

# PEBAX® 6333 SA 01

Polyether block amide **Pebax® 6333 SA 01 resin** is a thermoplastic elastomer made of flexible polyether and rigid polyamide. This SA grade is suitable for food contact applications.

## MAIN CHARACTERISTICS

| PROPERTIES                              | DRY / COND   | UNIT              | TEST STANDARD   |
|-----------------------------------------|--------------|-------------------|-----------------|
| <b>RHEOLOGICAL PROPERTIES</b>           |              |                   |                 |
| Molding Shrinkage, parallel             | 1.2 / *      | %                 | ISO 294-4, 2577 |
| Molding Shrinkage, normal               | 1.4 / *      | %                 | ISO 294-4, 2577 |
| <b>MECHANICAL PROPERTIES</b>            |              |                   |                 |
| Tensile Modulus                         | 307 / 285    | MPa               | ISO 527-1/-2    |
| Yield stress                            | 19 / 18      | MPa               | ISO 527-1/-2    |
| Yield strain                            | 22 / 22      | %                 | ISO 527-1/-2    |
| Nominal Strain at Break                 | > 50 / > 50  | %                 | ISO 527-1/-2    |
| Shore D Hardness, 15s                   | 58 / *       | -                 | ISO 7619-1      |
| Charpy Impact Strength, +23°C           | - / No Break | kJ/m <sup>2</sup> | ISO 179/1eU     |
| Charpy Impact Strength, -30°C           | - / No Break | kJ/m <sup>2</sup> | ISO 179/1eU     |
| Charpy Notched Impact Strength, +23°C   | - / No Break | kJ/m <sup>2</sup> | ISO 179/1eA     |
| Charpy Notched Impact Strength, -30°C   | - / 20       | kJ/m <sup>2</sup> | ISO 179/1eA     |
| <b>THERMAL PROPERTIES</b>               |              |                   |                 |
| Melting Temperature, 10°C/min           | 169 / *      | °C                | ISO 11357-1/-3  |
| Vicat Softening Temperature, 50°C/h 50N | 157 / *      | °C                | ISO 306         |
| <b>OTHER PROPERTIES</b>                 |              |                   |                 |
| Water Absorption                        | 1.1 / *      | %                 | Sim. to ISO 62  |
| Humidity Absorption                     | 0.7 / *      | %                 | Sim. to ISO 62  |
| Density                                 | 1010 / -     | kg/m <sup>3</sup> | ISO 1183        |

**MAIN APPLICATIONS:** • Athletic foot wear components • Fibers

• Note: this grade is not recommended by Arkema for usage in medical applications. For such applications Pebax® SA 01 MED should be used

## PACKAGING:

This grade is delivered dried in sealed packaging (20 or 25 kg bags) ready to be processed.

## SHELF LIFE:

Two years from the delivery. For any use above this limit, please refer to our technical services.

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**PEBAX®**  
BY ARKEMA

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# PEBAX® 6333 SA 01

**Processing conditions:**

- Typical melt temperature (Min / Recommended / Max) : 230°C / 260°C / 290°C
- Typical mold temperature : 25 – 60°C
- Drying time and temperature (only necessary for bags opened for more than two hours) : 4-6 hours at 65-75°C

**Processing conditions:**

- Typical melt temperature (Min / Recommended / Max) : 210°C / 225°C / 240°C
- Drying time and temperature (only necessary for bags opened for more than two hours) : 4-6 hours at 65-75°C

**PROCESSING**

Injection Molding, Other Extrusion

**DELIVERY FORM**

Pellets

**SPECIAL CHARACTERISTICS**

Heat Stabilized

**REGIONAL AVAILABILITY**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

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