



# Hytrel® 3078

## 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, 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® 3078 is a very low modulus grade, with nominal hardness of 30D. It contains non-discoloring stabilizer. It can be processed by many conventional thermoplastic processing techniques like injection molding and extrusion.

Food compliance:  
Refer to Hytrel® 3078FG

Typical applications:  
Compounding, extrusion, injection moulded and over-moulded parts for consumer use.

### Product information

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

### Rheological properties

Melt volume-flow rate	5 cm <sup>3</sup> /10min	ISO 1133
Melt mass-flow rate	5 g/10min	ISO 1133
Temperature	190 °C	ISO 1133
Load	2.16 kg	ISO 1133
Melt mass-flow rate, Temperature	190 °C	ISO 1133
Melt mass-flow rate, Load	2.16 kg	ISO 1133
Molding shrinkage, parallel	0.8 %	ISO 294-4, 2577
Molding shrinkage, normal	0.5 %	ISO 294-4, 2577



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### Typical mechanical properties

Stress at 10% strain	1.8 MPa	ISO 527-1/-2
Stress at 50% strain	5 MPa	ISO 527-1/-2
Stress at break	24 MPa	ISO 527-1/-2
Nominal strain at break	900 %	ISO 527-1/-2
Strain at break	>300 %	ISO 527-1/-2
Flexural Modulus	27 MPa	ISO 178
Tensile creep modulus, 1000h	18 MPa	ISO 899-1
Charpy impact strength, 73°F	N kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -22°F	N kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 73°F	N kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -22°F	N kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -40°F	N kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 73°F	N kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -40°F	N kJ/m <sup>2</sup>	ISO 180/1A
Brittleness temperature	-98 °C	ISO 974
Shore D hardness, 15s	26 -	ISO 48-4
Shore D hardness, max	30 -	ISO 48-4
Tear strength, parallel	80 kN/m	ISO 34-1
Tear strength, normal	77 kN/m	ISO 34-1

### Thermal properties

Melting temperature, 18°F/min	170 °C	ISO 11357-1/-3
Glass transition temperature, 18°F/min	-60 °C	ISO 11357-1/-2
Vicat softening temperature, 90°F/h, 2 lbf	80 °C	ISO 306
Coeff. of linear therm. expansion, parallel	177 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	206 E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.15 W/(m K)	
Eff. thermal diffusivity	5.44E-8 m <sup>2</sup> /s	
Spec. heat capacity of melt	2150 J/(kg K)	
RTI, electrical, 60mil	50 °C	UL 746B
RTI, electrical, 120mil	50 °C	UL 746B
RTI, impact, 60mil	50 °C	UL 746B
RTI, impact, 120mil	50 °C	UL 746B
RTI, strength, 60mil	50 °C	UL 746B
RTI, strength, 120mil	50 °C	UL 746B

### Flammability

Burning Behav. at 60mil 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



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Oxygen index	19 %	ISO 4589-1/-2
FMVSS Class	B -	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	33 mm/min	ISO 3795 (FMVSS 302)

### Electrical properties

Relative permittivity, 100Hz	5.4 -	IEC 62631-2-1
Relative permittivity, 1MHz	5.3 -	IEC 62631-2-1
Dissipation factor, 100Hz	70 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	150 E-4	IEC 62631-2-1
Volume resistivity	1E11 Ohm.m	IEC 62631-3-1
Surface resistivity	1E14 Ohm	IEC 62631-3-2
Electric strength	18 kV/mm	IEC 60243-1

### Other properties

Humidity absorption, 80mil	0.2 %	Sim. to ISO 62
Water absorption, 80mil	0.8 %	Sim. to ISO 62
Density	1070 kg/m <sup>3</sup>	ISO 1183
Density of melt	940 kg/m <sup>3</sup>	
Water Absorption, Immersion 24h	0.5 %	Sim. to ISO 62

### Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	2 - 3 h
Processing Moisture Content	≤0.08 %
Melt Temperature Optimum	205 °C
Min. melt temperature	190 °C
Max. melt temperature	210 °C
Mold Temperature Optimum	30 °C
Min. mold temperature	30 °C
Max. mold temperature	40 °C

### Extrusion

Drying Temperature	70 - 90 °C
Drying Time, Dehumidified Dryer	2 - 3 h
Processing Moisture Content	≤0.06 %
Melt Temperature Optimum	200 °C
Melt Temperature Range	190 - 205 °C

