Celanese
The chemistry inside innovation™

Hytrel® 8238

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® 8238 is the highest modulus grade, with nominal hardness of 82D. It contains non-discoloring stabilizer. It can be processed by many conventional thermoplastic processing techniques like injection molding and extrusion.

Typical applications:
Cubing, wire and cable, gears, sprockets, electrical connectors and oil field parts.

Product information

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

Rheological properties

Melt volume-flow rate	12	cm^3/10min	ISO 1133
Temperature	240	°C	
Load	2.16	kg	
Melt mass-flow rate	12	g/10min	ISO 1133
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

Typical mechanical properties

Tensile modulus	1200	MPa	ISO 527-1/-2
Tensile stress at yield	38	MPa	ISO 527-1/-2
Tensile strain at yield	19	%	ISO 527-1/-2
Stress at 10% strain	34	MPa	ISO 527-1/-2
Tensile stress at 50% strain, 1BA	28	MPa	ISO 527-1/-2
Tensile stress at 100% strain	26	MPa	ISO 527-1/-2
Tensile stress at break	46	MPa	ISO 527-1/-2
Nominal strain at break	340	%	ISO 527-1/-2
Tensile strain at break	>300	%	ISO 527-1/-2
Flexural modulus	1150	MPa	ISO 178
Flexural strength	35	MPa	ISO 178
Charpy notched impact strength, 23°C	10	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	5	kJ/m^2	ISO 179/1eA

Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Charpy notched impact strength, -40 °C	5	kJ/m²	ISO 179/1eA
Tensile notched impact strength, 23 °C	57	kJ/m²	ISO 8256/1
Izod notched impact strength, 23 °C	11	kJ/m²	ISO 180/1A
Izod notched impact strength, -40 °C	5.5	kJ/m²	ISO 180/1A
Poisson's ratio	0.44		
Brittleness temperature	-84	°C	ISO 974
Shore D hardness, 15s	70		ISO 48-4 / ISO 868
Shore D hardness, max	76		ISO 868
Tear strength, parallel	230	kN/m	ISO 34-1
Tear strength, normal	210	kN/m	ISO 34-1

Thermal properties

Melting temperature, 10 °C/min	221	°C	ISO 11357-1/-3
Glass transition temperature, 10 °C/min	45	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	45	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	105	°C	ISO 75-1/-2
Vicat softening temperature, 50 °C/h 50N	150	°C	ISO 306
Vicat softening temperature, 50 °C/h 10N	213	°C	ISO 306
Coeff. of linear therm. expansion, parallel, -40-23 °C	90	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	150	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23 °C	100	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	140	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.15	W/(m K)	ISO 22007-2
Effective thermal diffusivity, flow	5.44E-8	m²/s	ISO 22007-4
Specific heat capacity of melt	2150	J/(kg K)	ISO 22007-4
RTI, electrical, 0.75mm	50	°C	UL 746B
RTI, electrical, 1.5mm	90	°C	UL 746B
RTI, electrical, 3.0mm	90	°C	UL 746B
RTI, impact, 0.75mm	50	°C	UL 746B
RTI, impact, 1.5mm	85	°C	UL 746B
RTI, impact, 3.0mm	85	°C	UL 746B
RTI, strength, 0.75mm	50	°C	UL 746B
RTI, strength, 1.5mm	85	°C	UL 746B
RTI, strength, 3.0mm	85	°C	UL 746B
TGA curve	available		ISO 11359-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.91	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Oxygen index	22	%	ISO 4589-1/-2
FMVSS Class	SE		ISO 3795 (FMVSS 302)

Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Electrical properties

Relative permittivity, 100Hz	4		IEC 62631-2-1
Relative permittivity, 1MHz	3.7		IEC 62631-2-1
Dissipation factor, 100Hz	100	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	175	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	21	kV/mm	IEC 60243-1
Comparative tracking index	600		IEC 60112

Physical/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	1280	kg/m³	ISO 1183
Density of melt	1130	kg/m³	

VDA Properties

Emission of organic compounds	550	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	250	°C
Min. melt temperature	240	°C
Max. melt temperature	260	°C
Mold Temperature Optimum	50	°C
Min. mould temperature	45	°C
Max. mould temperature	55	°C
Hold pressure range	≤70	MPa
Ejection temperature	159	°C

Extrusion

Drying Temperature	100 - 120	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.06	%
Melt Temperature Range	235 - 250	°C

