

Polyether block amide **PEBAX® 6333 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	1.01	g/cm ³	ISO 1183
Water Absorption at Equilibrium At 20°C and 50 % RH	0.7	%	ISO 62
Water Absorption At 23°C and 24 h in water	1.1	%	
Melting Point	169	°C	ISO 11357
Vicat Point Under 1 daN	157	°C	ISO 306
Shrinkage (after 24h, 4 mm, mould at 40°C) // ⊥	1.2 1.4	% %	Internal method
Hardness Shore (*) Instantaneous After 15 s	64 58	Shore D Shore D	
Tensile Test (*) Stress at Break Strain at Break	53 >350	MPa %	ASTM D 638
Flexural Modulus (*)	285	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 20^(c)	kJ/m² kJ/m² kJ/m² kJ/m²	ISO 179

(*) Samples conditioned 15 days at 23°C - 50 % R.H. ; (c) = Complete Break

Processing Conditions	Typical Values
Drying (*) : Time / Temperature	4-6 hours / 65-75°C
Injection Temperature : Min / Recommended / Max	230°C / 260°C / 290°C
Extrusion Temperature : Min / Recommended / Max	210°C / 225°C / 240°C
Mold Temperature :	25-60°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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