

Hytrel® HTR8888 BK190A (PRELIMINARY)

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® HTR8888 BK190A is designed for blow molding or processing techniques requiring high melt viscosity. It has nominal hardness of 55D, is pigmented black with fine particle size carbon black, and contains a general purpose stabilizer.

Typical applications:

Hollow thin wall parts requiring a tough polymer with excellent flexibility and temperature properties such as automotive ducts.

Rheological properties

Melt mass-flow rate	5.4 g/10min	ISO 1133
Melt mass-flow rate, Temperature	230 °C	
Melt mass-flow rate, Load	10 kg	

Typical mechanical properties

Tensile modulus	209 MPa	ISO 527-1/-2
Stress at 5% strain	8.2 MPa	ISO 527-1/-2
Stress at 10% strain	11.7 MPa	ISO 527-1/-2
Tensile stress at 50% strain, 1BA	16.7 MPa	ISO 527-1/-2
Tensile stress at break, 50mm/min	36 ^[1] MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	370 %	ISO 527-1/-2
Flexural modulus	214 MPa	ISO 178
Charpy notched impact strength, 23 °C	N kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30 °C	134 kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -40 °C	24.1 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.48	
Shore D hardness, 15s	53	ISO 48-4 / ISO 868
Shore D hardness, max	56	ISO 868
Tear strength, parallel	130 kN/m	ISO 34-1
Tear strength, normal	110 kN/m	ISO 34-1

[1]: molded 1BA bar, 50mm/min

Hytrel® HTR8888 BK190A (PRELIMINARY)

THERMOPLASTIC POLYESTER ELASTOMER

Thermal properties

Melting temperature, 10 °C/min	190 ^[2] °C	ISO 11357-1/-3
Glass transition temperature, 10 °C/min	-15 °C	ISO 11357-1/-3
Vicat softening temperature, 50 °C/h 10N	156 °C	ISO 306

[2]: Select the highest peak in 2nd heating

Physical/Other properties

Density	1170 kg/m ³	ISO 1183
---------	------------------------	----------

Injection

Drying Recommended	yes
Drying Temperature	100 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.08 %
Melt Temperature Optimum	240 °C
Min. melt temperature	230 °C
Max. melt temperature	250 °C
Mold Temperature Optimum	45 °C
Min. mould temperature	40 °C
Max. mould temperature	50 °C

Extrusion

Drying Temperature	80 - 110 °C
Drying Time, Dehumidified Dryer	3 - 5 h
Processing Moisture Content	≤0.03 %
Melt Temperature Optimum	235 °C
Melt Temperature Range	220 - 250 °C

Blow Molding

Drying Recommended	yes
Drying Temperature	80 - 110 °C
Drying Time, Dehumidified Dryer	3 - 5 h
Processing Moisture Content	≤0.03 %
Melt Temperature Optimum	230 °C
Melt Temperature Range	220 - 240 °C
Swell ratio	1.9
Mold Temperature Optimum	80 °C
Mold Temperature Range	40 - 90 °C

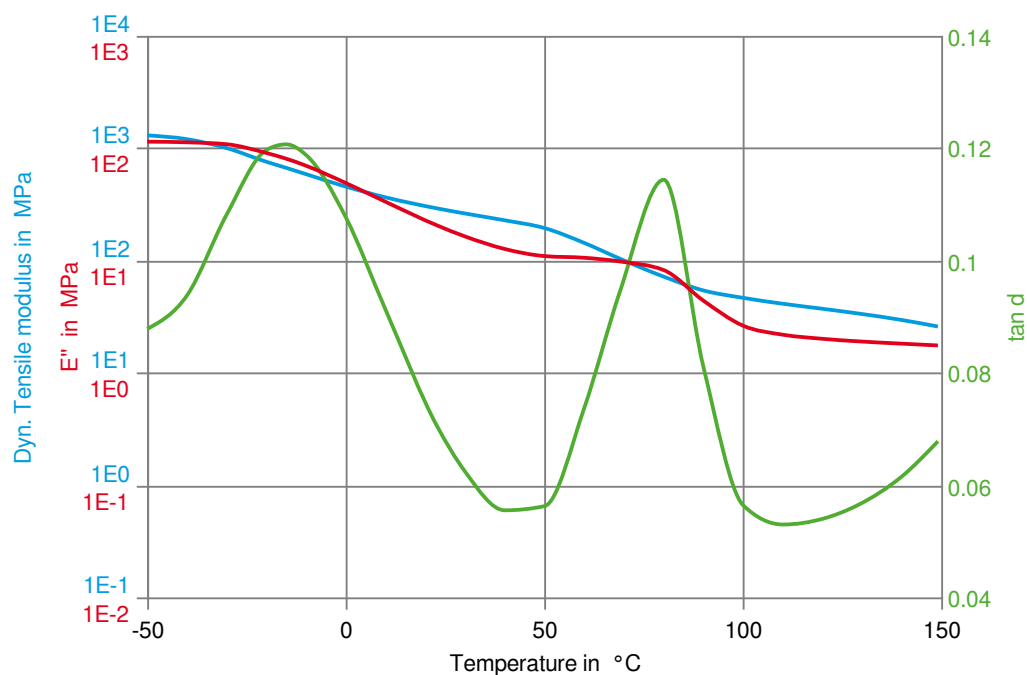
Characteristics

Processing	Injection Moulding, Extrusion, Blow Moulding, Thermoforming
Delivery form	Pellets
Special characteristics	Light stabilised or stable to light, Heat stabilised or stable to heat

Hytrel® HTR8888 BK190A (PRELIMINARY)

THERMOPLASTIC POLYESTER ELASTOMER

Dynamic Tensile modulus-temperature



Hytrel® HTR8888 BK190A (PRELIMINARY)

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
- ✗ 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

Hytrel® HTR8888 BK190A (PRELIMINARY)

THERMOPLASTIC POLYESTER ELASTOMER

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
- ✗ Coolant Glysantin G48, 1:1 in water, 125°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).

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

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may cause significant variations in data values. Properties of moulded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

© 2025 Celanese or its affiliates. All rights reserved. Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC.