

# Arnite® T

## PBT

Print date: 2024-02-28

### Introduction:

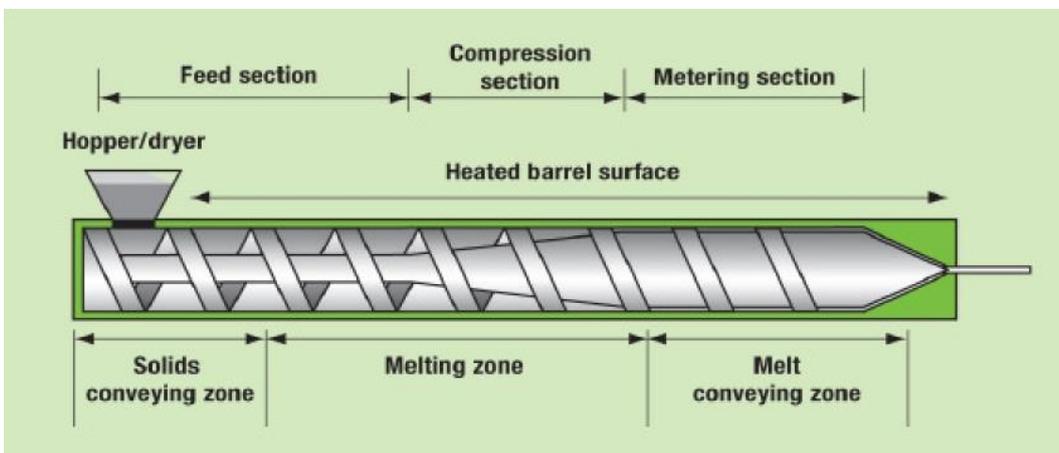
Arnite® T polyesters are available in various grades. The main difference is the viscosity. Extrusion (single screw) of Arnite® T is possible with a conventional 3 zone screw with a compression ratio between 2.5 and 3.2. A barrier screw in combination with a grooved barrel results in an optimal stable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

### Material handling:

Pre-drying of Arnite® T grades is essential for extrusion application. Therefore we recommend minimum 3 hours drying at 120 °C. Please refer table mentioned below. A desiccant dryer with a dew point of  $\leq -30$  °C should be used (airflow rate: 2,5-3,0 m<sup>3</sup>/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® T extrusion grades are run at mass temperatures between 225 and 265 °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.



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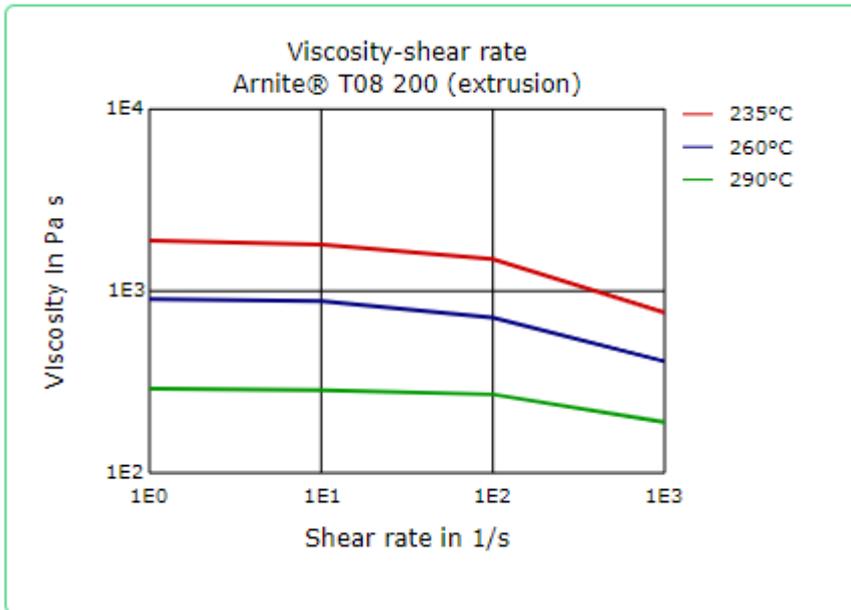
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Table 1. Typical temperature settings for Arnite® T extrusion (°C)

Grade Name	Zone 1	Zone 2	Zone 3	Zone 4	Die	Melt	Pre-Drying
Arnite® T04 200	220-235	230-245	235-245	235-245	240-250	240-250	120-140
Arnite® T06 200	225-240	235-250	240-250	240-250	240-260	240-260	120-140
Arnite® T08 200	230-245	240-255	245-255	245-255	245-265	245-265	120-140



