
Oxygen index	20 %	ISO 4589-1/-2
FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	51 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Relative permittivity, 100Hz	5.7 -	IEC 62631-2-1
Relative permittivity, 1MHz	5 -	IEC 62631-2-1
Dissipation factor, 100Hz	550 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	530 E-4	IEC 62631-2-1
Volume resistivity	4E9 Ohm.m	IEC 62631-3-1
Surface resistivity	2E13 Ohm	IEC 62631-3-2
Electric strength	17 kV/mm	IEC 60243-1

### Other properties

Density	1180 kg/m <sup>3</sup>	ISO 1183
Density of melt	1030 kg/m <sup>3</sup>	

### Film Properties

WVTR, 23°C/85%r.h.	1900 g/(m <sup>2</sup> *d)	DIS 15106-1/-2
Oxygen transmission rate, 23°C/85%r.h.	34000 cm <sup>3</sup> /(m <sup>2</sup> *d*bar)	DIS 15105-1/-2
Thickness of specimen	0.025 mm	

### VDA Properties

Odour	4 class	VDA 270
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### Injection

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	220 °C



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Mold Temperature Optimum	40 °C
Min. mould temperature	30 °C
Max. mould temperature	40 °C

### Extrusion

Drying Temperature	≤80 °C
Drying Time, Dehumidified Dryer	2 - 3 h
Processing Moisture Content	≤0.06 %
Melt Temperature Optimum	195 °C
Melt Temperature Range	185 - 200 °C

### Additional Information

Profile extrusion

#### PREPROCESSING

Drying temperature = 80°C  
Drying time, dehumidified dryer = 2-3 h  
Processing moisture content = <0.06 %

#### PROCESSING

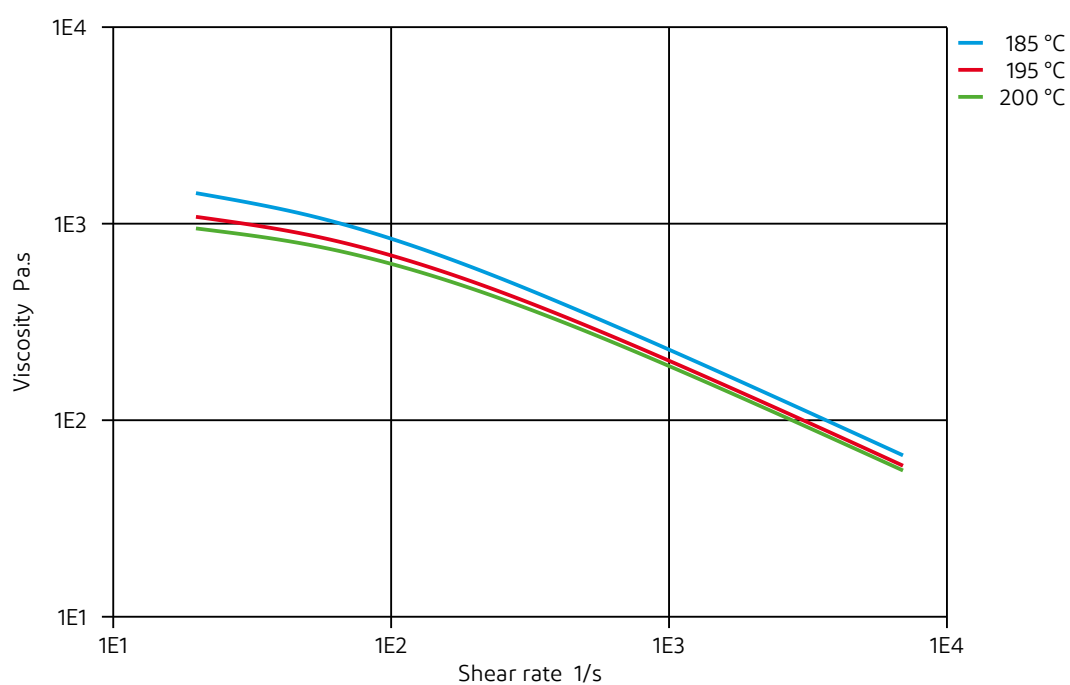
Melt temperature optimum = 195°C  
Melt temperature range = 185-200°C



