Celanese
The chemistry inside innovation™

Hytrel® 7246

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® 7246 is a high modulus grade with nominal hardness of 72D. It contains non-discoloring stabilizer. It can be processed by many conventional thermoplastic processing techniques like injection molding and extrusion.

The 72 Shore D hardness is based on a legacy method and is still used for grade identification purposes.

Typical applications:

Tubing, wire and cable jackets, gears and sprockets, oil field parts.

Product information

Resin Identification	TPC-ET	ISO 1043
Part Marking Code	>TPC-ET<	ISO 11469
ISO designation	ISO 20029-TPC-ET,,GLN,70-22-075	

Rheological properties

Melt volume-flow rate	12	cm^3/10min	ISO 1133
Temperature	240	°C	
Load	2.16	kg	
Melt mass-flow rate	13	g/10min	ISO 1133
Melt mass-flow rate, Temperature	240	°C	
Melt mass-flow rate, Load	2.16	kg	
Moulding shrinkage, parallel	1.6	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.6	%	ISO 294-4, 2577

Typical mechanical properties

Tensile modulus	550	MPa	ISO 527-1/-2
Tensile stress at yield	27	MPa	ISO 527-1/-2
Tensile strain at yield	23	%	ISO 527-1/-2
Stress at 5% strain	14	MPa	ISO 527-1/-2
Stress at 10% strain	23	MPa	ISO 527-1/-2
Tensile stress at 50% strain, 1BA	24	MPa	ISO 527-1/-2
Tensile stress at break	50	MPa	ISO 527-1/-2

Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Nominal strain at break	530	%	ISO 527-1/-2
Tensile strain at break	>300	%	ISO 527-1/-2
Flexural modulus	550	MPa	ISO 178
Shear Modulus	280	MPa	ISO 6721
Tensile creep modulus, 1h	360	MPa	ISO 899-1
Tensile creep modulus, 1000h	310	MPa	ISO 899-1
Charpy notched impact strength, 23°C	36	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	8	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40°C	7	kJ/m²	ISO 179/1eA
Tensile notched impact strength, 23°C	300	kJ/m²	ISO 8256/1
Izod notched impact strength, 23°C	38	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	7.0	kJ/m²	ISO 180/1A
Poisson's ratio	0.47		
Brittleness temperature	-97	°C	ISO 974
Shore D hardness, 15s	64		ISO 48-4 / ISO 868
Shore D hardness, max	68		ISO 868
Tear strength, parallel	180	kN/m	ISO 34-1
Tear strength, normal	170	kN/m	ISO 34-1
Abrasion resistance	100	mm³	ISO 4649

Thermal properties

Melting temperature, 10°C/min	218	°C	ISO 11357-1/-3
Glass transition temperature, 1 Hz	32	°C	ISO 6721
Temperature of deflection under load, 1.8 MPa	50	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	140	°C	ISO 306
Vicat softening temperature, 50°C/h 10N	205	°C	ISO 306
Coeff. of linear therm. expansion, parallel, -40-23°C	120	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	180	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	130	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	170	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.15	W/(m K)	ISO 22007-2
Effective thermal diffusivity, flow	8E-8	m²/s	ISO 22007-4
Specific heat capacity of melt	2150	J/(kg K)	ISO 22007-4
RTI, electrical, 1.5mm	85	°C	UL 746B
RTI, impact, 1.5mm	85	°C	UL 746B
RTI, strength, 1.5mm	75	°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
Oxygen index	23	%	ISO 4589-1/-2
FMVSS Class	DNI		ISO 3795 (FMVSS 302)

Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Electrical properties

Relative permittivity, 100Hz	4		IEC 62631-2-1
Relative permittivity, 1MHz	3.5		IEC 62631-2-1
Dissipation factor, 100Hz	160	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	300	E-4	IEC 62631-2-1
Volume resistivity	2E10	Ohm.m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	20	kV/mm	IEC 60243-1
Comparative tracking index	600		IEC 60112

Physical/Other properties

Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Water absorption, 2mm	0.6	%	Sim. to ISO 62
Water absorption, Immersion 24h	0.3	%	Sim. to ISO 62
Density	1260	kg/m³	ISO 1183
Density of melt	1110	kg/m³	

VDA Properties

Light stability delta l	-3		DIN 53236
Light stability delta a	-0.1		DIN 53236
Light stability delta b	15		DIN 53236
Light stability delta E	16		DIN 53236
Emission of organic compounds	300	µgC/g	VDA 277

Injection

Drying Recommended	yes	
Drying Temperature	110	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.08	%
Melt Temperature Optimum	245	°C
Min. melt temperature	235	°C
Max. melt temperature	255	°C
Mold Temperature Optimum	50	°C
Min. mould temperature	45	°C
Max. mould temperature	55	°C
Hold pressure range	≤70	MPa
Ejection temperature	149	°C

Extrusion

Drying Temperature	100 - 120	°C
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.06	%
Melt Temperature Optimum	235	°C
Melt Temperature Range	225 - 245	°C

Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Characteristics

Processing	Injection Moulding, Film Extrusion, Extrusion, Sheet Extrusion, Other Extrusion, Casting, Thermoforming
Delivery form	Pellets
Special characteristics	Light stabilised or stable to light