### Additional Information

Profile extrusion

### PREPROCESSING

Drying temperature = 80°C



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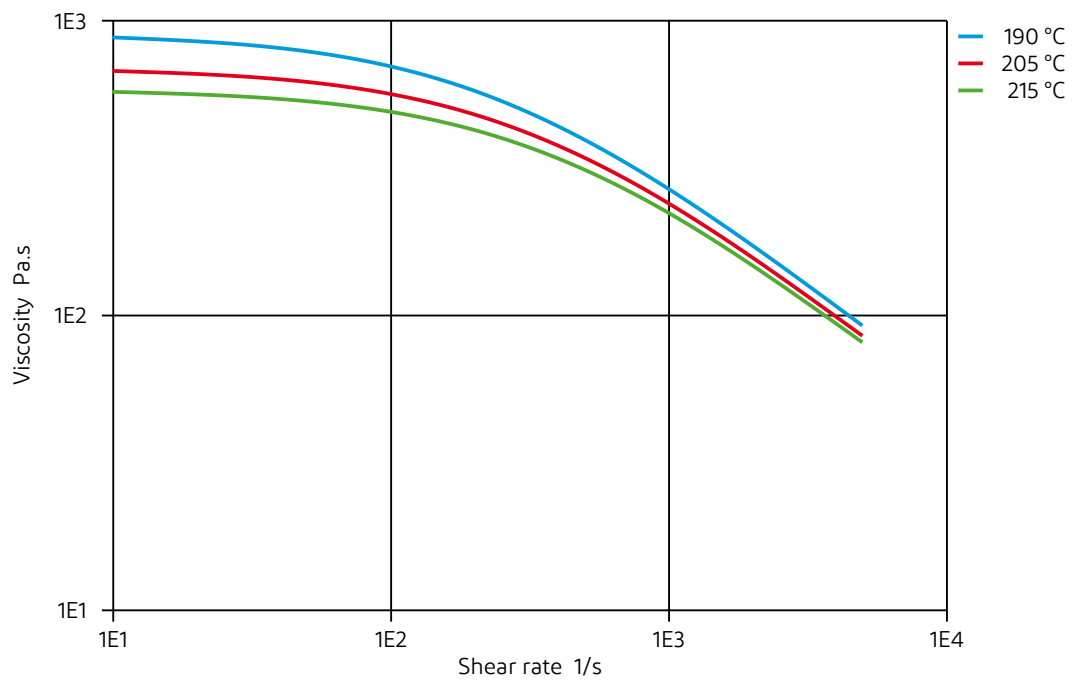
## THERMOPLASTIC POLYESTER ELASTOMER

