

# Arnitel<sup>®</sup> HM7118

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This quick start instruction gives an indication of the key settings for processing Arnitel<sup>®</sup> HM7118 to ensure best crystallization and prevent material degradation as a result of hydrolysis or thermal load. It is a summary of the Injection Molding Recommendations which can be found in our Plastics Finder at <https://plasticsfinder.com>. Our online guidelines are recommendations to help with material processing and/or to evaluate and resolve potential processing issues.

## TEMPERATURE SETTINGS

### Barrel temperature

The given temperature settings are general for Arnitel<sup>®</sup>. Optimal settings are governed by barrel size and residence time. Additionally, a higher hardness and higher melting point of the Arnitel<sup>®</sup>, requires a barrel temperature at the higher side.

Mold/Tool	Measured melt	Nozzle	Front	Center	Rear	
20 – 50°C 68 – 122°F	220–240°C 428–464°F	220–240°C 428–464°F	210–230°C 410–446°F	200–220°C 392–428°F	190–210°C 374–410°F	

## MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Arnitel<sup>®</sup> HM7118 is ≤ 5 minutes with preferably at least 50% of the maximal shot volume used. The MRT should not exceed 6 minutes. A full self-service MRT calculation can be done using the following [link](#).

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