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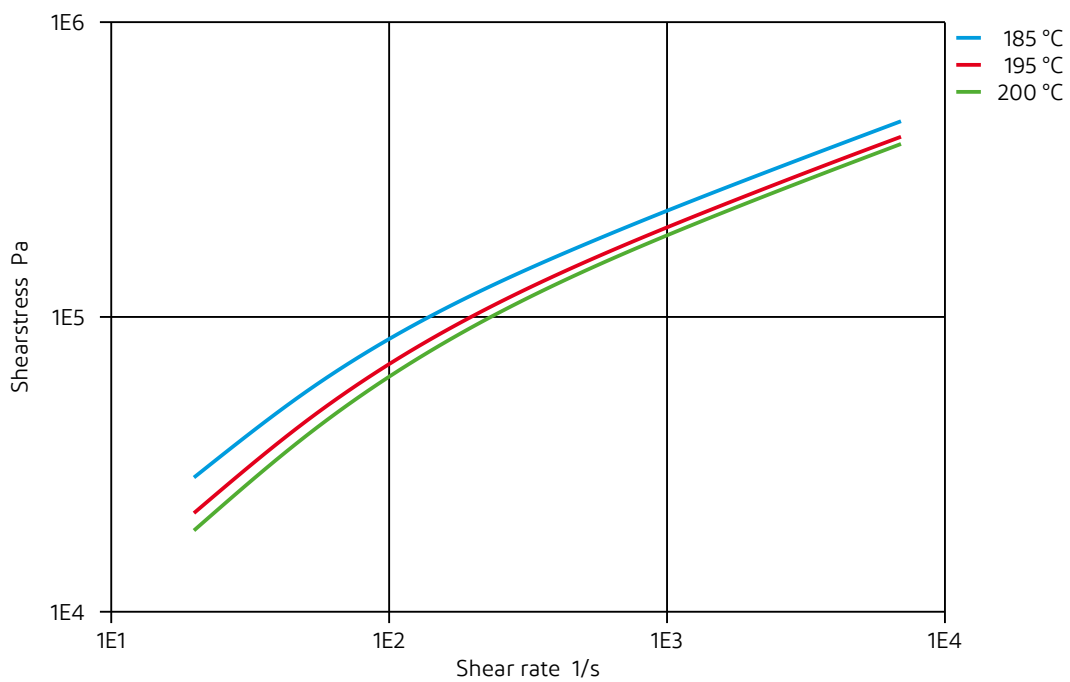
Viscosity-shear rate



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Shearstress-shear rate

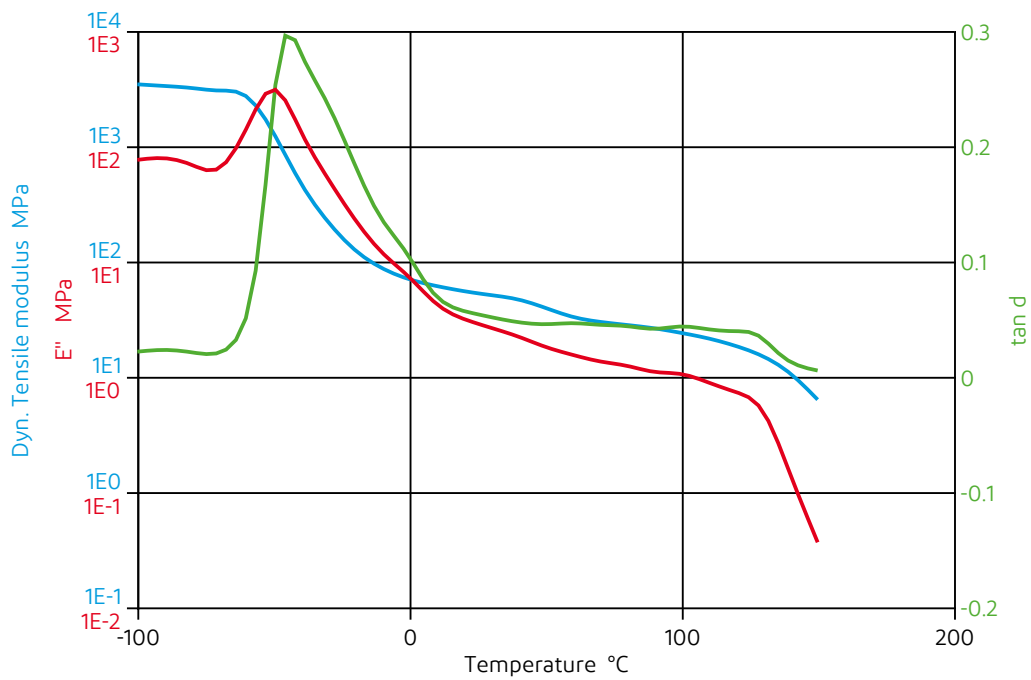




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Dynamic Tensile modulus-temperature

