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Hytrel® HTR8813 BK320

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® HTR8813 BK320 is a medium hardness halogen-free flame retarded thermoplastic elastomer with very good flammability performance. It can be processed by thermoplastic techniques such as injection moulding and extrusion.

Product information

Resin Identification	TPC-ET-FR(40+30)	ISO 1043
Part Marking Code	>TPC-ET-FR(40+30)<	ISO 11469

Rheological properties

Melt mass-flow rate	15	g/10min	ISO 1133
Melt mass-flow rate, Temperature	230	°C	
Melt mass-flow rate, Load	2.16	kg	
Moulding shrinkage, parallel	1.3	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	372	MPa	ISO 527-1/-2
Stress at 10% strain	11	MPa	ISO 527-1/-2
Tensile stress at break	11.2	MPa	ISO 527-1/-2
Tensile strain at break	126	%	ISO 527-1/-2
Flexural modulus	359	MPa	ISO 178
Charpy notched impact strength, -40°C	4.7	kJ/m²	ISO 179/1eA
Shore D hardness, 15s	55		ISO 48-4 / ISO 868
Shore D hardness, max	58		ISO 868
Tear strength, parallel	85	kN/m	ISO 34-1
Tear strength, normal	85	kN/m	ISO 34-1

Thermal properties

Melting temperature, 10°C/min	200	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	-30	°C	ISO 11357-1/-3
Vicat softening temperature, 50°C/h 10N	164	°C	ISO 306

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Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	IEC 60695-11-10
UL recognition	yes		UL 94
Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	IEC 60695-11-10
Oxygen index	49	%	ISO 4589-1/-2
Glow Wire Ignition Temperature, 2.0mm	700	°C	IEC 60695-2-13
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	mm/min	ISO 3795 (FMVSS 302)

Electrical properties

Electric Strength, Short Time, 3.2mm (0.126in)	17.5	kV/mm	ASTM D 149

Physical/Other properties

Density	1240	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	230	°C
Min. melt temperature	220	°C
Max. melt temperature	240	°C
Mold Temperature Optimum	45	°C
Min. mould temperature	40	°C
Max. mould temperature	50	°C
Ejection temperature	151	°C

Extrusion

Drying Temperature	100	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.06	%
Melt Temperature Range	220 - 235	°C

Characteristics

Processing	Injection Moulding, Film Extrusion, Extrusion, Sheet Extrusion, Extrusion - Wire and Cable, Other Extrusion
Delivery form	Pellets
Additives	Flame retardant, Non-halogenated/Red phosphorous free flame retardant
Special characteristics	Flame retardant, Light stabilised or stable to light, U.V. stabilised or stable to weather, Heat stabilised or stable to heat

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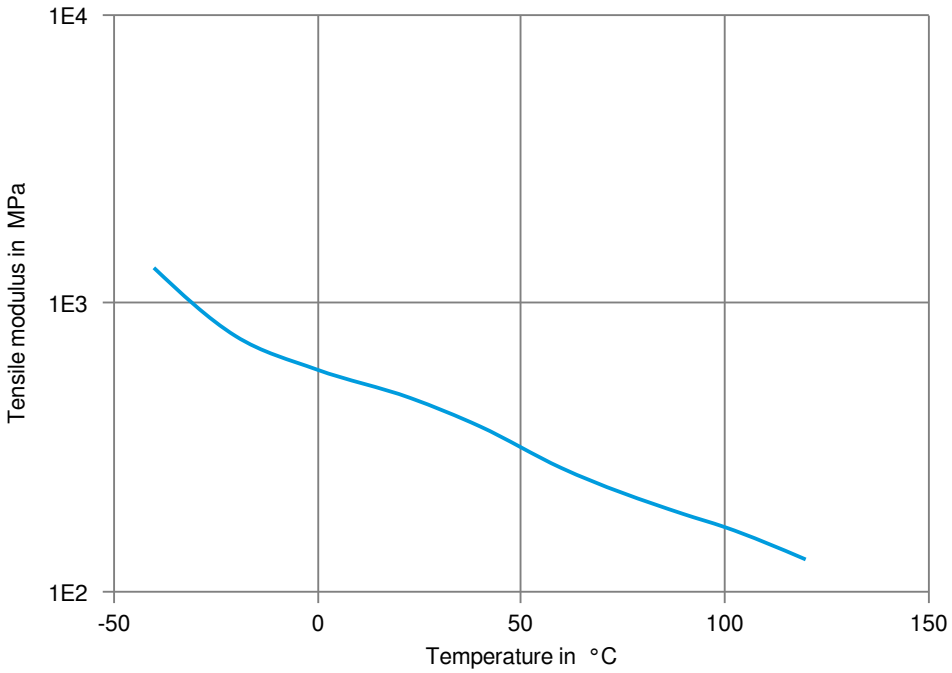
Tensile modulus-temperature



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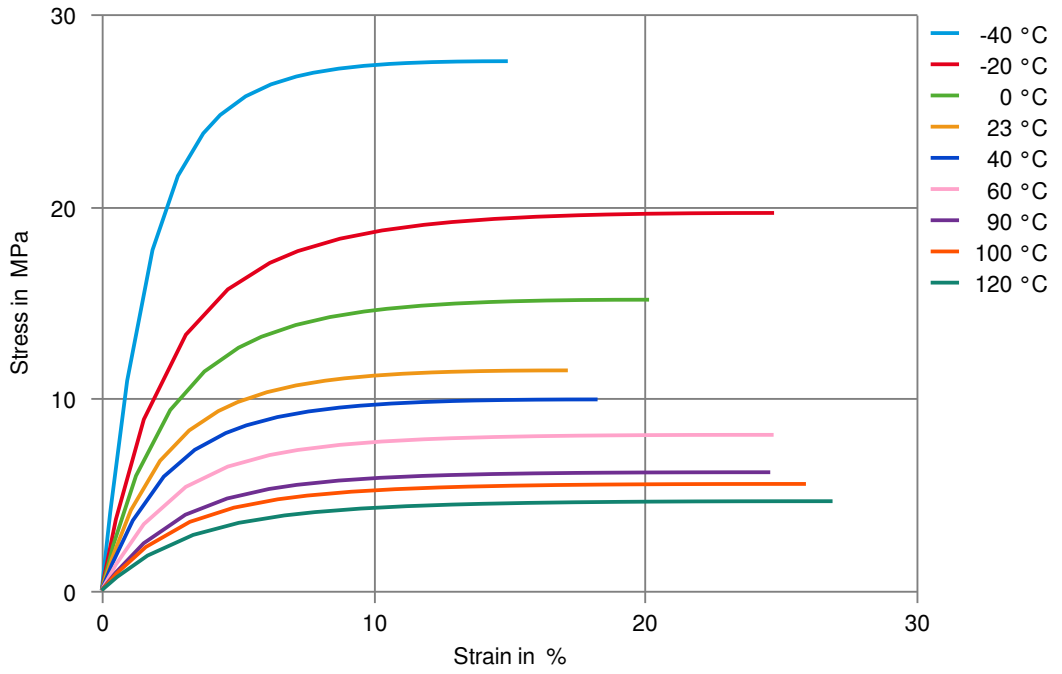
Stress-Strain (Flexible Materials)



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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
- ✔ Hydraulic oil Pentosin CHF 202, 125°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
- ✔ 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: 2025-04-22 Source: Celanese Materials Database