Automotive

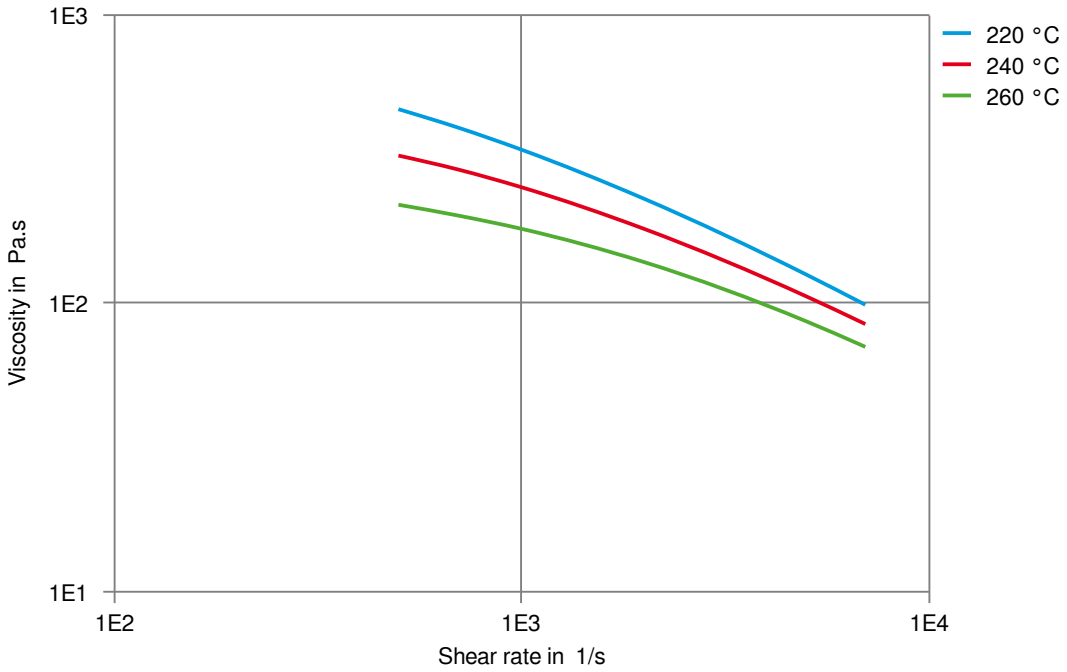
OEM	STANDARD	ADDITIONAL INFORMATION
General Motors	GMW17186P-TPC-ET-Type 2	
General Motors	GMW17327P-TPC-ET-Type 5	
Hyundai	MS220-24 Type B	
Mercedes-Benz	DBL5562.50 TPC	
Stellantis - Chrysler	MS-DB-448 / CPN-2312	Natural
Stellantis - Chrysler	MS-DB-448 / CPN-2760	Black
Stellantis - Chrysler	MS-DB-448 / CPN-5033	Natural
VW Group	VW 50123 TPC-ET 55D	

Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Viscosity-shear rate

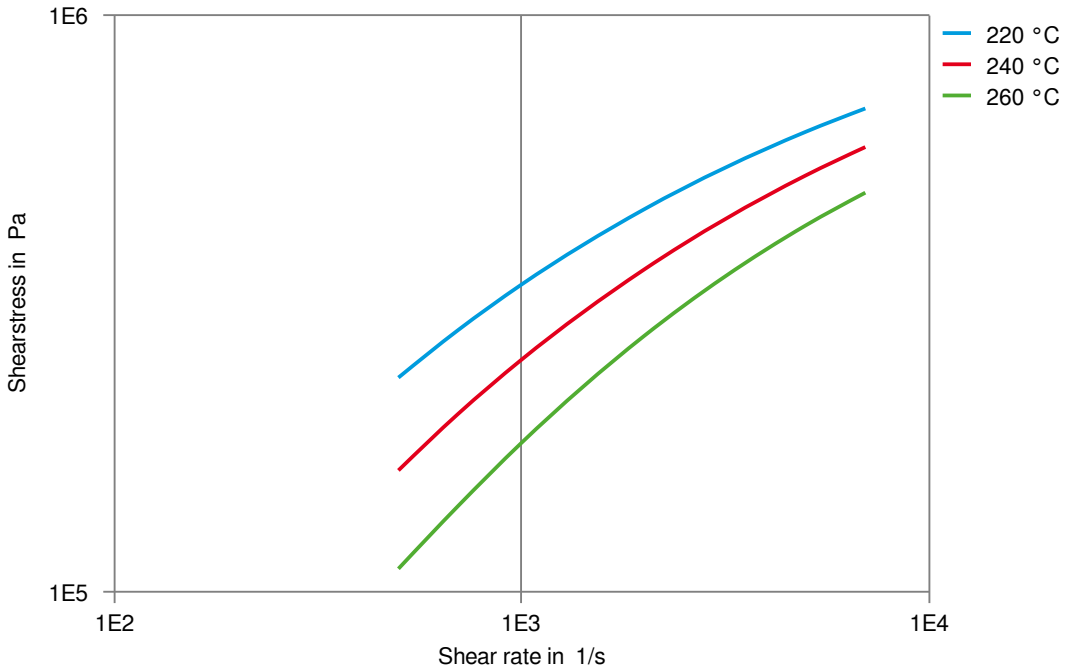


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Shearstress-shear rate

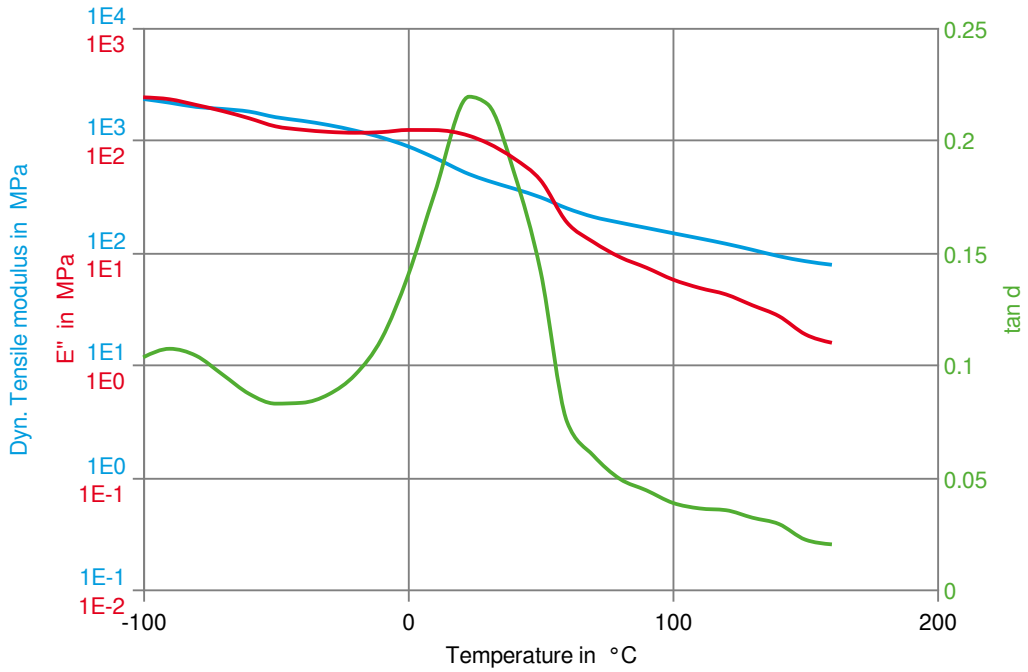


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Dynamic Tensile modulus-temperature

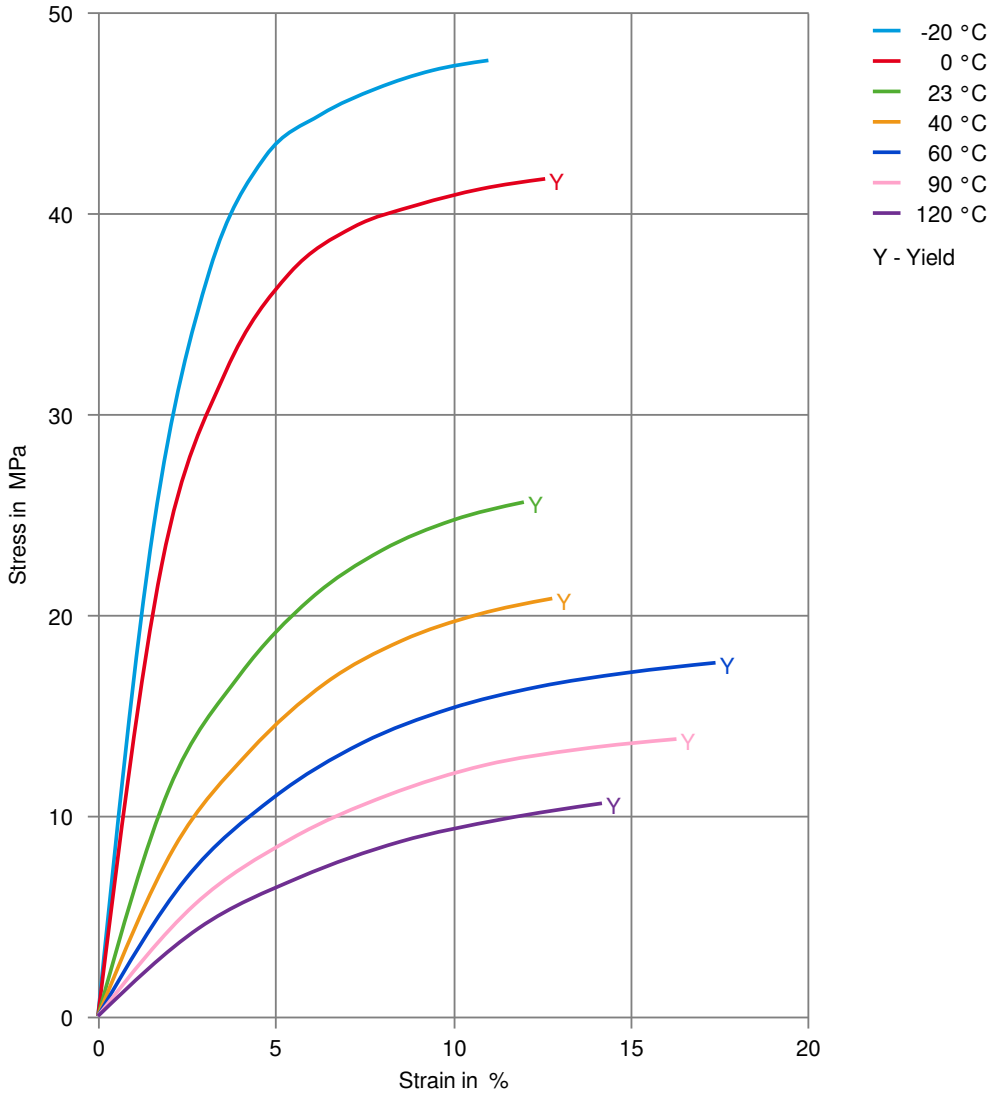


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Stress-strain

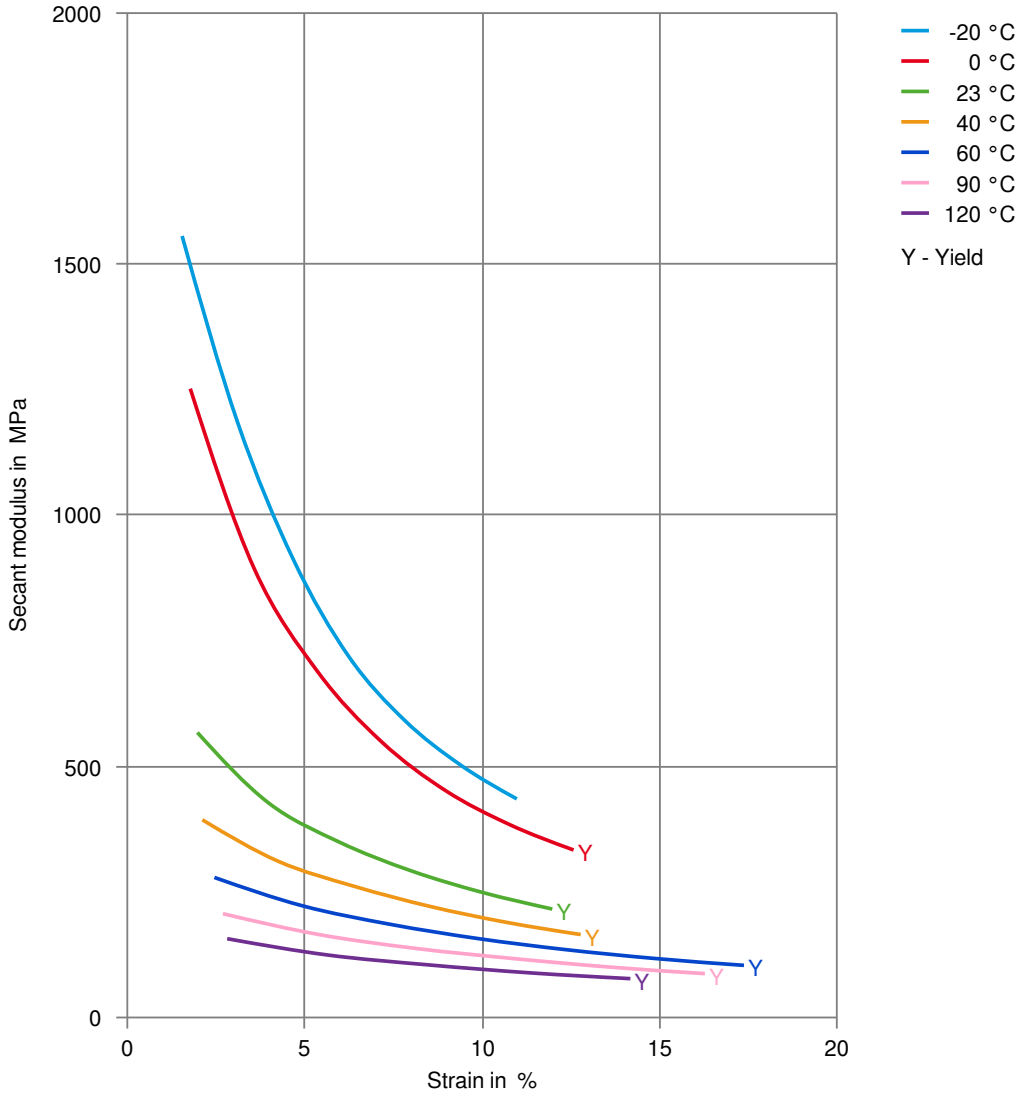


