

Polyether block amide **PEBAX® 3533 SA 01** is a thermoplastic elastomer made of flexible polyether and rigid polyamide. This SA grade is specially designed to food uses.

Main Characteristics	Value	Unit	Test Method
Density	1.00	g/cm ³	ISO 1183
Water Absorption at Equilibrium At 20°C and 50 % RH	0.4	%	ISO 62
Water Absorption At 23°C and 24 h in water	1.2	%	
Melting Point	144	°C	ISO 11357
Vicat Point Under 1 daN	77	°C	ISO 306
Shrinkage (after 24h, 4 mm, mould at 20°C) // ⊥	0.5 0.8	% %	Internal method
Hardness Shore (*) Instantaneous After 15 s	33 25	Shore D Shore D	ISO 868
Tensile Test (*) Stress at Break Strain at Break	39 >600	MPa %	ASTM D 638
Flexural Modulus (*)	21	MPa	ISO 178
Charpy Impact Unnotched 23°C Unnotched -30°C V-notched 23°C V-notched -30°C	No break No break No break No break	kJ/m ² kJ/m ² kJ/m ² kJ/m ²	ISO 179

(*) Samples conditioned 15 days at 23°C - 50 % R.H.

Processing Conditions	Typical Values
Drying (*) : Time / Temperature	4-8 hours / 55-65°C
Injection Temperature : Min / Recommended / Max	180°C / 210°C / 240°C
Extrusion Temperature : Min / Recommended / Max	190°C / 205°C / 220°C
Mold Temperature :	10-30°C

(*) Pebax® is delivered dried in sealed packaging ready to be processed. Drying is only necessary for bags opened for more than 2 hours.

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