

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 medical and 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 Saturation 24 h in water at 23°C	1.1	%	
Melting Point	169	°C	ISO 11357
Vicat Point Under 1 daN	157	°C	ISO 306
Hardness Shore (*) Instantaneous	64	Shore D	ISO 868
After 15 s	58	Shore D	
Tensile Test (*) Stress at Break	53	MPa	ASTM D 638
Strain at Break	>350	%	
Flexural Modulus (*)	285	MPa	ISO 178
Charpy Impact unnotched 23°C	No break	kJ/m ²	ISO 179
unnotched -30°C	No break	kJ/m ²	
V-notched 23°C	No break	kJ/m ²	
V-notched -30°C	20 ^(c)	kJ/m ²	

(*) 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.

DPT/TDS/10231 & 10232/ April 2008

The information contained in this document is based on trials carried out by our Research Centres and data selected from the literature, but shall in no event be held to constitute or imply any warranty, undertaking, express or implied commitment from our part. Our formal specifications define the limit of our commitment. No liability whatsoever can be accepted by Arkema with regard to the handling, processing or use of the product or products concerned which must in all cases be employed in accordance with all relevant laws and/or regulations in force in the country or countries concerned. We point out that it is the duty of the end user to check, in accordance with professional practice, the reciprocal compatibility of the material and the packaged foodstuffs (respective of Overall and Specific Migration Limits) and also that organoleptic characteristics of the latter remain constant. Due to the evolution of regulations or existing specific restrictions, it is necessary before any usage in food contact to request the related certificates from our commercial representatives.