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Secant modulus-strain

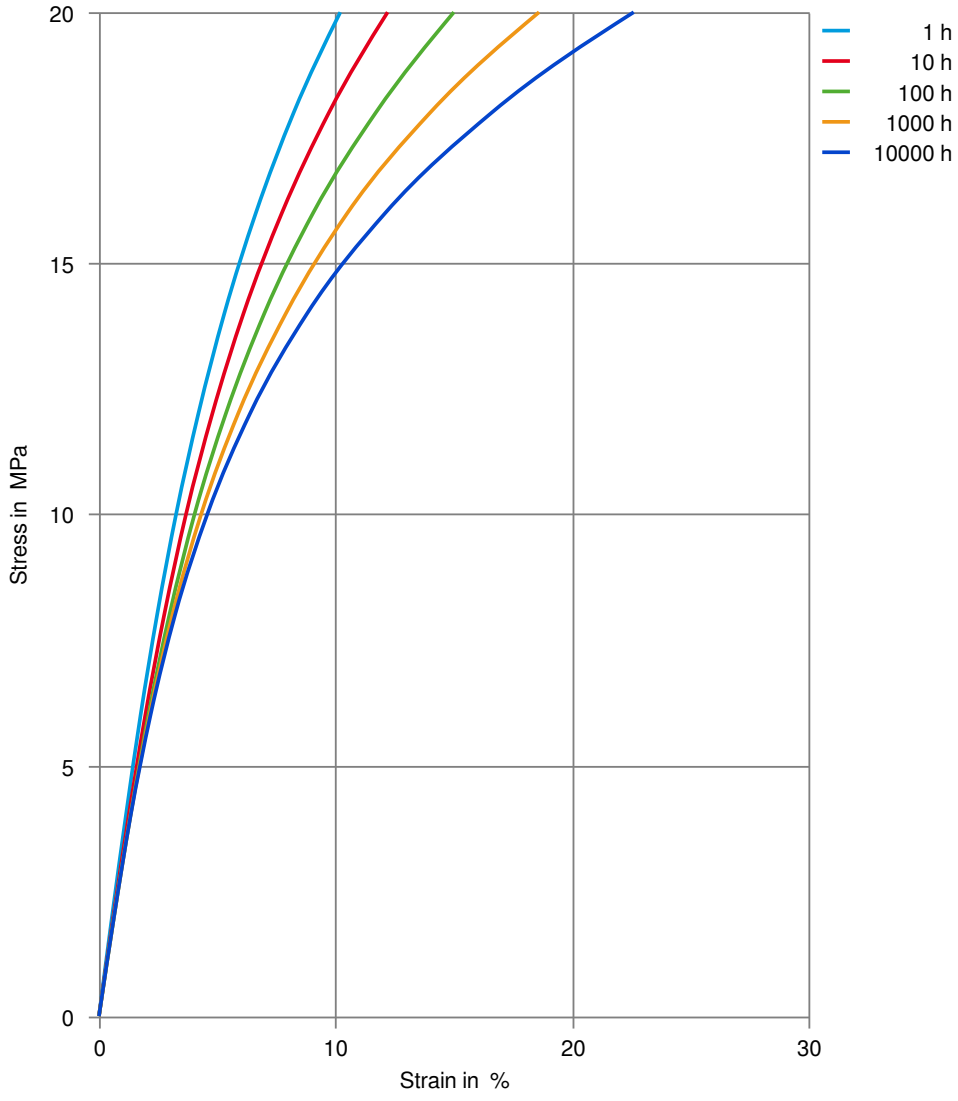


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Stress-strain (isochronous) 23 °C

