

Pebax® 3533 SA 01

Polyether Block Amide

Arkema

Message:

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.

General Information			
Uses	Non-specific Food Applications		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Density	1.00	g/cm ³	ISO 1183
Molding Shrinkage ¹			Internal Method
Across Flow : 24 hr, 4.00 mm	0.80	%	
Flow : 24 hr, 4.00 mm	0.50	%	
Water Absorption			ISO 62
23°C, 24 hr	1.2	%	
Equilibrium, 23°C, 50% RH	0.40	%	

Hardness	Nominal Value	Unit	Test Method
Shore Hardness			ISO 868
Shore A	82		
Shore A, 15 sec	80		
Shore D	33		
Shore D, 15 sec	25		

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	39.0	MPa	ISO 527-2
Tensile Strain (Break)	> 600	%	ISO 527-2
Flexural Modulus	21.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		

Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	77.0	°C	ISO 306

Melting Temperature	144	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	55.0 to 65.0	°C	
Drying Time	4.0 to 8.0	hr	
Processing (Melt) Temp	180 to 240	°C	
Mold Temperature	10.0 to 30.0	°C	
Extrusion	Nominal Value	Unit	
Drying Temperature	55.0 to 65.0	°C	
Drying Time	4.0 to 8.0	hr	
Melt Temperature	190 to 220	°C	
NOTE			
1.	Mold at 40°C		

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