DuPont™ Hytrel®

thermoplastic polyester elastomer

PRELIMINARY DATA

Hytrel® 4068FG

Hytrel® 4068FG is a high performance thermoplastic polyester elastomer with food compliance specificity.

Property	Test Method	Units	Value
Identification			
Resin Identification	ISO 1043		TPC-ET
Part Marking Code	ISO 11469		>TPC-ET<
Mechanical			
Stress at Break	ISO 527	MPa (kpsi)	22 (3.2)
Strain at Break	ISO 527	%	620
Tensile Modulus	ISO 527	MPa (kpsi)	30 (4.3)
Tensile Stress	ISO 527	MPa (kpsi)	
@ 10% Strain			3.5 (0.5)
Flexural Modulus	ISO 178	MPa (kpsi)	
-40°C (-40°F)			172 (25)
23°C (73°F)			55 (8)
100°C (212°F)			28 (4)
Tensile Impact Strength	ISO 8256	kJ/m^2	145
Notched Charpy Impact Strength	ISO 179/1eA	kJ/m^2	
-30°C (-22°F)			NB
23°C (73°F)			NB
Unnotched Charpy Impact Strength	ISO 179/1eU	kJ/m^2	
-30°C (-22°F)			NB
23°C (73°F)			NB
Tear Strength	ISO 34-1 method B/a	kN/m (lb/in)	
Parallel			95 (543)

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc
ISO Mechanical properties measured at 4.0mm, ISO Electrical properties measured at 2.0mm, and all ASTM properties measured at 3.2mm.
Test temperatures are 23°C unless otherwise stated.

The above data are preliminary and are subject to change as additional data are developed on subsequent lots.

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Property	Test Method	Units	Value
Thermal			
CLTE, Parallel	ISO 11359-1/-2	E-4/C (E-4/F)	
23 - 55°C (73 - 130°F)			2.3 (1.28)
CLTE, Normal	ISO 11359-1/-2	E-4/C (E-4/F)	
23 - 55°C (73 - 130°F)			2.3 (1.28)
Rheological			
Melt Mass-Flow Rate	ISO 1133	g/10 min	
220°C, 2.16kg			8.5
Other			
Density	ISO 1183	kg/m^3 (g/cm^3)	1100 (1.10)
Water Absorption	ISO 62	%	
Equilibrium 50%RH			0.3
Saturation, immersed			0.7
Mold Shrinkage		%	0.9
Processing - Injection Molding			
Melt Temperature Optimum		°C (°F)	225 (435)
Mold Temperature Range		°C (°F)	30-40 (85-100)
Mold Temperature Optimum		°C (°F)	40 (105)
Drying Time, Dehumidified Dryer		h	2-3
Drying Temperature		°C (°F)	100 (210)
Processing Moisture Content		%	<0.08

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