



# Hytrel® G4078 NC010

## 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 moulding 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® G4078 is a low modulus grade with nominal hardness of 40D. It contains non-discoloring stabilizer. It can be processed many conventional thermoplastic processing techniques like injection molding and extrusion.

### Product information

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

### Rheological properties

Moulding shrinkage, parallel	0.5 %	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 %	ISO 294-4, 2577

### 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	4.2 MPa	ISO 527-1/-2
Stress at 50% strain	8.5 MPa	ISO 527-1/-2
Stress at break	16 MPa	ISO 527-1/-2
Nominal strain at break	250 %	ISO 527-1/-2
Strain at break	220 %	ISO 527-1/-2
Charpy notched impact strength, 23°C	N kJ/m <sup>2</sup>	ISO 179/1eA
Tensile notched impact strength, 23°C	260 kJ/m <sup>2</sup>	ISO 8256/1
Shore D hardness, 15s	33 -	ISO 48-4
Tear strength, normal	120 kN/m	ISO 34-1



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### Thermal properties

Melting temperature, 10°C/min	170 °C	ISO 11357-1/-3
Vicat softening temperature, 50°C/h 10N	115 °C	ISO 306
RTI, electrical, 0.75mm	50 °C	UL 746B
RTI, electrical, 1.5mm	50 °C	UL 746B
RTI, electrical, 3mm	50 °C	UL 746B
RTI, impact, 0.75mm	50 °C	UL 746B
RTI, impact, 1.5mm	50 °C	UL 746B
RTI, impact, 3mm	50 °C	UL 746B
RTI, strength, 0.75mm	50 °C	UL 746B
RTI, strength, 1.5mm	50 °C	UL 746B
RTI, strength, 3mm	50 °C	UL 746B

### 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	3 mm	IEC 60695-11-10
UL recognition	yes -	UL 94
FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Comparative tracking index, 3.0mm	600 PLC	UL 746A
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### Other properties

Humidity absorption, 2mm	0.7 %	Sim. to ISO 62
Water absorption, 2mm	6.5 %	Sim. to ISO 62
Density	1180 kg/m <sup>3</sup>	ISO 1183
Density of melt	1060 kg/m <sup>3</sup>	
Water Absorption, Immersion 24h	3.4 %	Sim. to ISO 62

### Film Properties

WVTR, 23°C/85%r.h.	2000 g/(m <sup>2</sup> *d)	DIS 15106-1/-2
Type of extrusion	blown -	
Thickness of specimen	0.025 mm	



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

## Extrusion

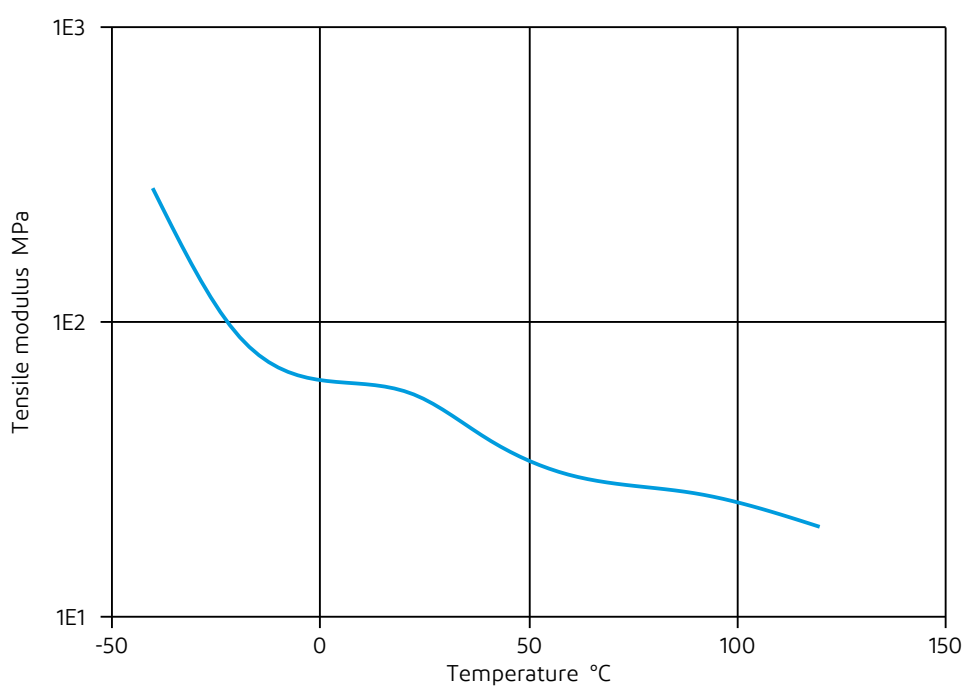
Drying Temperature	≤80 °C
Drying Time, Dehumidified Dryer	2 - 3 h
Processing Moisture Content	≤0.06 %
Melt Temperature Optimum	195 °C
Melt Temperature Range	185 - 200 °C



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THERMOPLASTIC POLYESTER ELASTOMER

Tensile modulus-temperature

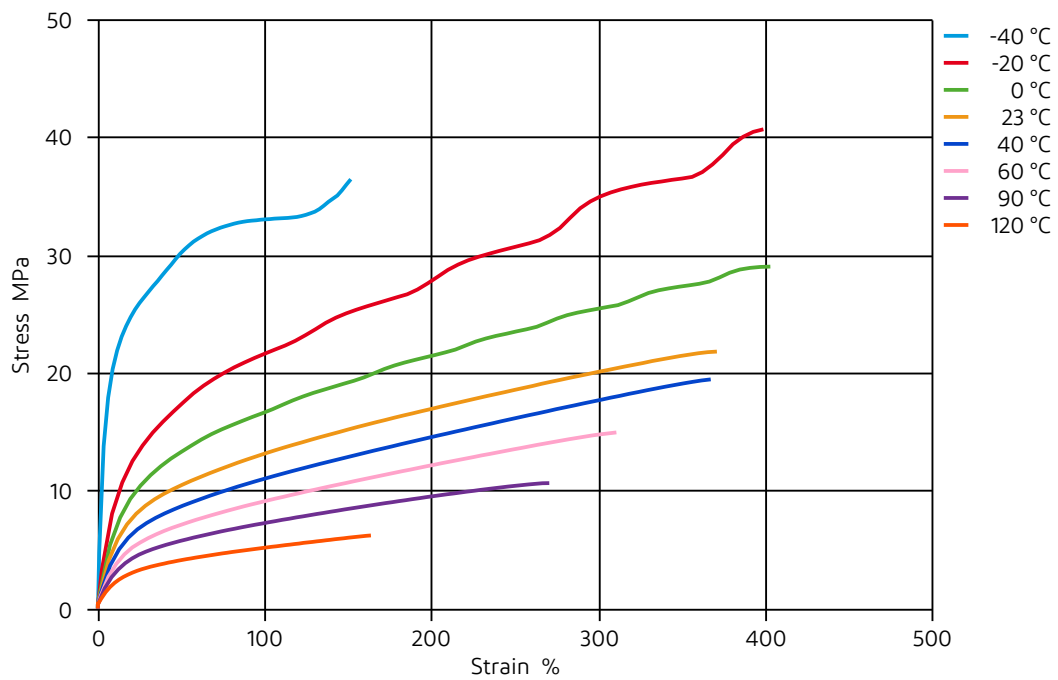




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THERMOPLASTIC POLYESTER ELASTOMER

Stress-Strain (Flexible Materials)



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## 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



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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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