Drying time, dehumidified dryer = 2-3 h  
Processing moisture content = <0.06 %

### PROCESSING

Melt temperature optimum = 200°C  
Melt temperature range = 190-205°C

### Viscosity-shear rate

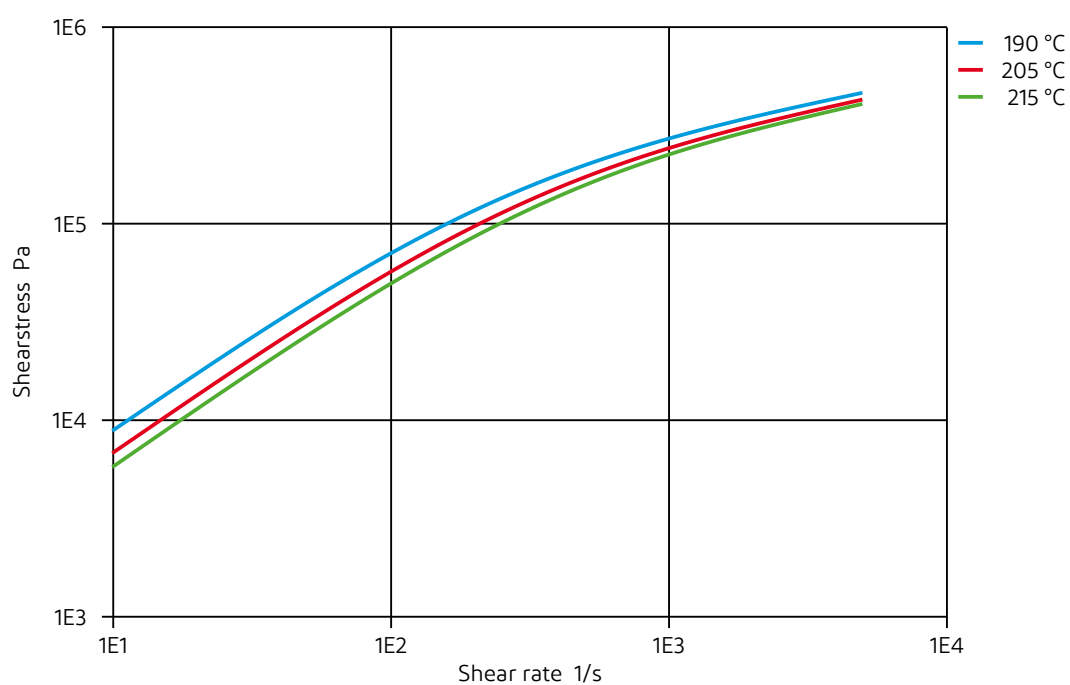




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Shearstress-shear rate

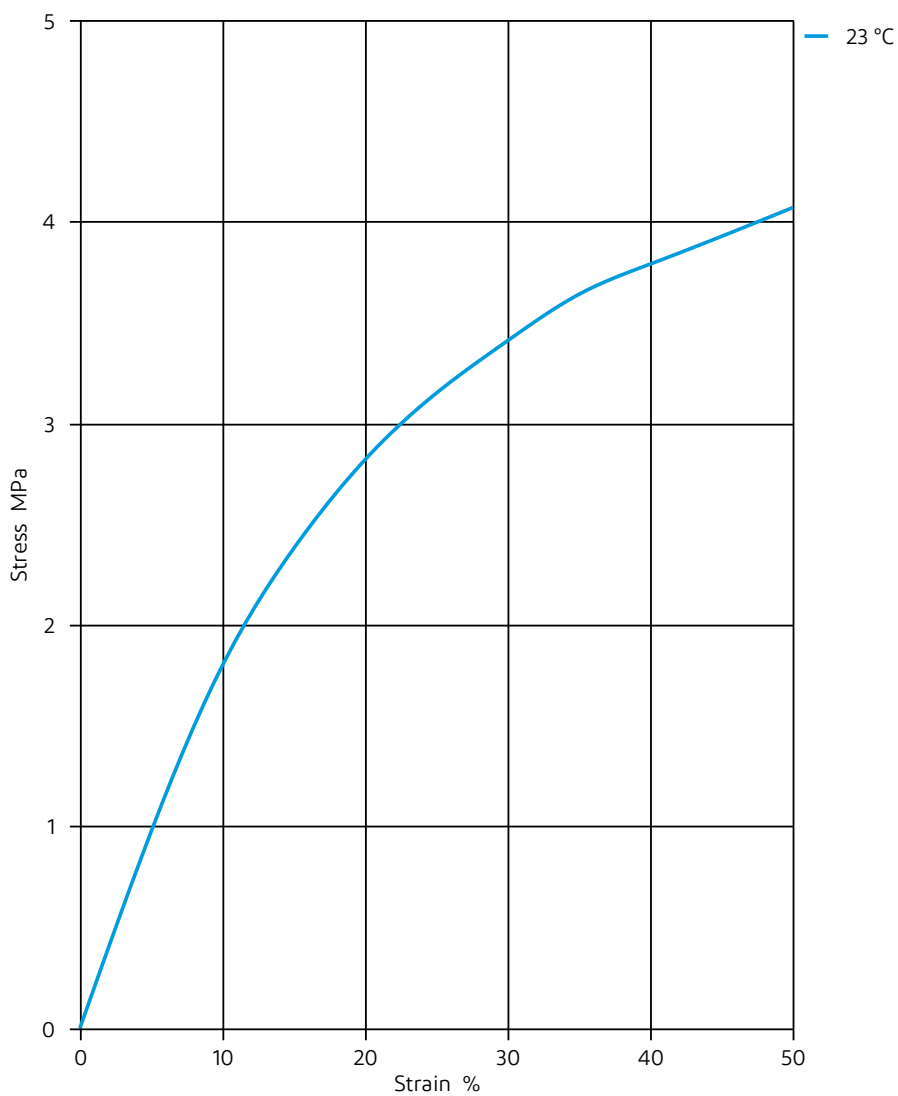




