

# Arnitel® XG01JK

Print Date: 2024-05-17

This quick start instruction gives an indication of the key settings for processing Arnitel® XG01JK 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]
<0.1 and as delivered	3-4	90	195
>0.1	4-6	90	195

## 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	190–240°C 374–464°F	190–230°C 374–446°F	190–215°C 374–419°F	180–200°C 356–392°F	150–180°C 302–356°F

## MELT RESIDENCE TIME

The optimal Melt Residence Time (MRT) for Arnitel® XG01JK 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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