

Recommendations on Extrusion processing of Arnite A02 306

Arnite A02 306 grade is a non-reinforced PET.

Drying conditions Arnite A02 306

| 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 | 275-285 | 270-280 | 270-280 | 270-280 | 270-280 |
| | 545-563°F | 527-545°F | 518-536°F | 518-536°F | 518-536°F | 518-536°F |
| Remarks: -A decreasing or flat temperature profile should be used. | | | | | | |