

Recommendations on Extrusion processing of Arnite A06 101

Arnite A06 101 grade is a non-reinforced PET.

Drying conditions Arnite A06 101

Drying time [hour]	Temperature [°C]	Remarks
3 – 4 { 6 – 7 }	140 – 160 (284-320°F)	-Desiccant dryers, dew point $\leq -30^{\circ}\text{C}$ (-22°F), and pre-dried air dryers are suitable for drying Arnite; -Maximum moisture content after drying is 0.005% by weight; -Moisture pick up very fast at 70 - 80°C (158-176°F), keep granulate hot at 90 – 110°C (194-230°F).

{ } : preferred.

Extrusion Temperatures

	Zone 1	Zone 2	Zone 3	Zone 4	Melt	Die
	[°C]	[°C]	[°C]	[°C]	[°C]	[°C]
	285-295	270-280	265-275	265-275	270-280	265-275
	545-563°F	518-536°F	509-527°F	509-527°F	518-536°F	509-527°F
Remarks: -A decreasing or flat temperature profile should be used.						