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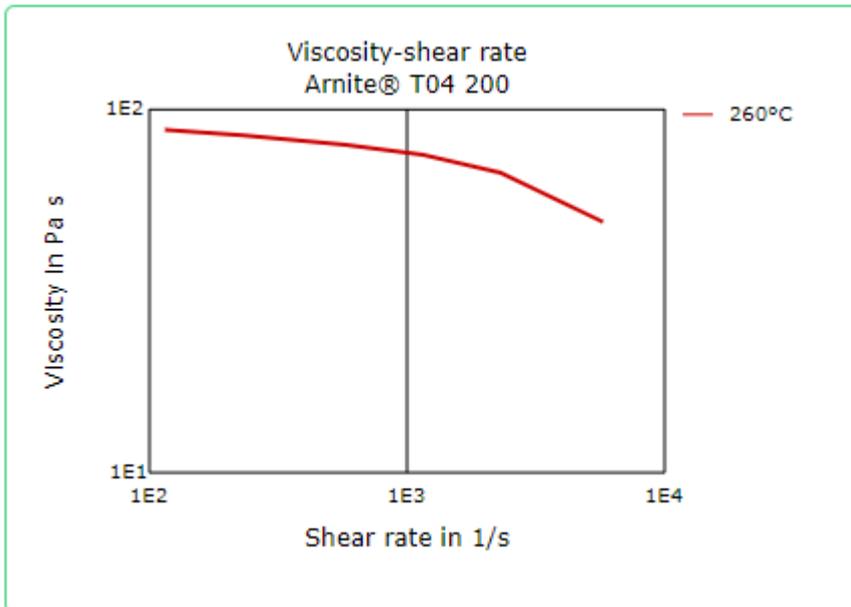
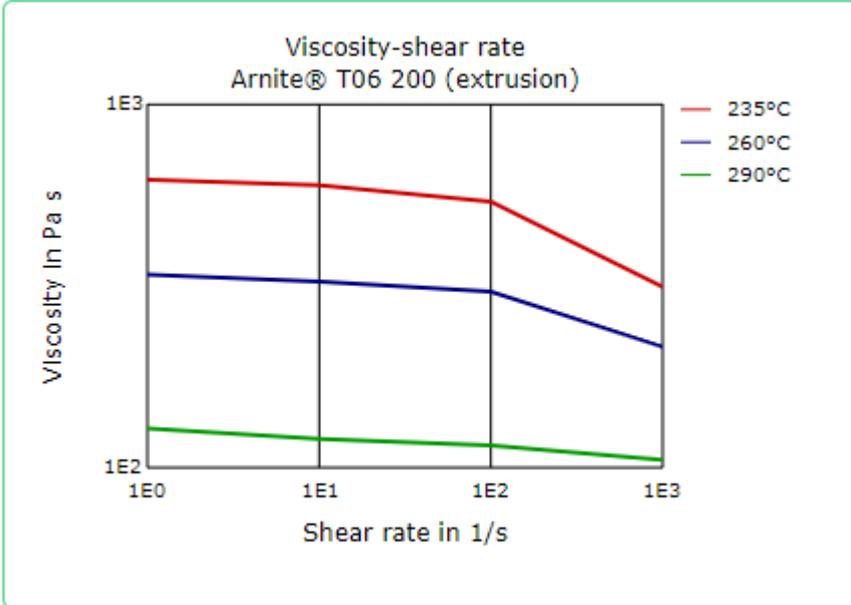
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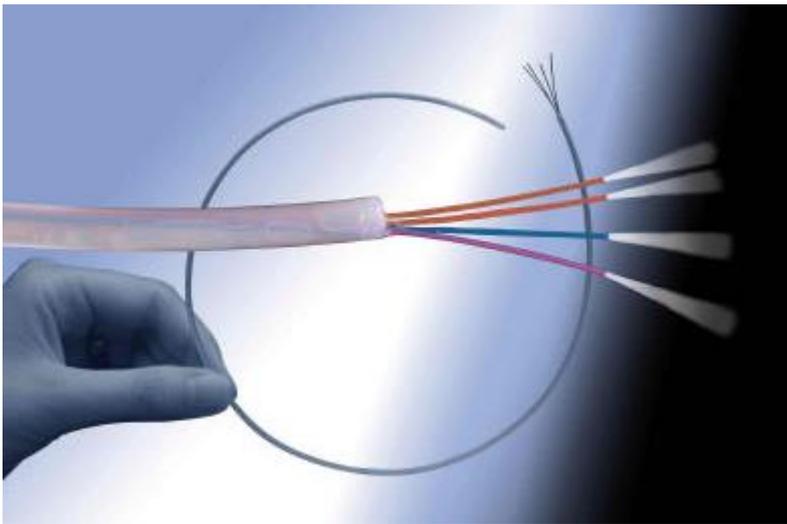
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## Application:

Low, Medium and High Viscosity Arnite® T grades (Example T04 200, T06 200 and T08 200) are used in Optical FiberFilm, Sheeting and Monofilament applications.



## Safety:

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

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