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ISO 9001 CERTIFIED

Promyde[®] B33 L is a lubricated Polyamide 6 grade of medium viscosity suitable for extrusion applications in general like high tenacity yarns, corrugated tubes and certain compounding applications.

Product Specifications	Values	Standard method
Relative viscosity	3,31 ± 0,1	ISO 1628
Monomer % max.	≤ 0,6	ISO 599
Moisture content % max.	≤ 0,1	NAPPA-032

Main properties	Unit	Value	Testing method
Melting point	°C	220	ISO 3146
Density	g/cm ³	1,13	ISO 1148
Apparent density	g/cm ³	0,69	NAPPA-059
Chip size (length-diameter)	mm	2,5	NAPPA-045

Packaging	Big bag / Octabin / Silo truck
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Disclaimer: All the information submitted is based on our knowledge and experience. The shown values have been established by using standard tests performed at our plant. Figures should be regarded as guidance and not as a minimum values. The affectation of the process and applications by different factors or conditions cannot be guaranteed, therefore, users are recommended to perform the test in order to determine the suitability of the product for one particular use.

CHARACTERISTICS

Promyde® B33 L is a medium viscosity lubricated Polyamide 6 suitable for general extrusion applications and especially for biaxial orientated (BOPA), cast film and monofilaments. This product combines good gas barrier properties and chemical resistance, good mechanical and optical properties, high abrasion resistance and good thermoformability.

FORMAT AND STORAGE

Promyde® B33 L is supplied in moisture-proof packaging. Typical formats are Big Bags, Octabins, 25kg bags, and bulk silo trucks. All containers are perfectly sealed. The product should be stored in a dry place and opened just before processing.

PROCESSING GUIDELINES

Drying

Material is supplied predried and ready to process. Bags and containers should be stored in a dry place at room temperature. Storage time should not exceed twelve months. Material from open or damaged containers should be dried in a dry-air dryer at 75 to 80°C, the drying time required will depend on the moisture content. Drying temperatures of above 80°C should be avoided because of possible oxidation.

Extrusion Processing

PROMYDE® B33 L may be processed on standard single-flighted, three-section screws. Better results can be obtained by using high-performance screws equipped with shearing and mixing sections. The screw length should be at least 24D, and preferably 28-33D to guarantee optimum plasticizing and conveying with the high through-put rates of film extrusion (D: screw diameter). A three-section screw should have a compression ratio (ratio of flight depth in the feed section to flight depth in the metering section) of 3:1 to 4:1.

It is recommended the length of screw sections as follows (L: overall length of screw):

Feed section: 0.25 to 0.30 x L

Compression section: 0.15 to 0.25 x L

Metering section: 0.4 to 0.55 x L

The following processing temperatures are recommended:

Feed section: 230-240°C

Compression section: 250-265°C

Metering section: 255-265°C

Die: 255-265°C

Conditioning

Films made of PROMYDE® B33 L will achieve their final dimensions and properties after equilibrium moisture absorption.

Note: All recommendations are based on knowledge and experience. The values have been established on standard tests. The figures should be regarded as guide values and not as binding minimum values. As many factors may affect processing or applications, we recommend that you make tests to determine the suitability of a product for your particular use.