

# Arnitel® PL381

Print Date: 2024-06-11

This quick start instruction gives an indication of the key settings for processing Arnitel® PL381 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://envalior.plasticsfinder.com>. Our online guidelines are recommendations to help with material processing and/or to evaluate and resolve potential processing issues.

## MATERIAL HANDLING

### Drying

Arnitel® grades are hygroscopic and absorb moisture from the air relatively quickly. Moisture absorption is fully reversible under the following drying conditions without compromising material quality. Preferred driers are de-humidified driers with dew points maintained between -30 and -40°C / -22 and -40°F. Vacuum driers with N<sub>2</sub> purge can also be used. Hot air ovens or hopper driers are not suitable for pre-drying Arnitel® grades; the use of such driers may result in non-optimum performance.

Moisture content	Time	Temperature	
		[°C]	[°F]
<0.05 and as delivered	3-4	110	230
>0.05-0.2	4-6	110	230

## TEMPERATURE SETTINGS

### Barrel temperature

The given temperature settings are general for Arnitel®. Optimal settings are governed by barrel size and residence time.

Additionally, a higher hardness and higher melting point of the Arnitel®, requires a barrel temperature at the higher side.

Mold/Tool	Measured melt	Nozzle	Front	Center	Rear
20 – 50°C 68 – 122°F	230–250°C 446–482°F	230–250°C 446–482°F	220–240°C 428–464°F	210–230°C 410–446°F	200–220°C 392–428°F

## MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Arnitel® PL381 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](#).

All the trademarks mentioned here are trademarks of Envalior.  
Seller represents and warrants exclusively that on the date of delivery by Seller the product shall be in conformity with the specifications agreed upon. Seller makes no other representations or warranties, whether express or implied.  
Seller is not responsible or liable for the design of the products of the Customer and it is the responsibility of the Customer to determine that the Seller's product is safe, complies with application laws and regulations, and is technically or otherwise fit for its intended use. Seller does not endorse or claim suitability of its products for a specific application and disclaims each and every representation or warranty, whether express or implied, in that respect.

Typical values are indicative only and are not to be construed as being binding specifications. Colorants in the product or other additives may cause significant variations in typical values.

Copyright © Envalior 2024. All rights reserved. No part of the information may be reproduced, distributed, or transmitted in any form or by any means, including photocopying, recording, or other electronic or mechanical methods, without the prior written permission of Envalior.