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## Stress-strain

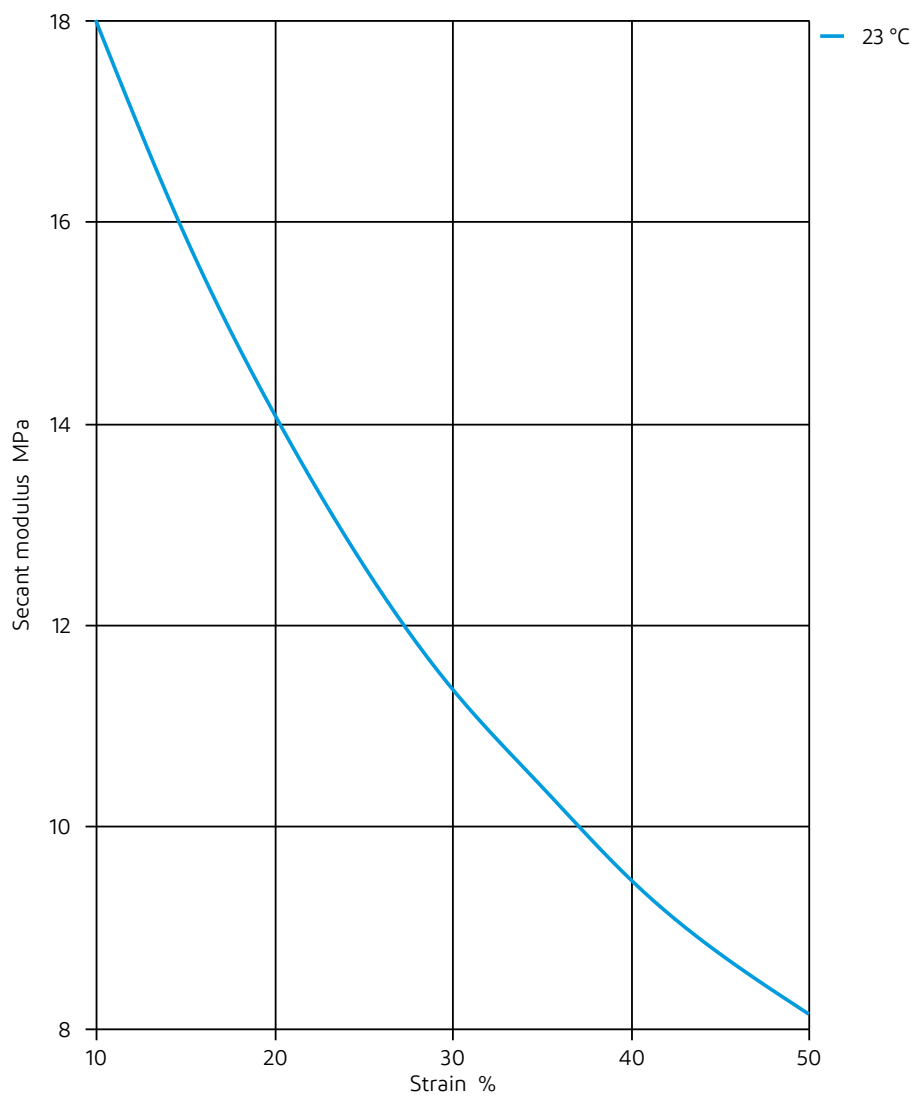




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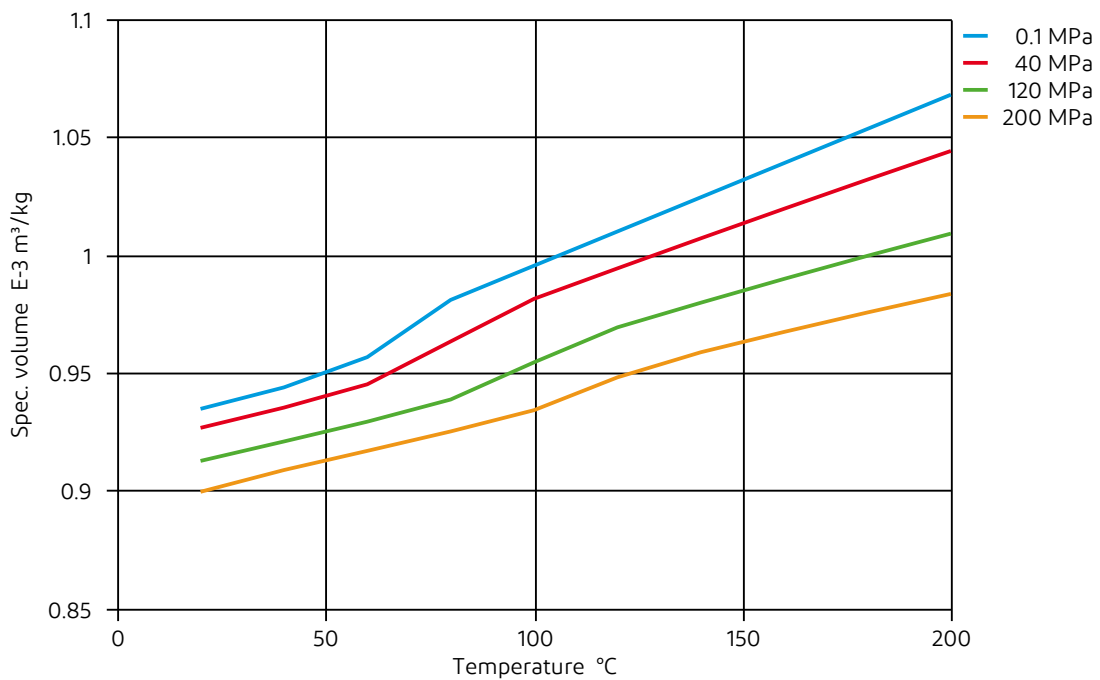
## Secant modulus-strain



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Specific volume-temperature (pvT)



