# Extrusion guidelines for Arnite® A-grades

## Introduction:

Arnite A polyesters are available in various grades. The main difference is the viscosity. Extrusion (single screw) of Arnite A is possible with a conventional 3 zone screw with a compression ratio between 2.5 and 3.2. A barrier screw in combination with a grooved barrel results in an optimal stable process.

## Material handling:

Pre-drying of Arnite A grades is essential for extrusion application. Therefore we recommend minimum 4 hours drying at 140 °C. Please refer table mentioned below. A desiccant dryer with a dew point of ≤ -30 °C should be used (airflow rate: 2,5-3,0 m³/ kg.hr) in order to reach a moisture level below 50 ppm (0,0005%). A drying hopper should be applied to the extruder.

## Processing:

Arnite A extrusion grades are run at mass temperatures between 270 and 280 °C depending on machine and material choice. Extrusion type Arnite T grades should be processed with low moisture content (< 50 ppm) to keep manufacturing stable. The machine parameters can be changed in order to meet the required stability and melt temperature.

## Application:

Arnite A02 307 is a low viscosity extrusion grade; it is convenient typical extrusion and master batch type of applications and can also be used in Food application come into contact. The product is widely used in the filter of paper clothing machine

## Safety:

Please handle the material with care. Follow all guidelines indicated on the temporarily version of the MSDS.

## DSM

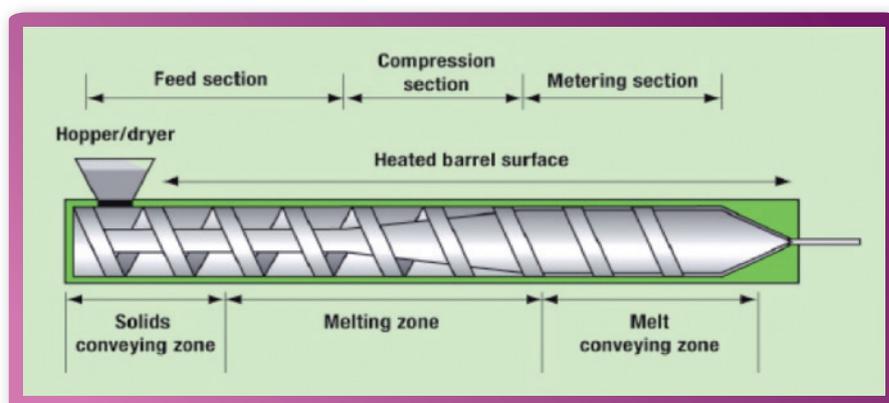For further information please see: www.arnite.com or contact:

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| Grade name | Zone 1 | Zone 2 | Zone 3 | Zone 4 | Die | Melt | Pre-Drying |
|---|---|---|---|---|---|---|---|
| Arnite A02 307 | 285-295 | 270-280 | 265-275 | 265-275 | 265-275 | 270-280 | 80 - 120 |

DSM
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