

Recommendations on Extrusion processing of Arnite D04 300

Arnite D04 300 grade is a non-reinforced PET.

Drying conditions Arnite D04 300

Drying time [hour]	Temperature [°C]	Remarks
3 – 4 { 6 – 7 }	150 – 185 (302-365°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]
	280-290	270-280	265-275	265-275	270-290	265-275
	536-554°F	518-536°F	509-527°F	509-527°F	518-554°F	509-527°F
Remarks: -A decreasing or flat temperature profile should be used.						