Characteristics

Processing	Injection Moulding, Film Extrusion, Extrusion, Sheet Extrusion, Other Extrusion, Casting, Thermoforming
Delivery form	Pellets
Special characteristics	Light stabilised or stable to light

Celanese
The chemistry inside innovation™

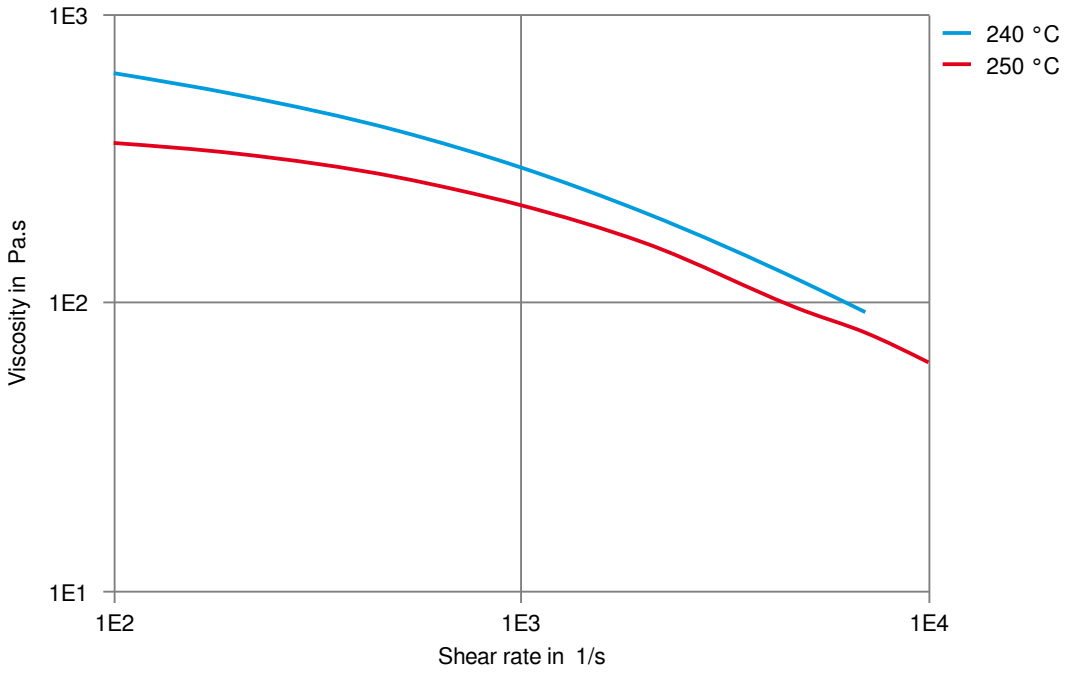
Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	GMW17327P-TPC-ET-Type 6	
Mercedes-Benz	DBL5562.50 TPC	
Stellantis - Chrysler	MS-DB-448 / CPN-3831	Natural