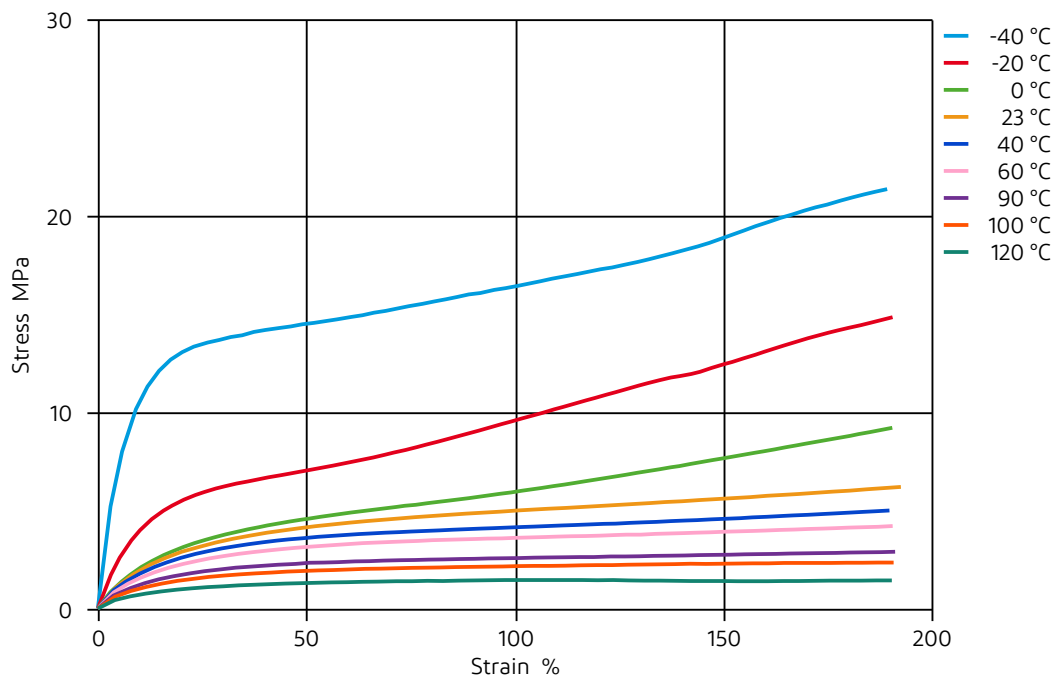




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Stress-Strain (Flexible Materials)



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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

#### 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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