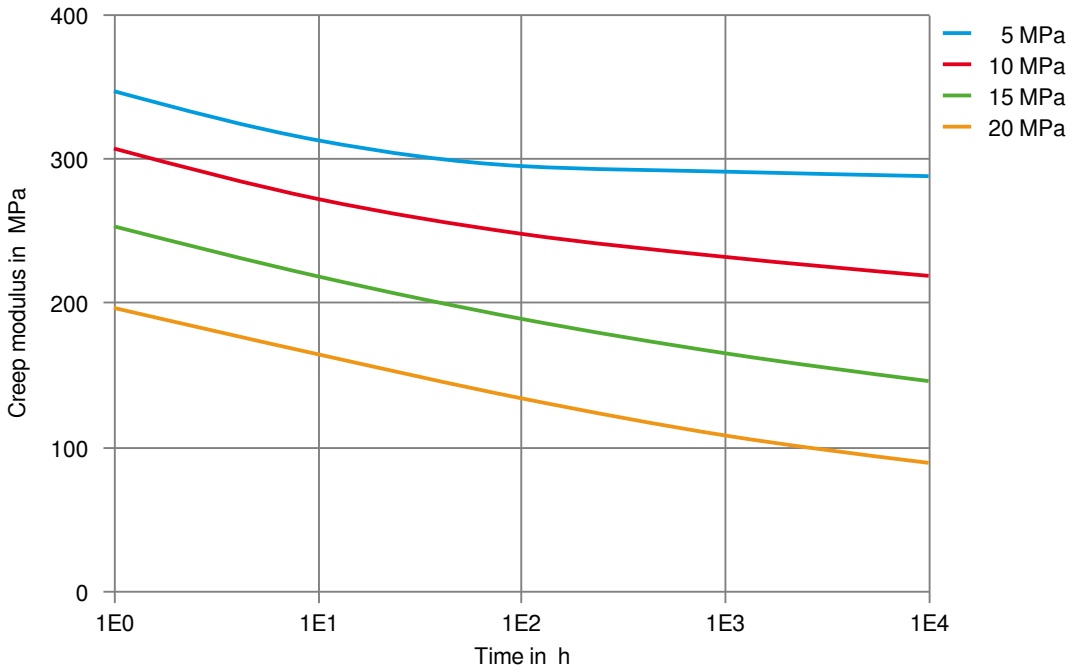


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Creep modulus-time 23 °C

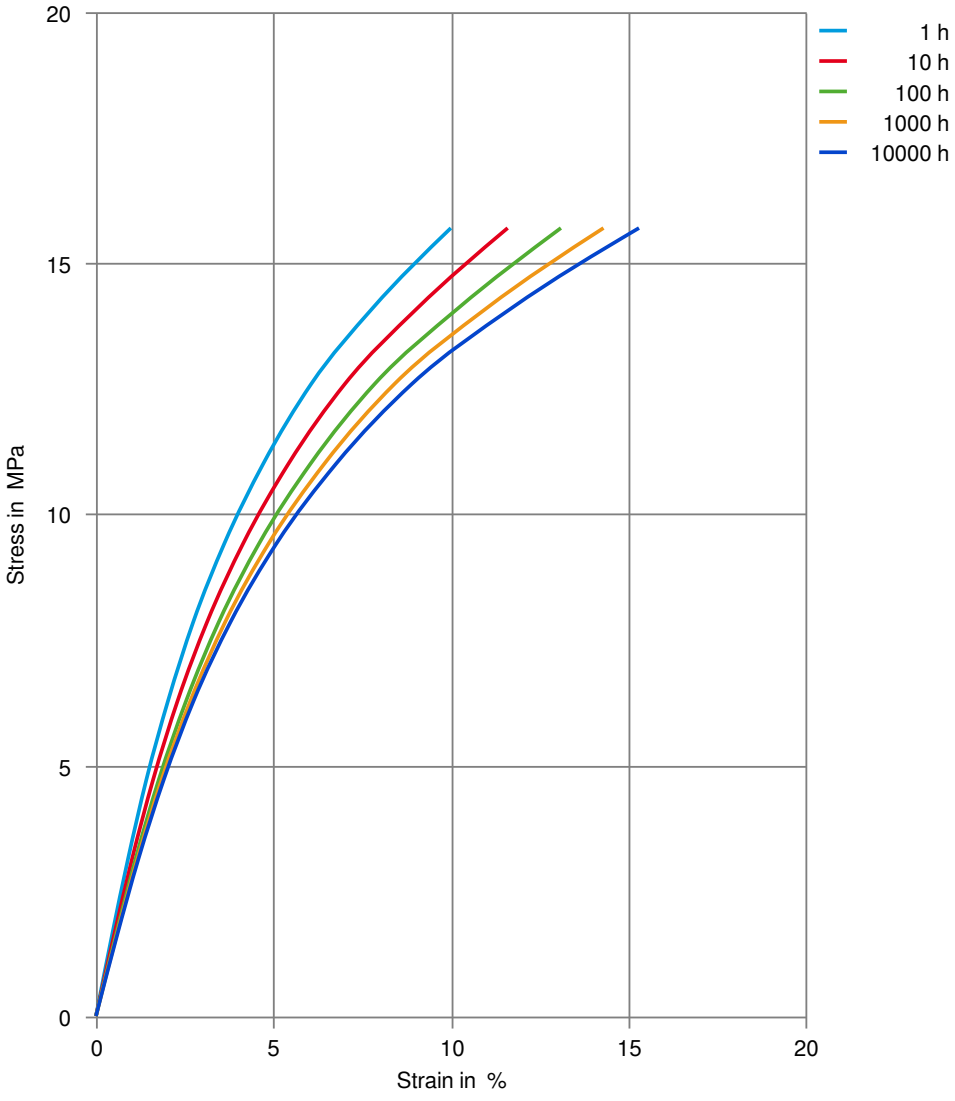


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Stress-strain (isochronous) 40 °C