Viscosity-shear rate

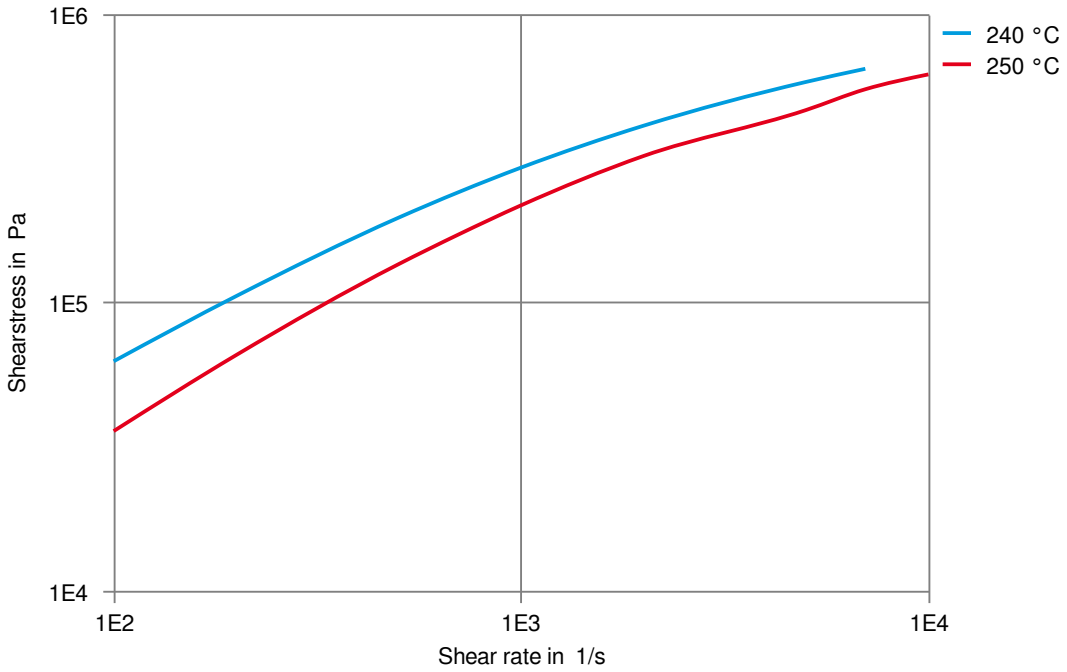


Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Shearstress-shear rate

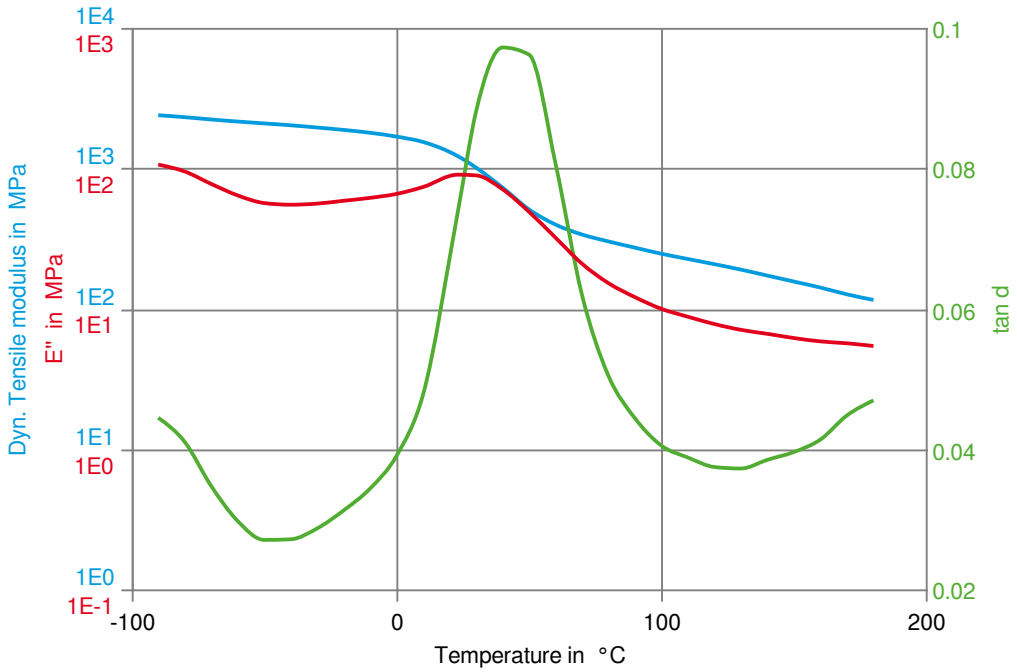


Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Dynamic Tensile modulus-temperature