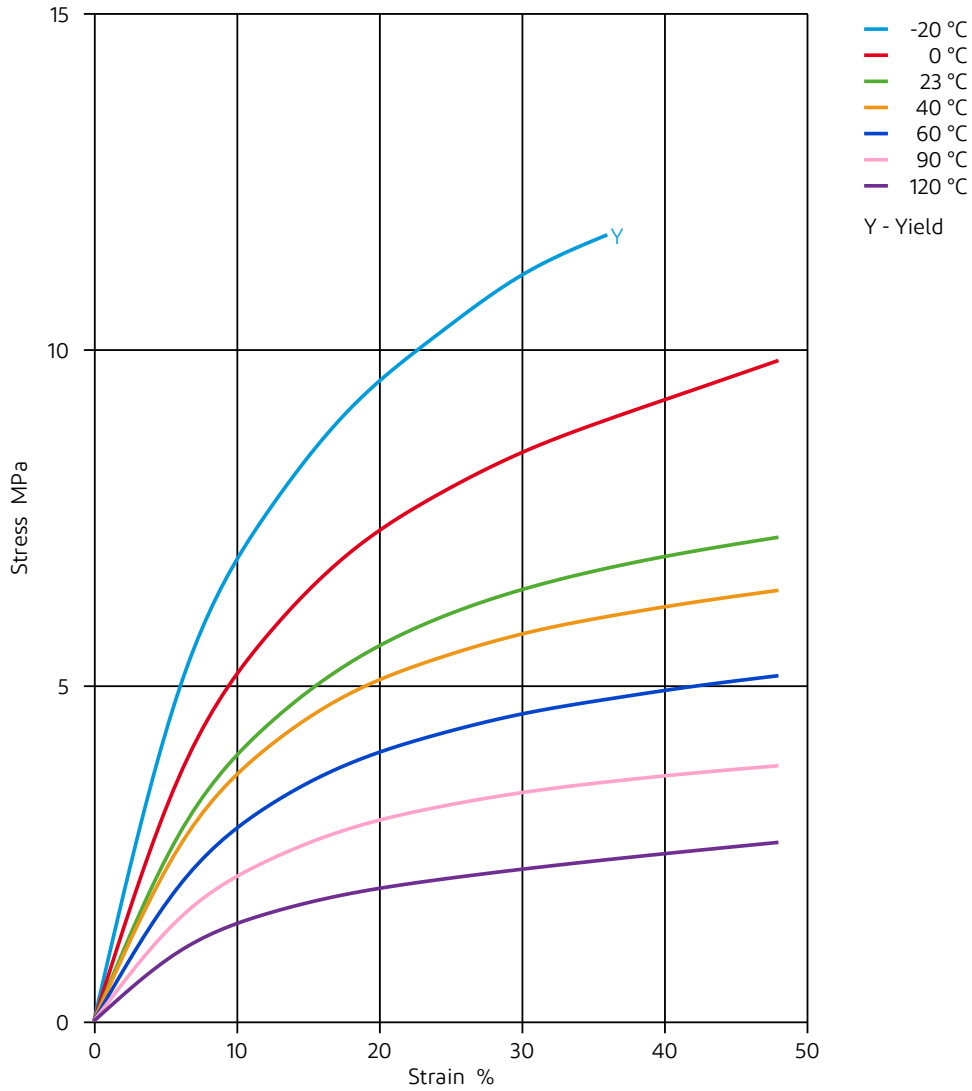




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## Stress-strain