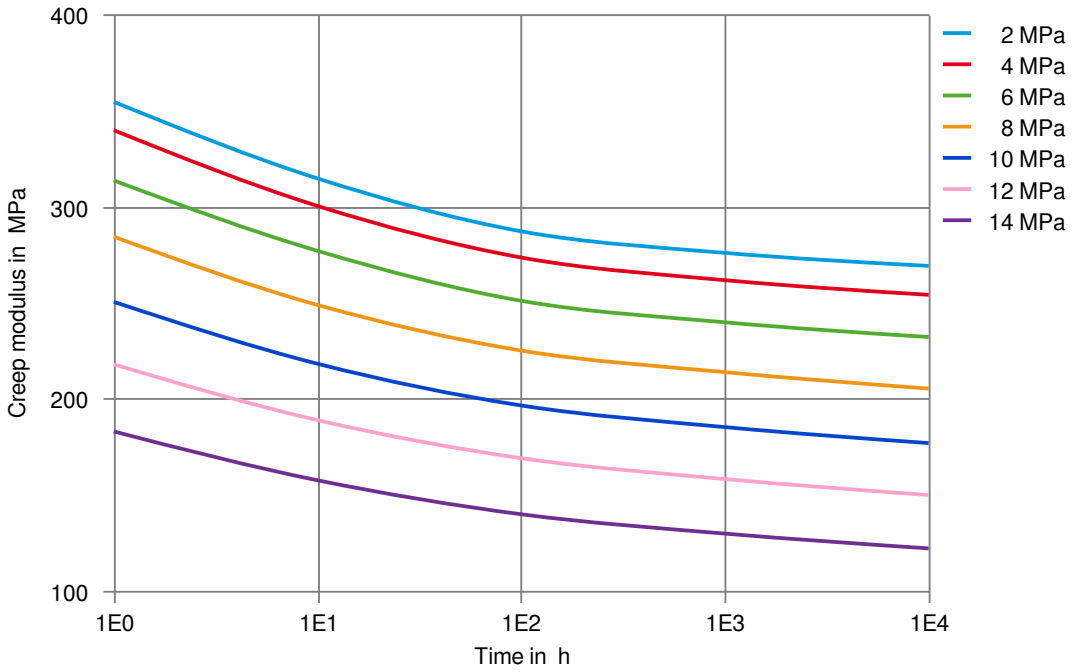


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Creep modulus-time 40 °C

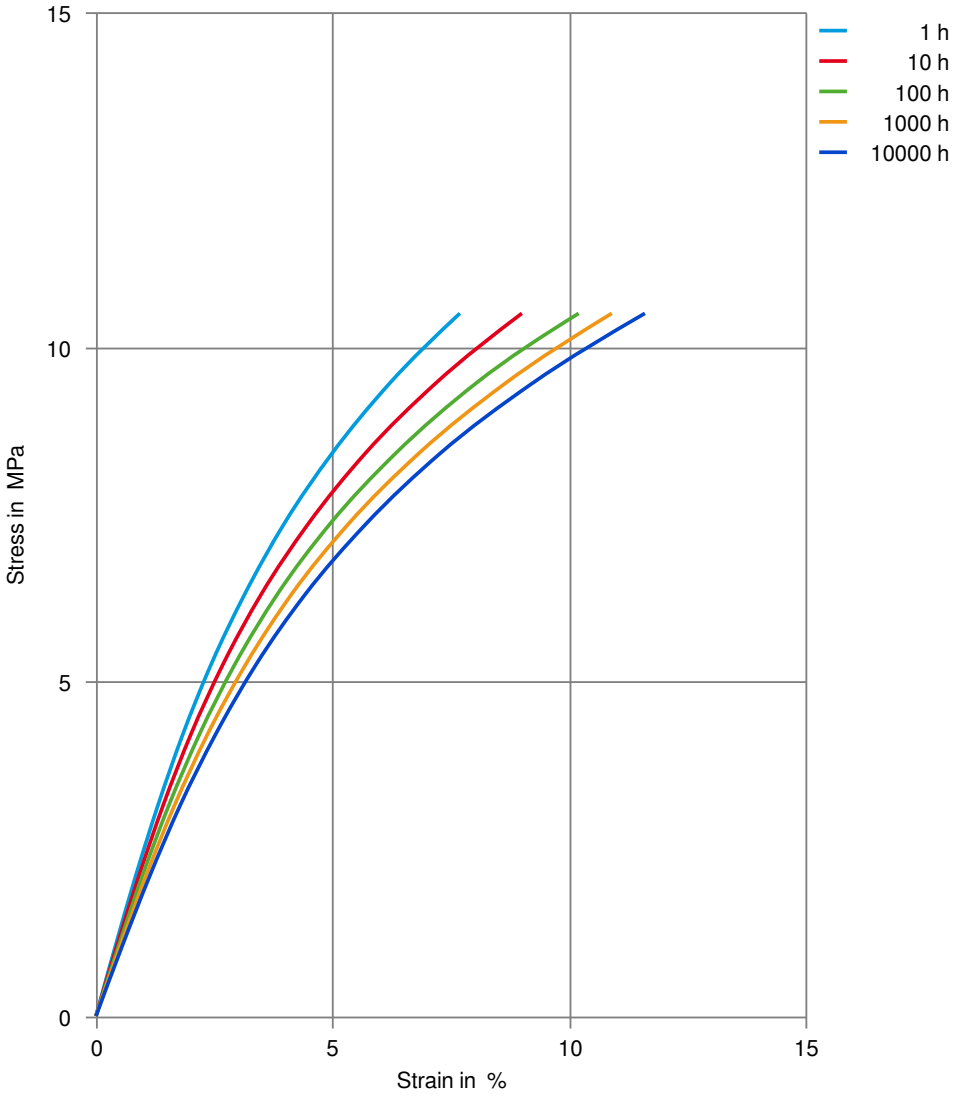


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Stress-strain (isochronous) 80 °C