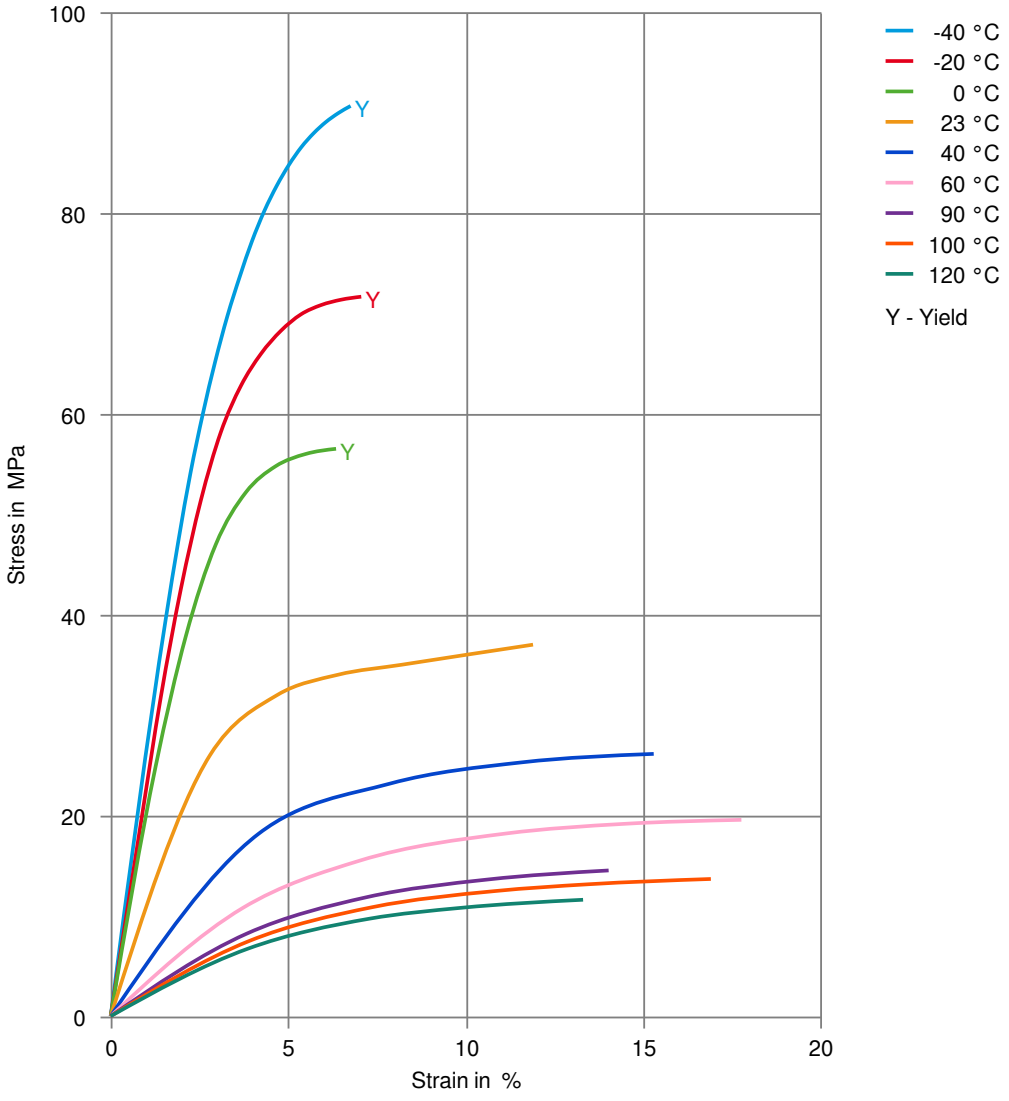


Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Stress-strain

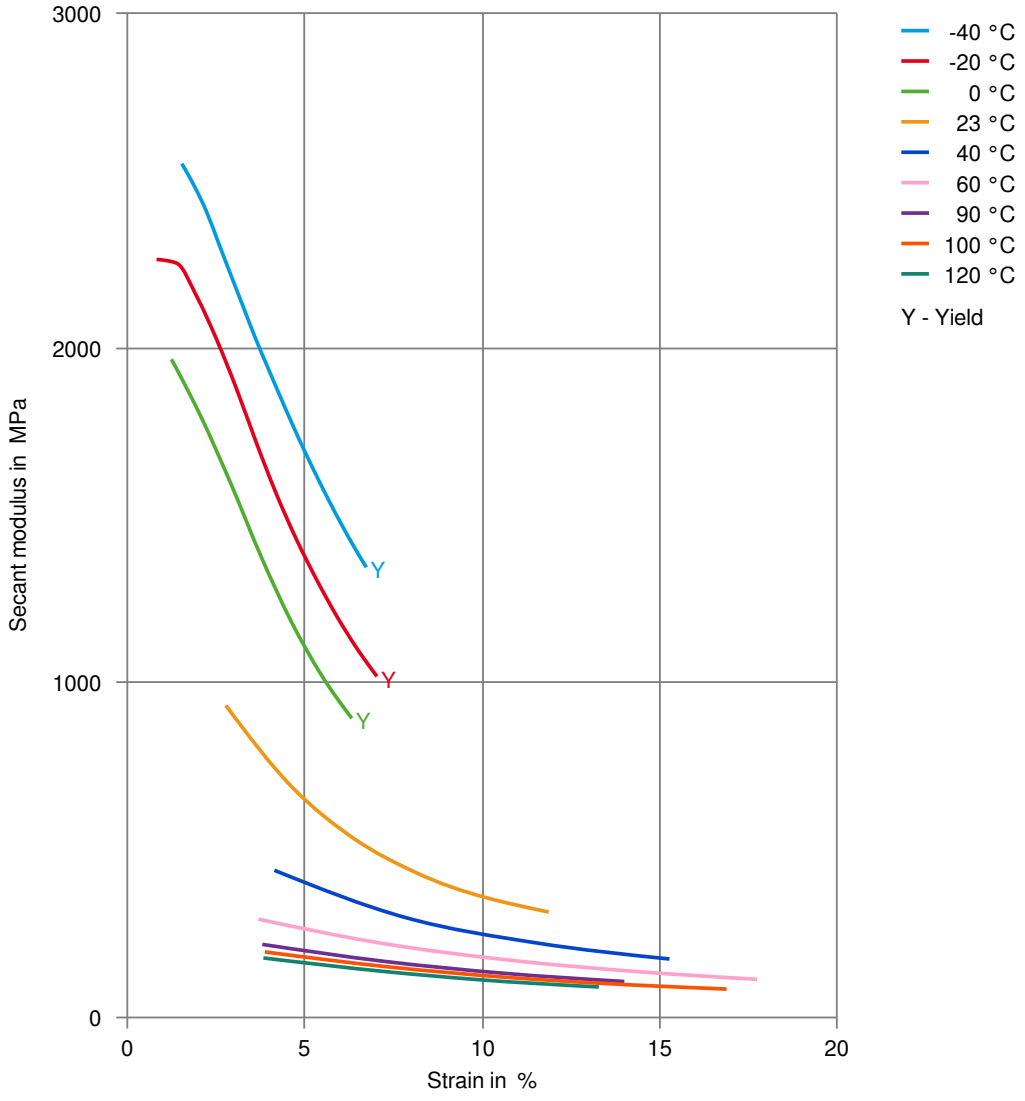


Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Secant modulus-strain

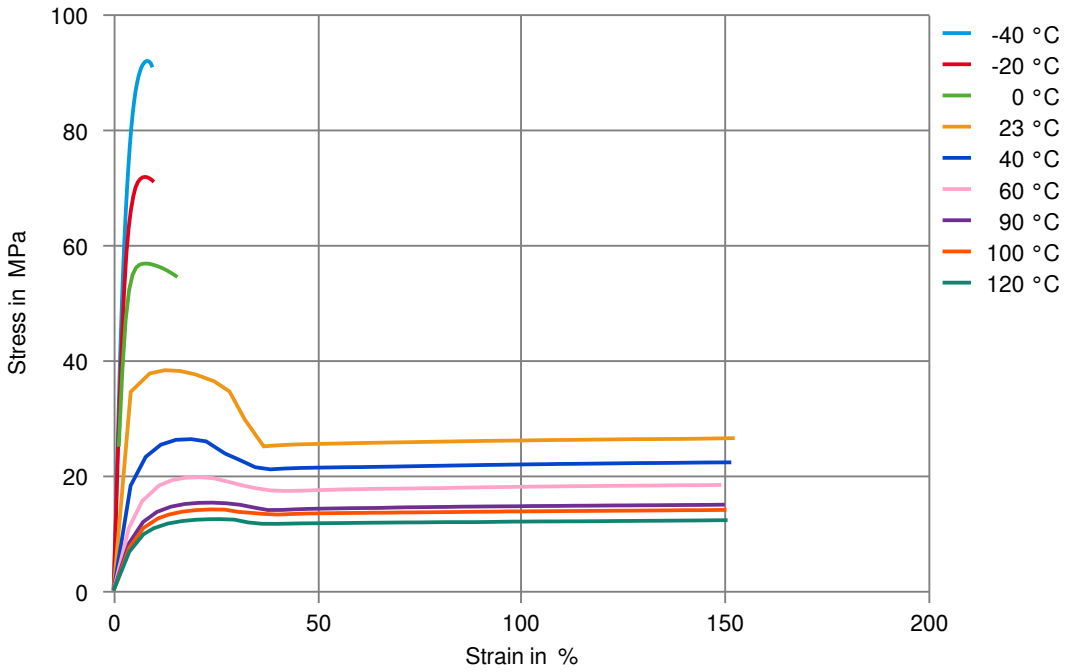


Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

Stress-Strain (Flexible Materials)



Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

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

Salt solutions

- ✔ Sodium Chloride solution (10% by mass), 23°C
- ✘ Sodium Hypochlorite solution (10% by mass), 23°C

Celanese
The chemistry inside innovation™

Hytrel® 8238

THERMOPLASTIC POLYESTER ELASTOMER

- ✔ 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).

Revised: 2025-04-17 Source: Celanese Materials Database