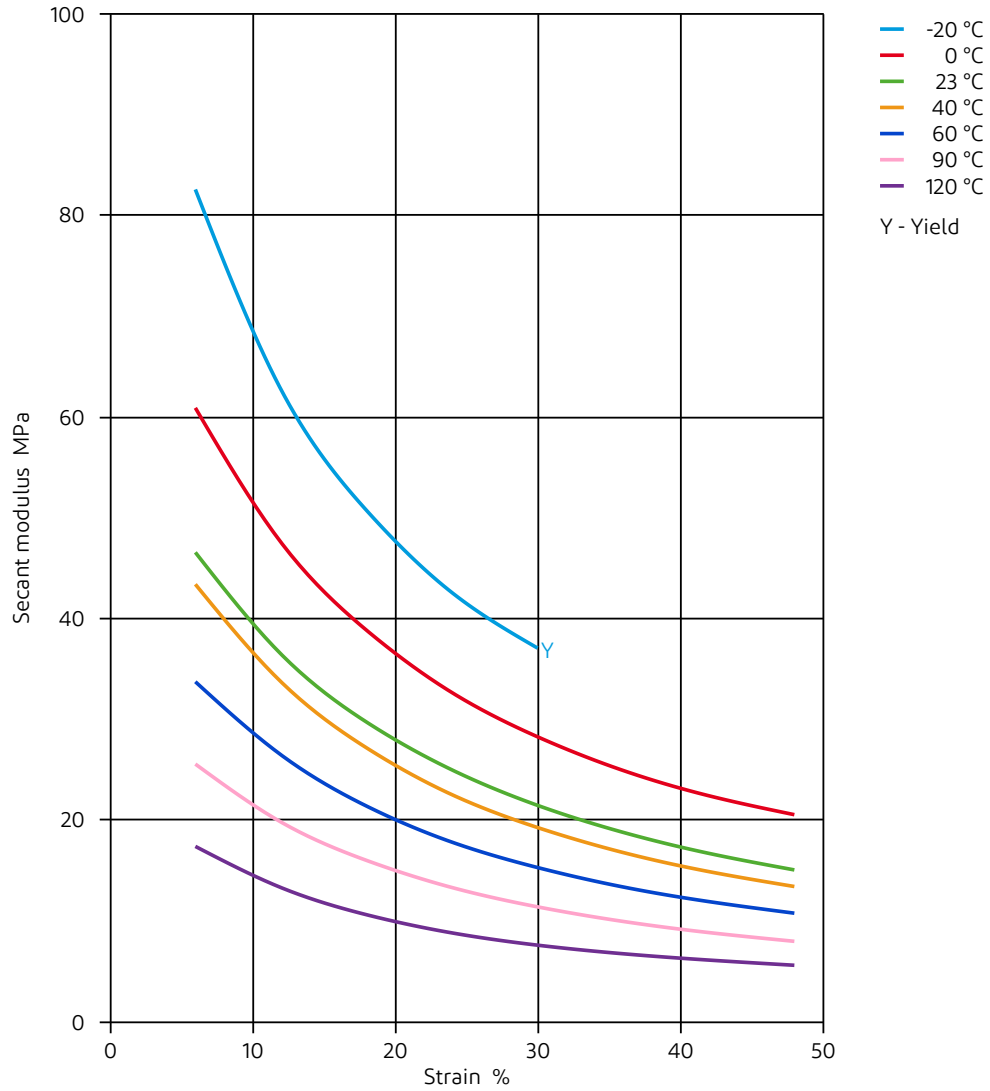




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THERMOPLASTIC POLYESTER ELASTOMER