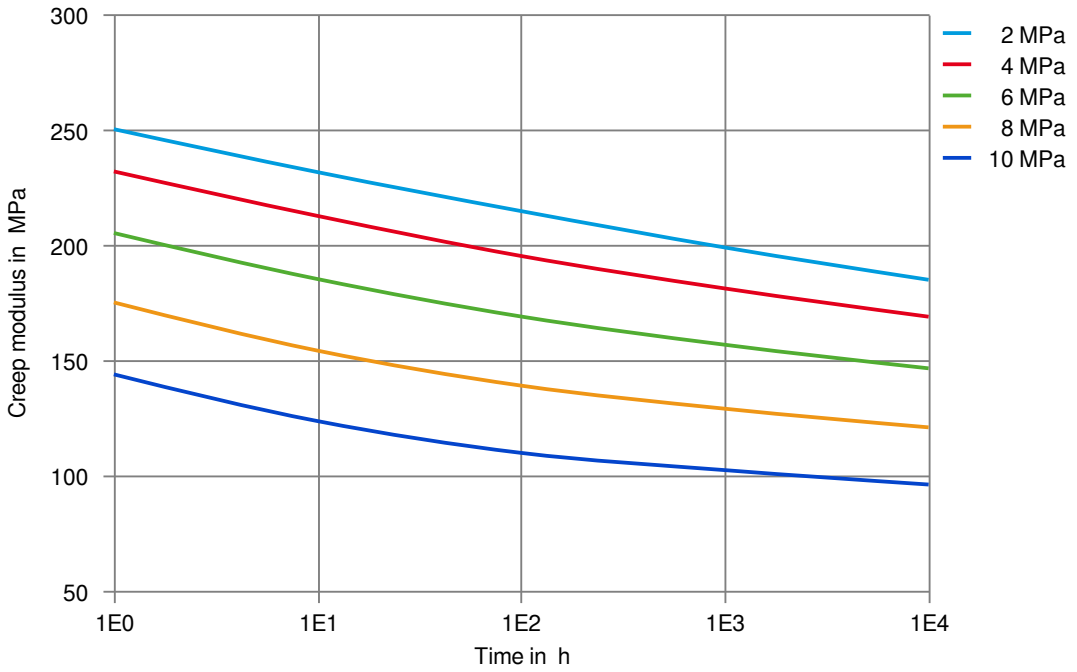


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Creep modulus-time 80 °C

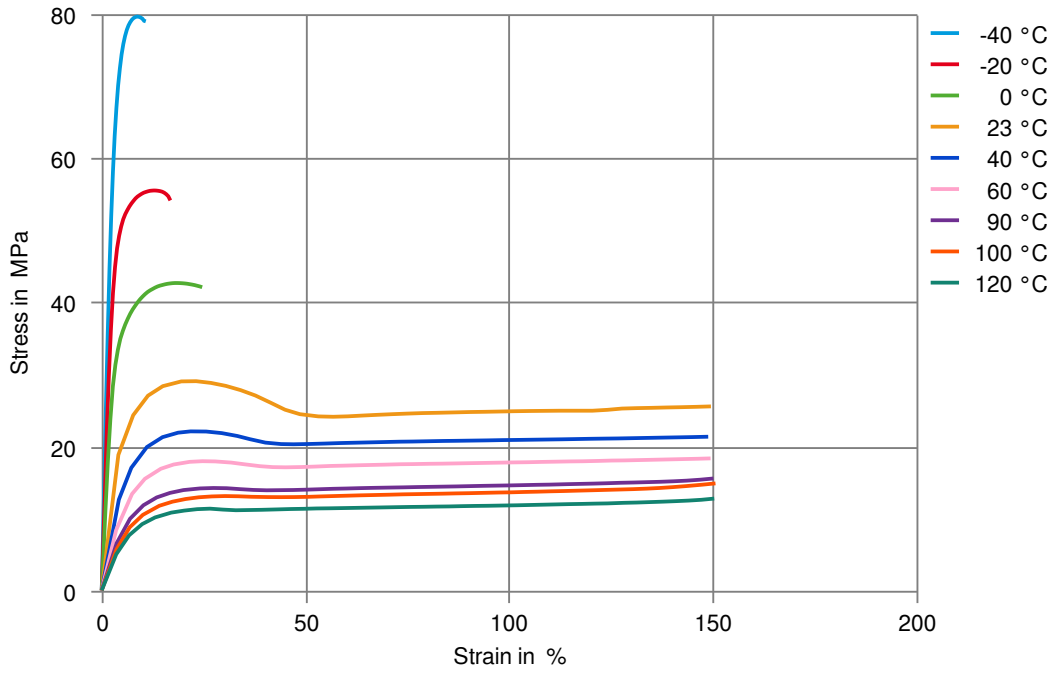


Celanese
The chemistry inside innovation™

Hytrel® 7246

THERMOPLASTIC POLYESTER ELASTOMER

Stress-Strain (Flexible Materials)



Celanese
The chemistry inside innovation™

Hytrel® 7246

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

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

Celanese
The chemistry inside innovation™

Hytrel® 7246

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
- ✘ DOT No. 4 Brake fluid, 120°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).

Revised: 2025-05-15 Source: Celanese Materials Database