



# GUIDELINES FOR PEBAX® Tube Extrusion

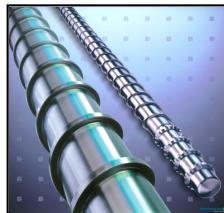


# PEBAX: 6333, 5533 & 4033 SN01

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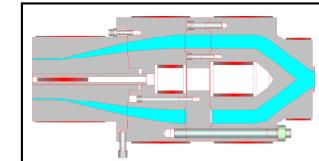
- Extruder

- Screw profile
  - standard 3 zones PA (Compression ratio 2 à 3)
- T° profile (to be adjusted as a function of output)
  - Tf at the entry
  - Tf + 20 °C at the end of the screw
  - Tf + 10 °C in the tools
  - Melt temperature
    - 6333: 190 °C
    - 5533: 180 °C
    - 4033: 180 °C
- Filtration
  - 40/40



- Tools

- PA equipments
  - Die head
  - Pin & die



- Calibrators

- Design with water lubrication at the entry and sleeve (like PA)
- Bronze or brass
- Low vacuum and high water level

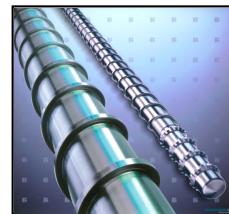
- Cooling

- Length of the line quite short

# PEBAX: 3533 & 2533 SN01

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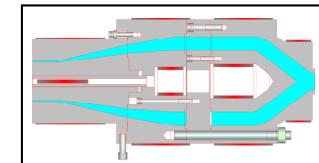
- **Extruder**



- Screw profile
  - standard 3 zones PA  
(Compression ratio 2 à 3)
- T° profile (to be adjusted as a function of output)
  - Tf at the entry
  - Tf + 20 °C at the end of the screw
  - Tf + 10 °C in the tools
- Filtration
  - 40/40

- **Tools**

- PA equipments
  - Die head
  - Pin & die



- **Calibrators**

- **Sticking on PA sizing ring**
- **Special design necessary**

- **Cooling**

- Length of the line quite short

# Soft grade extrusion

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- Special properties
  - High elasticity at the molten state
  - Sticking products
- Consequences: breaks of the melt
  - Elasticity leads to a less stable process
    - Necessity to shorten as much as possible the line length to strengthen the stability
  - Friction in the calibrator
    - Modify the calibrator design
    - Modifier the contact calibrator polymer: choice of another material