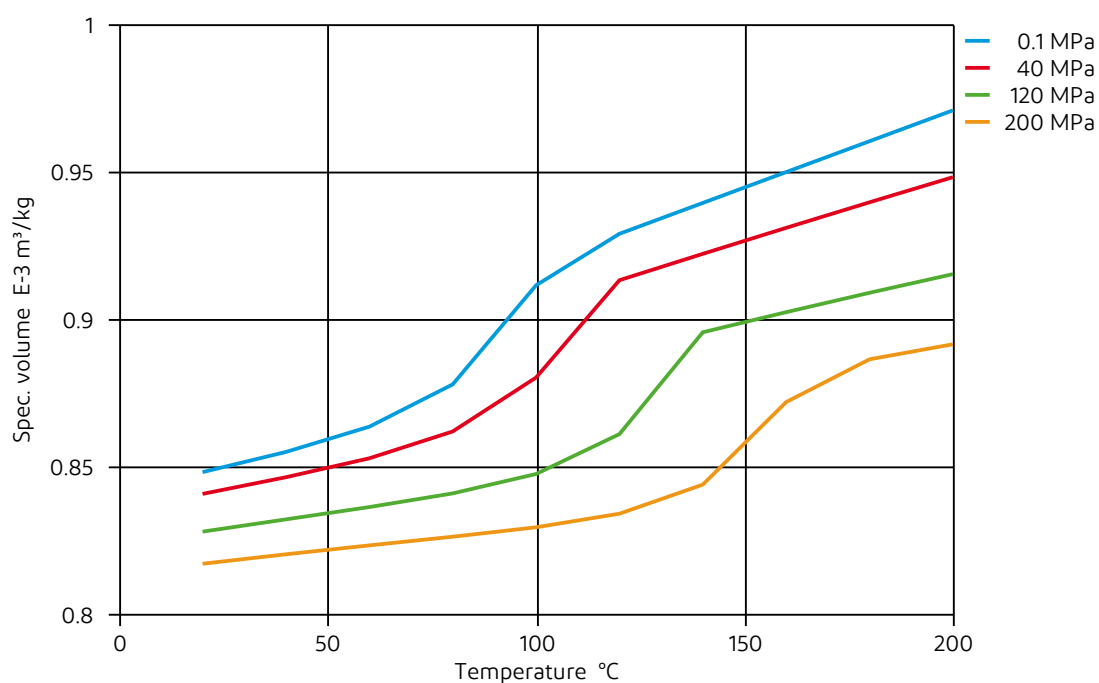
## Secant modulus-strain



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Specific volume-temperature (pvT)

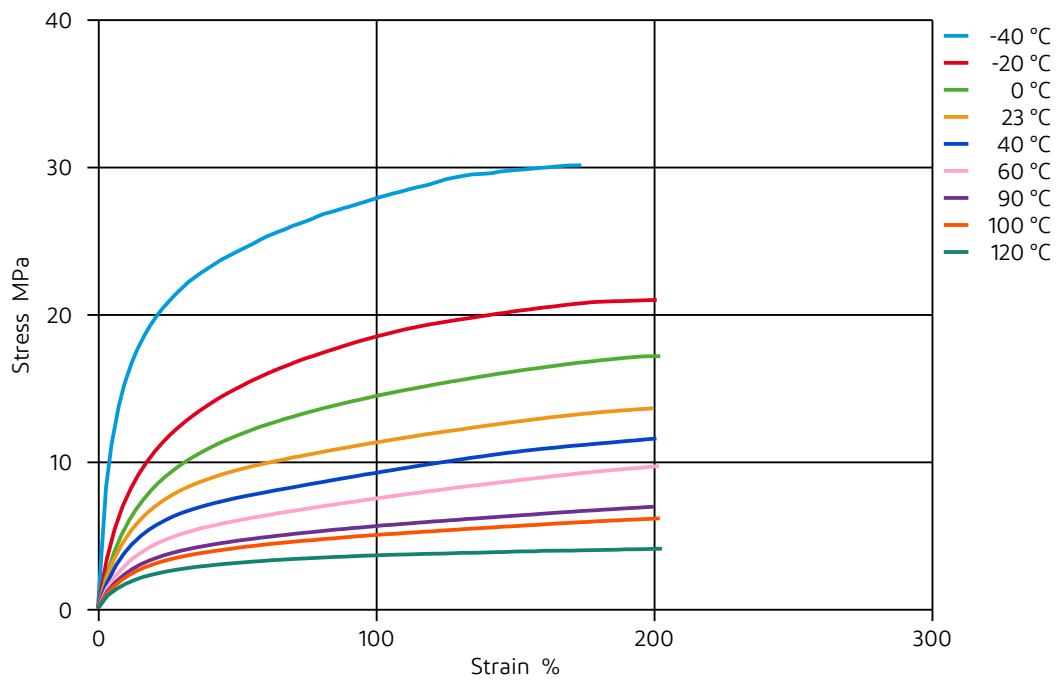




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THERMOPLASTIC POLYESTER ELASTOMER

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

#### 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

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### 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).

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